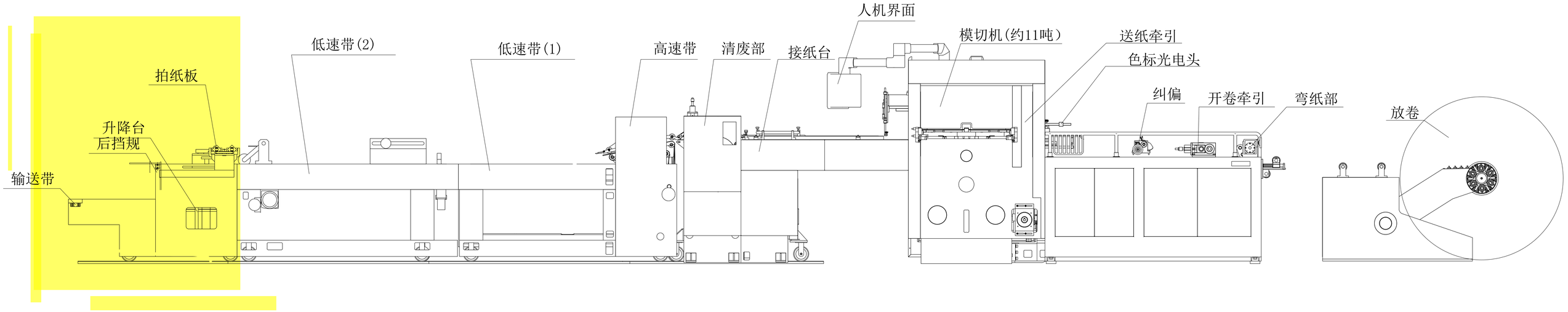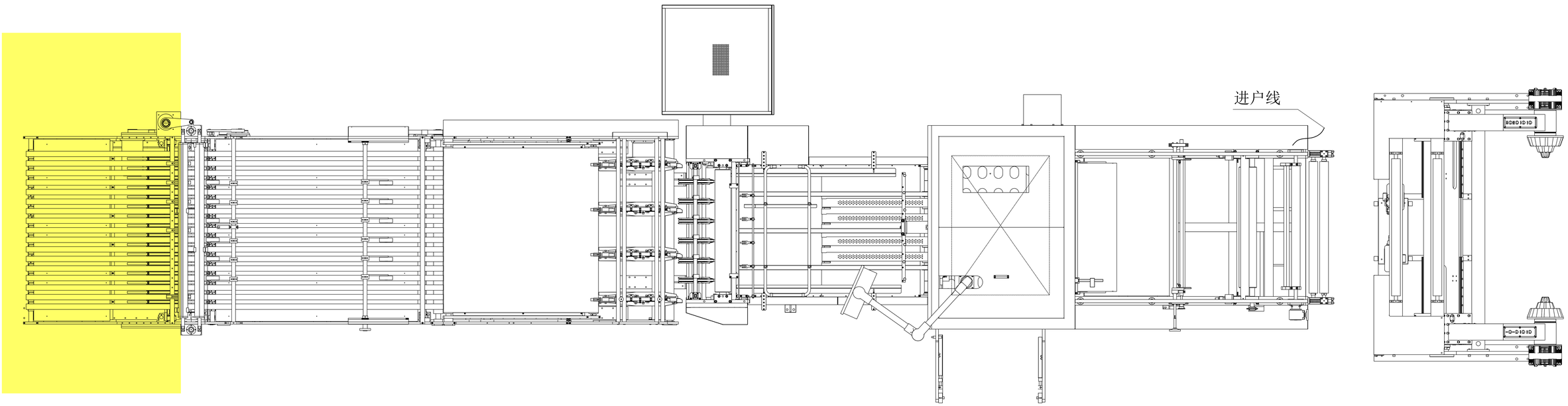卷筒纸模切清废带码垛收集工艺图