The 418HE bag machine operates through a hydraulic/mechanical system designed to operate in or out of line with blown film extrusion. The 418HE utilizes a shuttle principle and features automatic speed mating for inline use. A variety of consumer and industrial bags may be made on this machine, including trash, garment and merchandise bags, either stacked or on a roll. The 418HE will handle film thicknesses up to 12 mil flat (6 mil gusseted) and speeds of up to 300 fpm. It will produce high quality bottom or side sealed bags either single or multiple webs.

**Features**

- Consolidated operator control station with microprocessor based controls for bag length readout, speed, and count
- Left and right side single point lubrication
- High performance hydraulic system
- Dual input-output nip rolls
- Twin sealbar configuration

**Benefits**

- Digital readout of bag length, film speed, and cycle rate allow faster product set up with reduced scrap.
- Digital counter indicates batch count, batch total and bag total for easier production tracking and inventory control.
- Digital autotune heat controllers (3) for accurate sealing temperature improves bottom or side seal quality and consistency. Front and rear seal bars and platen temperatures controlled independently.
- Faster, easier lubrication promotes regular maintenance for longer machine life.
- Inline heat exchanger with Formulated oil ensures long hydraulic system life, increased reliability and uptime.
- Fittings with O-ring seal eliminate leakage for improved housekeeping.
- Differential speed control allows web tension to relax during seal/perforation. Tension relaxation promotes positive seal and perforation integrity during downstream web handling for fewer web breaks and improved winding.
- Grooved exit roll for reduced air entrapment.
- Two seal bars enable sealing on either side of perforation, or both sides, for side seal bag.
### Dimensions

<table>
<thead>
<tr>
<th></th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inches</td>
<td>14.50</td>
<td>MS+43.25</td>
<td>MS</td>
<td>20.50</td>
<td>38.25</td>
<td>60</td>
<td>10</td>
</tr>
<tr>
<td>Millimeters</td>
<td>368</td>
<td>MS+1100</td>
<td>MS</td>
<td>520</td>
<td>970</td>
<td>1525</td>
<td>255</td>
</tr>
</tbody>
</table>

MS = 30 to 100 inches (in 10 inch increments)
MS = 762 to 2540 millimeters (in 254 millimeter increments)

### Specifications

**Machine Size:**
30" to 100" wide (762 to 2540mm)

**Max. Speed:**
300 fpm (90m/m) - dependent on machine size and product

**Max. Web Thickness:**
12 mil flat/6 mil gusseted (305/152 micron)

**Max. Cycle Rate:**
120/min, depending on bag length & film gauge

**Bag Repeat Length:**
Std. - min. 10" (254mm)  
- max. 90" (2285mm)  
- with std. mech. skip seal 180" (4.5m)  
- with optional electronic skip seal 360" (9.1m)  
- for other repeat lengths, consult factory

**Voltage:**
230/460V

**Air:**
80 psi static pressure (5.5 bar)

**Water:**
3 Gpm @ 60° F. (11.4 L/M @ 15.6°F.)

### Options

- High Wattage Heaters
- Seal Bar Radii
- Perforation Blades - depending upon product application
- Electronic Eye - for print registration
- Hole Punching
- Garment Head Attachment
- Slit Seal Attachment
- MC M&D Unwind
- MC M&D Re-wind
- Castors - for machine portability
- Garment Bag Attachment
- Winders
- Bag Separators