

**1-SECOND HAND FIVE-PLY PAPER
CORRUGATING AND CARTON PRODUCTION
LINE**

***Ply: 5 ply line - Year production : 2017
Width : 2000 mm - Speed : 200 m/min
HS code: 84393000***

1. 主要技术参数:

Main technical parameter

- 型号 2000-2000-II
Model 2000-2000-II
- 瓦线总长 约 100m (以基础图为准)
The total meter about 100 meters (base on the foundation drawing)
- 设计速度 180m/min
Design speed 180m/min
- 工作速度 90-120m/min(三层)、80-120m/min(五层)
Working speed 3 layer 90~120m/min 5 layer 80~120m/min
- 有效幅宽 2200mm
Working width 2200mm
- 瓦楞楞型 UV 偏 V 型 A、C、B、E 楞组合
Corrugated fluting UV look like V type A flute C flute B flute E flute (choose the flute)
- 蒸汽压力 压力 0.8-1.2Mpa
Steam pressure 0.8-1.2MPa
- 空压气压力 压力 0.6-1.0Mpa
Air compression 0.6-1.0Mpa
- 总装机容量功率 约 28Kw
Total power Approximately 28kw
- 设备方向 客户指定
Direction of operating customer decides

2. 设备配置清单

Equipment configuration list

序号 Serial	名称 Name	数量 Quantity	备注 Note
1	YZJ1-型液压无轴纸架 YZJ1-hydraulic mill roll stand	1 台 1 sets	夹纸、左右移动及升降全部液压驱动，张力控制采用单点盘式气动刹车，夹纸采用膨胀式顶针夹纸。 Clip the paper , move left and right , lift up and down adopt hydraulic drive , the tension control adopts the single point disc brake. Clip the paper adopts inflated collet.
2	型面纸预热器	1 台	预热缸直径 $\Phi 900$ mm, 电调包角 $60^{\circ} \sim 280^{\circ}$

	type surface paper preheater.	SIX sets	The preheater diameter is $\Phi 900$ mm , electric adjustment for the heating area,the adjusting range is $60^{\circ}\sim 280^{\circ}$.
3	型 单面瓦楞机 type single facer	4 台 four sets	楞型 A、C、B、E 参数由客户选定 上、下瓦楞辊直径 $\Phi 500$ mm，大小辊设计，表面研磨镀铬处理，无糊叉负压吸风式，万向节联轴器驱动，上下瓦楞座整体装拆，胶量电动微调附人机界面显示，主动力变频电机附变频控制。 电器元件（低压电器、变频器、）配施耐德（）正泰和台湾台达（）产品 配断纸自动检测控制单元 配车速同步控制模块 配胶量自动控制单元 Corrugated flute A/C/B/E , the customer choose the parameter. The upper and down corrugated roller diameter is $\Phi 500$ mm, big and small roller design, the surface is grinding and chromed , no paste fork vacuum suction type , cardon coupling drive , the upper and down corrugated seat is a whole ,
4	型芯纸预调器 core paper preheater	6 台 SIX sets	预热缸直径 $\Phi 900$ mm 电调包角 $60^{\circ}\sim 280^{\circ}$ 导纸轮配张力平衡器 The preheater diameter is $\Phi 900$ mm , electric adjustment for the heating area , the adjusting range is $60^{\circ}\sim 280^{\circ}$. The leading paper roller is equipped with tension balance device.
5	型三重预热器 FOUR layer preheater	1 台 One set	预热缸直径 $\Phi 1000$ mm，电调包角 $60^{\circ}\sim 280^{\circ}$ The preheater diameter is $\Phi 1000$ mm , electric adjustment for the heating area,the adjusting range is $60^{\circ}\sim 280^{\circ}$.

<p>型, 双层涂胶机 THREE layer pasting machine</p>	<p>型, 双层涂胶机 THREE layer pasting machine</p>	<p>1 台 One set</p>	<p>压辊式, 压纸轮高低电动调整, 升降气动控制胶量间隙电动微调附人机界面显示, 分层变频电机驱动附变频控制。配断纸自动检测控制单元, 配车速同步控制模块, 配胶量自动控制单元。</p> <p>Roller pressure , the height of the press roller adopt electric adjustment with pneumatic control , the thickness of the glue roller adopt electric micro adjustment with human machine interface. It adopts inverter independent control. It is equipped with break paper automatic detection unit , speed synchronous control match speed module , the thickness of the glue adopt automatic control</p>
<p>型, 双层输送天桥 double layer convey bridge.</p>	<p>型, 双层输送天桥 double layer convey bridge.</p>	<p>1 套 One set</p>	<p>提升部变频电机单独驱动, 自动同步运转, 自动调整纸板对齐, 吸附式张力控制, 变频器调整张力大小, 桥上、地面两处操控。</p> <p>The lifting department adopt independent drive, automatic synchronous running , automatically adjust paperboard neatly , suction tension control , inverter adjust the tension , on the bridge and ground two set control</p>
<p>AUTO CORRECTION SYSTEM</p>	<p>AUTO CORRECTION SYSTEM</p>	<p>1 套 One set</p>	<p>提升部变频电机单独驱动, 自动同步运转, 自动调整纸板对齐, 吸附式张力控制</p> <p>The lifting department adopt independent drive, automatic synchronous running , automatically adjust paperboard neatly</p>
<p>型双面机 double facer</p>	<p>型双面机 double facer</p>	<p>2 套 TWO set</p>	<p>18 块加热板, 表面研磨处理, 密集式重力轮施压, 气动分段调压, 液压自动升降, 棉织带气动张紧, 上带自动纠偏, 下带手动调节, 热板温度三点显示 (前、中、后三点), 主动力变频电机驱动附变频控制。</p> <p>Eighteen heating plates , the surface of the machine is grinding. It adopts concentrated gravity roller press , pneumatic section adjustment , hydraulic automatic lifting . The</p>

			cotton belt adopts pneumatic tensioning , the upper belt adopts automatic correcting the error , the under cotton belt adopts manual adjustment. The temperature of the heating plate shows in three position (former , middle , back) , the inverter motor with variable frequency control.
9	型电脑纵切压线机 computer slitter scorer	2 台 two set	纵切压线变频控制，与生产线速度同步控制，电脑控制自动排单，自动磨刀，三种压线型式电动转换，自动调整间隙刀轮、线轮气动升降，左右电动纠偏。 The slitter scorer adopts inverter control , the same speed with the production line , the computer arrange order automatically , sharp the knife automatically , three pressing line type electric changing , automatically adjust the knife wheel gap , the pressing line wheel pneumatic lifting , electric adjustment for the left and right correcting the error.
10	型螺旋刀电脑横切机 spiral knife computer cut off	1 台 ONE set	意大利 PHASE 交流伺服电机,伺服驱动器控制螺旋刀辊横切，具备多组订单处理功能，自动换单、选择换单，进、出纸输送变频控制，自动跟踪生产线速度 Adopt Italian PHASE AC servo motor , servo driver control screw knife roller type, it can deal with several orders , changing the order automatically or manual , feeding in and out paper adopts inverter control, automatically tracks the speed of the production line.
11	ZJX- II 型制胶循环系统 ZJX- II making glue recycle system.	1 套 One set	各用胶部分储存和循环系统采用齿轮泵自动循环 Each using glue unit and glue storage unit adopt gear pump automatically recycle.
12	NC DOUBLE CUT OFF	1 套 One set	意大利 PHASE 交流伺服电机,伺服驱动器控制螺旋刀辊横切，具备多组订单处理功能，自动换单、选择换单，进、出纸输送变频控制，自动跟踪生产线速度

			Adopt Italian PHASE AC servo motor , servo driver control screw knife roller type, it can deal with several orders , changing the order automatically or manual , feeding in and out paper adopts inverter control, automatically tracks the speed of the production line.
13	DK ² - II 型电气控制系统 DK ² - II electric control system.	1 套 ONE set	主电机采用变频电机附变频器调速 胶量、速度 PLC 程序控制，触摸屏显示调节 整机配备速度呼唤、联动调速及自动调浆系统 配常规工况及整线速度显示牌 The main motor adopts inverter control , the glue quantity and speed adopt PLC control. The production line links together and control together with the touching screen displaying. It is also equipped with the automatic adjusting glue system. There is a big display board showing the working condition and the speed.
14	FLUTE ROLLERS (C,B,E)	3 套 THREE set	Corrugated flute A/C/B/E , the customer choose the parameter. The upper and down corrugated roller diameter is $\Phi 400$ mm, big and small roller design, the surface is grinding and chromed , no paste fork vacuum suction type , cardon coupling drive , the upper and down corrugated seat is a whole ,
15	BELT double facer	1 套 One set	machine,for low & High Speed Machine. High Quality Corugator Belt.Used on Double facer machine,for low & High Speed Machine. available with different specifications, minimum 50% Cotton, combined with 40% PET & 10 IDFA. IDFA prevent the cotton belt to be stretch or shrink. Cotton absorbs the heat and prevent the BELT to be damaged.
16	SPLICER	1 套	.The maximum diameter of the

		SIX set	<p>applicable paper: 1000mm.</p> <p>1. Paper planes with automatic tension control, high-speed bin, high success rate.</p> <p>2. No tail paper receiving, reducing paper consumption (only partially overlapping paper tape with a width of 40mm).</p> <p>3. when paper car take out, the automatic turn out, and the vacuum adsorption, easy paper loading, automatic tension control paper receiving zero turnovers.</p> <p>4. All PLC automatic control, accurate, less failure, easy maintenance.</p>
17	DOUBLE BASKET TYPE STACKER	1 套 One set	Multiple section belt transmission , it is the same speed with the production line with synchronous control
18	Rotary SHEET CUTTER	1 套 One set	

注：用户自备部分

Note : the customer provided

1. 生产线供热设备：额定蒸发量 4T/h，额定压力 1.1MPa 的蒸汽锅炉一套。
The production line supply heat, the rated steamed boiler is 4T/h , one set of rated pressure is 1.1Mpa .
2. 生产线用水管道及管件、锅炉至用汽设备接口处管道及回汽排水管道。
The production line water pipe and pipe fitting , the supply and back water pipe from the boiler to the using water machine connector.
3. 生产线所用气源至用气设备处、制胶房至用胶设备处管道及管件。
The pipe for the air need to get the using machine , the glue pipe and pipe fitting from the making glue room to the using machine.
4. 总配电柜至卖方电器柜所用线料及车间地下铺设的电缆电线所需的管材。
The wire between the general electric box and the customer electric box and the pipe under the ground when laying the cable and wire.
5. 地基基础工程，必须达到卖方提供的基础图要求。
The foundation engineering is should meet the foundation drawing of the order party request.
6. 试车用的原纸、水、电、制胶原料。
原纸要求：含水率 1.0±1%，面纸 120~200g/m² ，里纸 120~150g/m²，
芯纸 80~110g/m²，瓦纸 80~110g/m² ，以上原纸等级不低于 B 级。
The base paper , water , steam , electric power and glue making material.

The base paper requirement : moisture content $1 \pm 1\%$, surface paper $120 \sim 200 \text{ g/m}^2$, inner paper $120 \sim 150 \text{ g/m}^2$, core paper $80 \sim 180 \text{ g/m}^2$, corrugated paper $80 \sim 180 \text{ g/m}^2$, all the base paper level above is not less than B level.

Y. 调试设备常用的工具及辅料。

The common tools and auxiliary material when debug the machine.

3. 各单机技术说明

The single machine technical specification



mill roll stand

* 最大原纸直径: 1000 mm .

The maximum diameter of the base paper is 1000 mm

* 最小原纸直径: 300 mm .

The minimum diameter of the base paper is 300 mm

* 采油压升降式夹纸臂(附 4 KW 液压站).

The lifting arm adopts hydraulic drive (4 kw hydraulic station)

* 夹纸开合及左右移动皆以油压操作.

The clip paper and move left of right adopts the hydraulic drive.

* 张力控制:采用单点盘式气动刹车

The tension control adopt the single point disc pneumatic brake

* 每台原纸架附二台原纸搬运车及轨道(长度 6 M)

Each mill roll stand is equipped two trolley and six meter rail

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- * 夹头使用膨胀式夹头

Adopt expansion chuck

- * 液压站阀件台湾品牌

The hydraulic station valve is Taiwan brand



型单面瓦楞机.

single facer

- * 机械设计速度: 10·m/min

The mechanical design speed is 10·m/min

- * 加热方式: 蒸汽加热

Heating type : steam heating

- * 瓦楞辊:直径 320·mm,以镍铬钼合金钢制造,经热处理硬度在 HRC $\text{\textcircled{00-08}}$ 度,表面研磨镀铬处理,瓦楞辊使用寿命一般在 800-1000 万跑米 (视纸质)。

The corrugated roller diameter is 320·mm , made from Ni Cr Mo alloy steel , after heat treatment , the hardness is about HRC $\text{\textcircled{00-08}}$. Surface of the roller is grinding and chromed the life of the roller is about 8-10 millions meters.(according to the paper quality)

- * 压力辊:以碳钢制造,表面经研磨及镀铬处理

Press roller : it is made of carbon steel , surface of the roller is grinding and chromed.

- * 涂胶辊:表面压细目凹花并经镀铬处理,以防止甩浆.溅

Pasting glue roller : surface of roller is concave and chromed , in case of splash the glue

- * 上瓦楞辊及压力辊均由气缸控制动作

The upper corrugated roller and press roller adopt pneumatic cylinder control.

- * 涂胶辊移动由气缸控制动作

Pasting glue roller adopts pneumatic cylinder control

- * 匀胶辊: 表面经研磨及镀铬处理

Even glue roller : surface of the roller is grinding and chromed

- * 上下瓦楞轮及压力轮轴承哈、瓦、洛产，采用耐高温黄油润滑。

Bearing of the corrugated roller and press roller are Harbin, ZWZ, LYC with bearing high temperature oil to lubricate.

- * 涂胶辊与匀胶辊间隙采用减速电机电动微调并附触摸屏显示

The gap between pasting glue roller and even glue roller

- * 气压操作及电气操作集中在同一控制箱上

The pneumatic control and electric control are concentrated on one control box.

- * 含蒸气旋转接头,不锈钢软管排水器及本机使用之蒸气管道一套，能彻底排水

Including the steam rotary connector , stainless flexible pipe and the steam pipe of the machine , can drain the water throughly.

- * 电动隔糊装置(附减速电机二个)

Electric separate glue device (with two reducing speed motor)

- * 电眼追踪装置,断纸自动退糊及停机

Electric eye tracking device , automatically quit the glue and stop the machine.

- * 主传动采用油浸式齿轮箱变速传动

The main drive adopts gear box variable speed drive with the oil immersed gear lubrication

- * 输出轴配制万向接头

The output roller adopts the cardan

- * 主驱动电机采用变频电机附变频控制

The main motor adopts the inverter control



型面纸预热器

surface paper preheater

- * 预热缸: 直径 900mm 钢制品一支.

Preheater : the diameter is 900mm

- * 预热缸符合一类压力容器国家标准，附有压力容器检验合格证书

The preheater is according to the first grade national standard pressure vessel with the inspection certificate.

- * 导纸辊: 2支,其中1支固定,另1支可在预热缸外围游动,导纸轮位置以电动调整.

The leading roller : two , one is fixed , the other can adjust , the position of the roller adopts the electric adjustment.

- * 预热范围采电动操作，调整范围 60°-280°

The heating range adopts electric adjustment , the adjusting range is 60°-280° .

- * 附减速电机一个

A reducing speed motor.

- * 不锈钢蒸气软管、排水器

The stainless flexible steam pipe , drainer



型芯纸预调器

core paper preheater

- * 预热缸: 直径 900mm 钢制品一支.

The preheater : the diameter is 900mm

- * 预热缸符合一类压力容器国家标准，附有压力容器检验合格证书

The preheater is according to the first grade national standard pressure vessel with the inspection certificate.

- * 导纸轮: 2支,其中1支固定,另1支可在预热缸外围游动,导纸轮位置以电动调整.

The leading roller : two , one is fixed , the other can adjust , the position of the roller adopts the electric adjustment.

- * 预热范围采电动操作，调整范围 60°-280°

The heating range adopts electric adjustment , the adjusting range is 60°-280° .

- * 附张力平衡器一组

The tension balance device

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- * 附减速电机一个

A reducing speed motor.

- * 不锈钢蒸气软管、排水器.

The stainless flexible steam pipe , drainer



型三重预热器

FOUR layer preheater

- * 预热缸： 直径 900mm 钢制品三支.

The preheater : the diameter is 900mm

- * 预热缸符合一类压力容器国家标准，附有压力容器检验合格证书

The preheater is according to the first grade national standard pressure vessel with the inspection certificate.

- * 导纸轮： 6支,其中 3支固定,另 3支可在预热缸外围游动,导纸轮位置以电动调整.

The leading roller : six , three is fixed , other three can adjust , the position of the roller adopts the electric adjustment.

- * 预热范围采用电动操作，调整范围 60°-280°

The heating range adopts electric adjustment , the adjusting range is 60°-280° .

- * 附减速电机 3个

Three reducing speed motors.

- * 不锈钢蒸气软管、排水器.

The stainless flexible steam pipe , drainer

- * 机台由上中下 3层叠加而成，可单独操作使用，亦可一起工作

The machine is three layers , it can work at the same or separately



型双层输送天桥

double layer convey bridge

- * 主桥架以 2·# 槽钢制作,两侧均附安全栏杆及满铺的高强度踏板, 3 组爬梯, 确保桥上工作安全及操作方便。

Main bridge frame is made of 2·# groove steel , the two sides are equipped with safe guard rail and high strength foot step , three set ladder. Ensure the worker on the bridge safe and operate easily.

- * 爬坡输送架 2 组,安装在各单面瓦楞机之上方 (附变频电机 2 个)

The paper convey shelf two sets, they are installed above the single facer.(two inverter motor)

- * 平行输送架 2 层,引导单面瓦楞纸由单面瓦楞机到三重预热器.

Two layer parallel transmission frame, the function is to lead the paper from the single facer to the three layer preheater.

- * 附桥上吸风装置:纸之张力以空压控制, 以变频器调整张力大小(附吸风机 2 台)

The absorb wind device : its function is to control the paper tension with the inverter to control.(two sets absorb wind device)

- * 桥上吸风装置导纸板以自动调整左右移动 (附减速电机 4 个)

The suction wind device leading paper board on the bridge automatically adjust the right or left moving (equipped with four reducing speed motor)

- * 附操作盒, 可在桥上或地面涂胶机操作柜控制吸风装置导纸板左右移动

Two sets control box , the operator can operate the absorb wind device lead paper board move left and right on the bridge and on the ground.

- * 所有的皮带轮轴及导纸辊表面经磨削加工并镀铬处理

All the belt roller and lead paper roller adopt grinding and chromed treatment

型双层输送天桥

AUTO CORRECTION SYSTEM

- * 主桥架以 20# 槽钢制作,两侧均附安全栏杆及满铺的高强度踏板, 3 组爬梯, 确保桥上工作安全及操作方便。

Main bridge frame is made of 20# groove steel , the two sides are equipped with safe guard rail and high strength foot step , three set ladder. Ensure the worker on the bridge safe and operate easily.

- * 爬坡输送架 2 组,安装在各单面瓦楞机之上方 (附变频电机 2 个)

The paper convey shelf two sets, they are installed above the single facer.(two inverter motor)



型双层涂胶机.

double layer pasting glue machine

- * 涂胶辊:轮面压细网目凹花及镀铬处理计二支.

Pasting glue roller : surface of the roller is concave, two branch.

- * 匀胶辊:轮面经研磨及镀铬处理计二支.

Even glue roller : surface of the roller adopts grinding and chromed , two branch.

- * 采用压载辊施压上胶

Adopt pressure roller to paste the glue.

- * 两层单独传动(附减速电机 2 个).

Two layer separate drive. (two sets reducing speed motor)

- * 压纸轮之升降气压控制

The lift and down of the press paper roller adopts pneumatic control.

- * 压纸轮高低以减速电机电动微调

The press roller height adopts reducing speed motor electro micro adjustment.

- * 涂胶辊与匀胶辊之间隙以减速电机电动微调并附触摸屏显示，微调显示精度 0.1-0.2mm.

The gap between pasting glue roller and even glue roller adopt reducing speed motor with micro adjustment and touching screen display , the display precision is 0.1-0.2mm.

- * 浆盆采用不锈钢材料制作，装拆方便，清洗容易

The glue box adopts stainless steel material , easy installation and clean.

- * 面纸断纸或热板部停机时,压纸轮自动上升

The press paper roller will automatically go up when the paper broken or the heating department stops.

- * 采用变频器控制涂胶机运转速度与热板同步

Adopt inverter to control the pasting machine, the speed is synchronous with the heating plate.



型双面机.

double facer

A: 加热部:

A: heating department

- * 热板: 共计 18 块，表面经研磨处理

Heating plate : eighteen heating plates , surface of the heating plate is grinding.

- * 烘干箱符合一类压力容器国家标准，附有压力容器检验合格证书

Heating box accords with the national pressure vessel first standard with the pressure vessel inspection certificate.

- * 热板配压轮

The heating plate is equipped with the press roller.

- * 升降以油压电控操作(附 4KW 液压站一组)

The heating plate adopt hydraulic power to control (attach a 4kw hydraulic station)

- * 蒸气配管为手动调节方式

The steam pipe is manual adjustment.

- * 升降配齿轮箱

Up and down adopt gear box.

- * 主骨架用 2^#槽钢制作

The main frame adopt 2^# groove steel to make.

- * 上帆布带自动纠偏装置一组

The upper cotton belt is equipped with the auto correcting device .

B: 冷却部:

B: Cooling part

- * 上帆布带张力调整器二组

The upper cotton belt is equipped with two sets tension device.

- * 下帆布带张力调整器(含帆布带左右调整功能)一组.(手动调整).

The under belt is equipped with tension device , including the cotton belt adjust left or right with manual adjustment.

C: 驱动部:

C : Drive part

- * 上,下驱动轮表面包覆耐磨橡胶,并加工成人字型,使纸板稳定性佳.

The upper and under drive roller are packed with wear-resisting rubber , the shape of it is like 人, so it has good stability.

- * 齿轮箱经上下万向接头分别传动上, 下驱动轮.

The gear box adopt cardon to connect with separate drive.

- * 附齿轮箱一个

Attach a gear box

- * 附控制箱 1 个

Attach a electric control box

- * 主驱动电机为变频电机附变频控制。

The main motor is inverter.



型电脑纵切压线机

computer slitter scorer

- * 最大分纸张数：四开（刀轮五组，压线轮八组）
Maximum dividing paper quantity : four piece (five knife wheel , eight pressing line wheel)
- * 最小裁切距离：120mm 最小压线距离：0mm
The minimum cut distance: 120mm , the minimum pressing line distance : 0mm.
- * 上刀轮座与压线轮座升降以气压控制，更换订单时不必切断纸板及停机
The upper knife wheel and pressing line wheel adopt pneumatic control , it does not need to stop the machine and cut the paperboard when changing the order.
- * 分纸及压线尺寸以电动马达方式调整，最长2-8秒内完成尺寸调整
The dividing paper size and pressing line size adopt electric motor to adjust within 2-8 seconds to finish the adjustment.
- * 最多可输入999组尺寸可依实际需要输出任何一组订单生产
It can input 999 sets of size , the operator can choose any one according to the production needs.
- * 刀线左右排置由滚珠螺杆控制
The knife adopts the ball screw bar to control
- * 机器可左右横移100mm，采用手动方式调整
The machine can move within 100mm laterally with manual adjustment.
- * 预留电动式吸废纸装置风口
It is equipped with the electric type suction waste paper device.
- * 压线采用三种压线方式电动转换
It adopts three type pressing line type with electric change.
- * 线轮，刀轮用变频电机传动，连线后可与热板作同步运转
The pressing line wheel , knife wheel adopt inverter to transmit , after linking , it can run synchronously with the heating plate.



型螺旋刀电脑横切机.

spiral knife cut off machine,

- * 单层螺旋刀辊结构.

Single layer spiral knife structure

- * 采用高品质的工业计算机或人机界面组成上位计算机控制系统

Adopt high quality industrial computer and human-machine interface to make up the computer control system.

- * 采用交流伺服电机驱动，驱动器采用进口专用伺服驱动器控制

Adopt AC servo motor to drive , the drive unit adopt import specialized servo drive unit to control.

- * 具备多组订单处理功能，自动更换下批订单指示,操作简单便利.

It possesses the function to deal multi group orders , automatically show and change the next order instruction, easy operation and convenient.

- * 采用螺旋刀，裁切用力小，效率高

Adopt spiral knife with small strength and high efficiency.

- * 螺旋刀由特殊材料制成，刀辊结构设计合理，刀具寿命长

The spiral knife is made of special material. It is made of reasonable design and the knife is a long using life.

- * 机械结构设计合理，机械造型美观

The mechanical structure design is reasonable. the machine is a nice appearance.

- * 采用精密齿轮传动，通过锻造、精加工和热处理等工艺手段；

齿轮侧隙小、噪音低、传动平稳

Adopt precise gear to drive , through the forging precise machining and heat treatment.

It possess little gear gap , low noise and steady transmission.

- * 切断长度 400mm - 9999mm

The cut off length is 400mm - 9999mm

* 切断精度: ± 1 mm, 切断精度以 0.1 mm 为单位.

The cut off precision is ± 1 mm, the cut off precision unit is 0.1 mm.



2500型螺旋刀电脑横切机.

2500 type spiral knife cut off machine,

* 双层螺旋刀辊结构.

Single layer spiral knife structure

* 采用高品质的工业计算机或人机界面组成上位计算机控制系统

Adopt high quality industrial computer and human-machine interface to make up the computer control system.

* 采用交流伺服电机驱动, 驱动器采用进口专用伺服驱动器控制

Adopt AC servo motor to drive, the drive unit adopt import specialized servo drive unit to control.

* 设置远端吸附测米装置, 消除因刀辊裁切震动导致测米精度不准现象。同时设置动力输送平台, 配合压纸太阳辊减小纸板切断后的甩尾现象。

The far-end measuring device can eliminate the inaccuracy caused by the vibration of the knife roller cutting. Meanwhile, the dynamical transmission platform is set up to reduce the cardboard drift after cutting off.

* 横切进纸部采用双排太阳辊压纸结构，减小纸板震动，提高了测米精度；停机时可手动开合进纸部方便人员调试和维修。

The feeding part adopts double row rubber rollers to reduce the cardboard vibration and improve the measuring accuracy. It can be opened manually to debug and maintenance when the machine stops running.

* 采用新型滚筒式结构，中间芯轴钢性支撑，刀筒、刀架和配重结构一体加工形成，在提高钢性的同时有效降低了刀筒惯量，整体强度高。

Use new rotary drum structure and the middle spindle is supported rigidity. The cylinder, framework and counter weight are formed integrated. It can reduce the inertia and improve the whole strength.

* 封闭式强制润滑循环冷却系统，安装流量检测装置，具有自动检测设备缺油报警停止运行功能，避免设备因长期缺油损坏。

The closed forced lubrication circulation cooling system is set up the flow detection device. It can detect the oil shortage to stop the machine automatically, so as to avoid the damage owing to lack of oil.

* 出纸部分采用加长皮带输送设计，安装高压离心风机保证纸板输送平稳、整齐；配置有自动排废功能，实现局部粘合不良和换单交口的快速排废。

The paper ejecting part adopts extended belt conveying design and high pressure centrifugal fan to ensure the cardboards are smooth and orderly delivery. It also has automatic waste discharging function, which can manage the bad adhesion paper and waste order change part quickly.

* 具备多组订单处理功能，自动更换下批订单指示,操作简单便利.

It possesses the function to deal multi group orders , automatically show and change the next order instruction, easy operation and convenient.

* 采用螺旋刀，裁切用力小，效率高

Adopt spiral knife with small strength and high efficiency.

* 螺旋刀由特殊材料制成，刀辊结构设计合理，刀具寿命长

The spiral knife is made of special material. It is made of reasonable design and the knife is a long using life.

* 机械结构设计合理，机械造型美观

The mechanical structure design is reasonable. the machine is a nice appearance.

* 切断长度400mm - 9999mm

The cut off length is 400mm - 9999mm

* 切断精度: ± 1 mm.

The cut off precision is ± 1 mm.

* 具备999笔订单处理功能. 计算机自动更换下批订单指示,操作简单便利.

It possesses dealing with 999 sets order ability, computer automatically change following orders, easy operation and convenient precision of cutting off is ± 1 mm

DK₂-II 型电气控制系统

DK₂-II electric control system

A: 总体控制方式:

Total control manner

- * 采用 PLC 现场总线控制，全线协调生产。
Adopt PLC control , the production line coordinate production.
- * 细致的控制方式，平滑的调速曲线，方便的操作流程，完整的故障应对方案。
Meticulous control manner , smooth adjusting speed curve.
- * 人性化的人机界面具备完善的帮助中心、故障检测、运行操控和状态监视等。
The human-machine interface has perfect help center, fault detect , operation control stateful inspection and so on.
- * 以变频调速为主轴，从纸架到双面机，从天桥输送到张紧控制，从电柜散热到电机散热，所有电机自动关闭，全面节省能源消耗和降低机械损耗。
Adopt inverter to drive , from the mill roll stand to the double face machine , from the over head convey bridge to the tension control , both the electric box and motor heat dissipation, all the motor automatically close , saving the energy consumption and reduce the mechanical consumption .

B: 各机组控制方式:

Each unit control method

- * 液压纸架：液压控制、本机和单面机两地控制。
Mill roll stand : hydraulic control , two position control , one is on mill roll stand , the other is on the single facer.
- * 预热器： 常规控制、本机和单面机两地控制。
Preheater : routine control : two position control , one is on mill roll stand , the other is on the single facer.
- * 单面机： PLC 控制、触摸屏显示、主机变频调速、自动浆厚、断纸检测、联动控制、产量控制、自动浆糊循环。
Single facer : PLC control , touching screen display , main motor inverter control , automatically adjust the glue thickness , break paper inspection device , linkage control production control , the glue automatically cycle.
- * 输送天桥：常规控制、变频风量调整，输送电机变频调速。
The convey bridge : routine control , inverter adjust the quantity of the glue , the transmission motor adopts inverter.
- * 涂胶机： PLC 控制、触摸屏显示、自动浆厚、断纸检测、自动压载、自动浆糊循环。
Pasting glue machine : PLC control , touching screen display , automatically adjust the glue thickness , break paper automatic inspection device , automatically add the load ,

the glue automatically cycle.

- * 双面机： PLC 控制和触摸屏显示、温度显示、异地调速、产量控制。

Double face : PLC control , touching screen display , temperature displays , different place adjusting the speed , production control.

- * 显示牌： PLC 控制、大型数码显示主线的速度，速度状态和生产状态提示。

The display board : PLC control , big digital board shows the machine speed with the speed state and production state.

C: 元器件选型:

Components selection

- * 主要元器件选用法国施耐德、台湾永宏、台湾台达、韩国奥托尼克斯等国际知名品牌的产
品。

The main components selects the Schneider , Fatek in Taiwan , Delta in Taiwan , Autonics in Korea and other international famous brand.



PRESSURE ROLLERS

three set cardon coupling drive , the upper and down corrugated seat is a whole ,for glue of single facer

20 AIRBAG TYPE SHOE PLATE DOUBLE FACER 1套

one set the under cotton belt adopts manual adjustment. The temperature of the heating plate shows in three position (former , middle , back) , the inverter motor with variable frequency control.

Double facer belt

two set High Quality Corugator Belt.Used on Double facer machine,for low & High Speed Machine.

High Quality Corugator Belt.Used on Double facer machine,for low & High Speed Machine.

available with different specifications, minimum 90% Cotton, combined with 10% PET & 10% IDFA. IDFA prevent the cotton belt to be stretch or shrink. Cotton absorbs the heat and prevent the BELt to be damaged.

—
This belt can run successfully both on Steam base Double Facers and machines based on Direct flame. The heat resistance is so heavy that it can melt on 200 Degree, and Long



SPLICER

1.The maximum diameter of the applicable paper:1000 mm.

2.Paper planes with automatic tension control, high-speed bin, high success rate.

3.No tail paper receiving, reducing paper consumption (only partially overlapping paper tape with a width of 40 mm).

4.when paper car take out, the automatic turn out, and the vacuum adsorption, easy paper loading, automatic tension control paper receiving zero turnovers.

5.All PLC automatic control, accurate, less failure, easy maintenance.

6.The first round of the buffer when you pull the paper, automatic alignment, easy to pull paper.

7.Machine superiority cylinder control speed splicers paper receiving moment does not appear normal motor control of rubble, blistering.

8.paper receiving highest speed of 220 m / min.



SPLICER

one set Synchronous with production management control system, changing order automatically in high speed.

۲, Belt type stacking platform, AC servo control movements, stacking smoothly and tidily.

۳, Automatic paperboard side delivery when reaching set quantity.

۴, Paperboard dam controlled by AC servo system, changing order automatically and fast.

۵, Individual sealed control cabinet, electrical equipment running in clean environment.

۶, Color touch-screen display for easy field operation.

۷, Fully automatic operation control, high efficiency and lower manpower



DM3-2500 型双层吊篮式自动堆码机

DM3-2500 double layer hang basket auto stacker

* 独立的输送带，分别由变频电机控制，自动依生产速度变更输送速度。

Five piece independent conveyer belt with different inverter motor control, automatically change transmit speed according to production speed

* 吊篮式电脑自动控制，伺服马达升降叠纸装置，可以做到吊篮匀速升降，堆码平稳、整齐。

Hang basket computer automatic control, servo motor up and down furl paper device, it can make the receiving paper plate uniform moving, it is steady and neat.

* 输送首段真空吸附送纸，四排碳纤维压条自动控制压纸，纸板整齐、分批准确，堆叠更稳定。

Transmit first section adopt vacuum type, four rows carbon fiber pressing bar automatically control pressing paper, paper receiving neatly, steadily and accurately.

* 采用电脑化自动控制，能接受订单，自动换单，换批，纸张计算精确。

Adopt computer automatic control, can accept the order, automatically change order and batch, paper calculate accurately.

* 叠纸方式配合纸板的速度及订单改变而自动控制，效率高，节省人力。

The paper patting type automatic control according to the paperboard speed and order change with high efficiency and save labor.

* 后挡板尺寸调整采用伺服电机同步设定。

Back baffle size adjustment adopt servo motor to synchronous setting.

* 堆码横排平台模组带结构，堆码达到设定数量时自动平稳横向输出。

Stacker later output adopt plate module belt, after reaching the setting quantity will automatically output steadily.

* 上层最大堆积高度 2000mm，最大堆积长度 3500mm，下层最大堆积高度 1500mm，最大堆积长度 3000mm。

Up layer paperboard maximum height is 2000mm, maximum length 3500mm, down layer maximum height is 1800mm, maximum length 3000mm.

ZG3 型蒸汽管道加热系统 \ 套

ZG3 steamed pipe heating system , one set

* 为生产线各用热设备提供加热能源，保持工作温度的稳定。

Supply the heating source to the production line and keep the working temperature steady.

* 各机组均设计成独立小单元分汽系统，减缓流速，汽水分离，控制方便。

Each unit is design as a small independent system , to slow the flow velocity , to make the

steam and water divided , control conveniently.

* 通过调节蒸汽压力来实行对工作温度的控制，并设有压力监视仪表。

By adjusting the steam pressure to control the working temperature with the pressure monitor instrument

- * 采用台湾品牌倒桶式疏水阀，加热迅速，疏水效果好。

Adopt the Taiwan brand relading drain valve , quick heating and good drain effect.

- * 每组疏水单元均设有排空旁通，停产时设备降温迅速。

Each drain unit is equipped with the by pass device . It can cool quickly when stop produce.

- * 管道加热系统与旋转加热部件间以金属软管实现柔性连接，以延长旋转接头的使用寿命。

The steamed heating system and the rotary heating part adopt metal flexible pipe to connect to

prolong the rotary heating connector using life.

- * 所有蒸汽输送管材料均选用优质无缝钢管，确保其在压力作用下的使用安全性。

All the steamed pipe adopt good quality seamless pipe to ensure the operator safe when

working at normal situation.

- * 所有用热设备分汽包接口到锅炉房所有供热元件用户自备。

All supplying heat components between the connectors of using heating equipment and

the boiler are provided by the customer.

- * 所有用热设备管道保温材料用户自备。

All the using heating pipe and thermal insulation material are provided by the customer.



KY- II ROTARY SHEET CUTTER

Single layer spiral knife structure

- * **采用高品质的工业计算机或人机界面组成上位计**

计算机控制系统

Adopt high quality industrial computer and human-machine interface to make up the computer control system.

*** 采用交流伺服电机驱动，驱动器采用进口专用伺服驱动器控制**

Adopt AC servo motor to drive , the drive unit adopt import specialized servo drive unit to control.

