

WJ1800-250 Type 3 LAYER CORRUGATOR LINE

(Design Speed :250m/min Working Speed: 200m/min)



WJ1800-250 Type 3 LAYER CORRUGATOR LINE

Type	Name	Qty.	Feature
HB-I	Hydraulic Mill Roll Stand (with trolley and track)	3	Main shaft diameter is 242mm, doublecurve heavy rocker arm, tooth clip,multipoint brake,hydraulic lift, left and right translation. Guide rail length is 6000 mm, the car uses 10 mm plate welding
SP-1-600	Pre-heater	2	The roller \varnothing 600 mm, including the pressure vessel certificate; electric adjustment angle; angle can be adjusted within the range of 360 °
320C	Single Facer	1	Corrugated diameter is 320mm, 48CrMo high quality alloy steel; Adopt independent gearbox, universal joint drive structure; Air cylinder ballast structure; Steam heating
SP-2-600	Duplex Pre-heater	1	The roller \varnothing 600 mm, including the pressure vessel certificate; electric adjustment angle; angle can be adjusted within the range of 360 °
OHB	Conveying Bridge	1	Main girer is 200mm box iron , independent frequency conversion motor drive paper transport, adsorption tension. Electric correction.
CGM-F	Gluer Machine	1	Glue roller dia. is 269mm, carved 25 line pit type checker; independent variable frequency motor drive, glue clearance controlled by PLC and man-machine interface; Glue quantity of digital display.
HPM	Double Facer	1	Hot plate 600 mm * 14pcs; press rollers lift by pneumatic, compressed press rollers structure
FTKM	Thin Blade machine	1	Blade adjust by electric, 4 blade 6 line, Adopt tungsten carbide knife
NC-120	NC Cut-Off	1	Full AC servo control, braking is energy storage type, duplex spiral cutter structure, oil-immersed gear transmission, a 10.4 -inch touch screen display.
SMA-S	Carton Sheet Stacker	1	Electrical adjust the cardboard size , Transverse output cardboard by pneumatic
ZQ	Internal Steam System	1	Steam system components adopt GB valva; Contains rotary joint, up and down distributor , drain valve,steam trap and pressure gauge, etc.; Boiler and piping supply by customer
ZJZ	Glue Making System	1	Customer-owned pipeline。

HB-I Hydraulic Mill Roll Stand

► Structure and Features:

1. Reel paper lift-lower, clamp, loosen, movement, contra position operated by hydraulic.feeding kraft / reel paper quickly.
2. Brake: multiple-point brake.
3. Each stand with two feeding trolley



► Spec of stand:

1. Width: Max: 1800mm Min: 700mm
2. Diameter: Max: $\Phi 1500\text{mm}$
3. Main Shaft Dia.: $\Phi 242\text{mm}$
4. Max Weight:3000Kg(One side)
5. Pneumatic Source Pressure(Mpa): 0.4---0.8Mpa

► Spec of Hydraulic:

1. Working Pressure(mpa):16-18mpa
2. lift hydraulic cylinder: $\Phi 100 \times 440\text{mm}$
3. Clamping hydraulic cylinder: $\Phi 63 \times 1300\text{mm}$
4. Power Motor for Hydraulic Station:3KW --380V -- 50Hz
5. Magnetic Valve Voltage:380V 50HZ

✘ Kraft paper feeding ground rack & trolley



►**Structure and Features:**

1. To feed the kraft paper to reel stand.
2. The whole body of rack is under the ground, main frame: Model 14 channel steel with ϕ 20mm drawing bar weld together, overall length 6000mm.
3. Two racks for one reel stand to feed the kraft paper at both side.

SP- 600 Preheater



►**Structure and Features:**

1. The preheater roller is under the stander of the 1st class(grade) pressure vessel of the national.
2. All the surfaces of every rollers have been grinded with high accuracy and chromed plated to less the resistance of paper preheating, long service of using life.
3. Electric to enlarge the preheating area, preheating area can be in 360° to adjust the preheating Area

►**Common Spec:**

1. Working Width: 1800mm
2. Diameter of the Preheater cylinder: $\Phi 600\text{mm}$ Diameter of the roller for Preheating : $\Phi 85\text{mm}$
3. Steam temperature: 150-200°C Steam pressure: 0.8-1.3Mpa
4. Working Power: 380V 50Hz
5. Power: 250W Short Time(S2) Working Type

※320C Single facer



►Structure and Features:

1. Adopt vacuum suction structure, with high pressure strong blower. Suction with silencer. Gas supply and electrical control cabinet to focus on the same operation cabinet, not less than 1.5 meters away from the host, Fully enclosed full operation side
2. Base and wallboard cast iron wall, Wallboard thickness 130mm。 universal Joints
3. Corrugated roller material adopt 48CrMo alloy steel, quenched、Laser hardening, Surface finish, main roll of corrugated diameter $\phi 320\text{mm}$, surface hardness HRC58 degree above。 The key parts of the tile and pressure roller bearings Wafangdian produce high temperature bearings
4. Pressure roller $\phi 324\text{mm}$, surface grinding and chrome-plated; cylinder control and remove up and down, 45 carbon steel materials, quenching

5. Pneumatic control glue to glue back, glue roller diameter ϕ 240mm, Engraved polished surface after a 25-line pit style textured machined chrome plated, after scraping the roller surface polished hard chrome plated

6. Corrugated roller, pressure roller materials provided by the Central Plains Steel, High on corrugating unilateral 0.15mm, 0.075mm high pressure roller unilateral. Plus stopper. ϕ 160mm cylinder with compression cylinder

7. Preheat roll adopt seamless steel pipe production by tiangan ϕ 400mm, connecting with metal

► Common Spec:

1、 Effective width: 1800mm

2、 Operation direction: left or right (determined in accordance with customer plant)

3、 Design Speed: 120m/min Working Speed: 100m/min

5、 Temperature: 160—200°C 6、 Gas source: 0.4—0.9Mpa

7、 Steam pressure: 0.8—1.3Mpa 8、 Corrugated flute: A\B\C\E\F

► Roller diameters parameters

1. Dia. of corrugated roller: ϕ 320mm 2. Dia. of pressure roller: ϕ 324mm

3. Dia. of glue roller: ϕ 240mm 4. Dia. of preheat roller: ϕ 400mm

► Spec of Motor:

1、 Main drive motor: 15KW Rated voltage: 380V 50Hz Continuous (S1) working standard

2、 Suction motor: 11KW Rated voltage: 380V 50Hz Continuous (S1) working standard

CGM-F Gluer Machine



►Structure and Features:

1. After the glue roller surface quenched, bore machining, surface grinding and doing balancing engraved pit style textured, coating evenly, consume less glue.
 2. Glue roller rotation frequency motor control, the inverter control ensures glue line speed and duplex roller synchronous machines, and can operate independently.
 3. Electric adjustment digital glue. Automatic cycle for glue, glue avoid sedimentation and viscosity stability.
 4. Pneumatic presses structure, trimming the gap by the electric.
 5. Sided machine speed signal measurements taken in order to achieve its synchronous operation.
- Man-machine interface display, easy operation.

►Common Spec:

1. Preheater cylinder temperature range: 160—200°C Steam pressure: 0.8—1.2Mpa
2. Pneumatic system: 0.4—0.7Mpa

►Spec of the rollers' diameter:

1. Glue roller:Φ269mm Glue amount adjusting roller:Φ140mm
2. Down preheater roller:Φ402mm Up preheater roller: Φ374mm Paper roller: Φ86mm

►Spec of Motor:

1. Glue rollers frequency variable motor: 3KW
Nominal voltage: 380V 50Hz Continuous (S1) working Type
2. Glue quantity adjustment motor: 100W
Nominal voltage:380V 50Hz Short time (S2) working Type
3. Glue pump motor: 2.2KW
Nominal voltage: 380V 50Hz Continuous (S1) working Type

OHB Conveying Bridge



►Structure and Features:

1. The Main Frame is connected with channel steel, and angle steel.
2. With Protecting Handrail on both sides and safety pedal, the operation side is installed with safety ladder, to make sure the safety and convenience of the worker.
3. Vacuum suction tension control, suction pipe with adjusting valve, draw fan power can be adjusted freely.
4. Correct the position by double guide posts , correct parts are driven by screw , fast and accuracy to position, steady to move.

►Spec of the rollers:

1. Paper feeding rollers & tension rollers: $\Phi 127\text{mm}$ transport rollers: $\Phi 110\text{mm}$
2. Main tension drive rollers: $\Phi 127\text{mm}$ paper pass rollers and paper guide rollers: $\Phi 110\text{mm}$
3. Paper feeding rollers with belts: $\Phi 110\text{mm}$

►Spec of Motor:

1. Single face sheet draw motor: 3kw, 380V 50Hz Continuous (S1) working Type
2. Draw Fan Motor: 3kw, 380V 50Hz Continuous (S1) working Type
3. Paper width adjusting speed reducer: 250w 380V 50Hz Short time (S2) working Type

HPM Double Facer



►Structure and Features:

1. Hot Plates' surfaces is grinded and then chromed plated,width:600mm.total 14 pieces of hot plates

Hot plates are made by container plates, can pass the national first level pressure container standars

2. Hot plates adopts the compressed press rollers structure.Pressure roller lifting adopt pneumatic structure

3. Up convey belt left and right correct by auto with both sides, tension adjusting system; down belt manual small amount adjust.

4. Drive rollers' surface is wrapped by rubber, Y shape structure,with middle height,to make sure the board can be out smoothly

5. Main drive motor: Variable frequency motor, high force when low speed start, high speed adjusting range, steady to use,easy to mend.

6. Hot Plates' heat pipe piecewise control temperature.

7. Up belt adopt double cylinder S type tensioning device

8. Under belt adopt S type manual correct tensioning device.

►Common Spec:

1. Temperature requirement: 160—200°C Steam Pressure :0.8-1.3Mpa

2. Air pressure:0.6—0.9Mpa

3. Cool shaping length: 4m Heating plates amount: 14 pieces

Up drive roller

Down drive roller Wrapped by anti-grinded rubber

1、 Front driven belt roller

Back Shaping Driven belt roller

2、 Belt Press roller

Shaping Holder Roller

3、 Up Belt Tension roller

Up belt correcting roller

4、 Down Belt Tension roller

Down Belt Holder Roller

Note: All the surfaces of the rollers are grinded and then chromed plated.

► **Spec of Motor:**

Main Drive Motor: 37kw Frequency

Nominal voltage: 380V 50Hz Continuous (S1) working Type.

FTKM Electric Slitter Scorer



► **Structure and Features:**

1. Overcome the phenomenon of collapse the board when crop, smooth cutting, and the quality is improved

2. The machine can move lift and right, adjust by cycloidal reducer.
3. Cutter and line pressing adjustment convenient, error is ± 0.5 mm, with automatic sharpening device
4. 4 blades 6 lines type, blade is made of tungsten alloy steel, life is more than 30,000 m

► **Technical parameter:**

1. Max. width: 1800mm
2. Specification: 4 knives 6 lines
3. Min. Cut width: 135mm
4. Max cut width: 1450mm

► **Motor:**

1. Knife motor:0.4KW
2. Knife driver motor:5.5KW

NC-120 Cut Off Machine



► **Structure and Features:**

1. Cutting length:500mm-9999mm. Cutting precision: ± 1 mm.
2. Knife shaft gear using precision forging steel material high frequency quenching, lateral clearance transmission , adopt the keyless connection mode, high driving accuracy.
3. Helical knife structure,type sawtooth knife,decrease cutting obstruction,low noise.
4. Balance treatment, high quality alloy steel for blade shaft,which helps to keep it good stability.

5. Sun-shape wheels press cardboard in the front and the rear conveyer. The transporting is stable and with even pressure, which avoids jamming caused or broken cardboard.
6. Precision adjustable gap gear, ensure blade precision engagement, running balance.
7. Machine base and wall panel adopt the grey cast iron, good rigidity, strong vibration resistance.
8. The servo controller controls the servo motor, Taiwan Eview 10.4 inch touch screen

► **Technical parameter:**

1. Min. cut length: 500mm
2. Max cut length: 9999mm
3. Cut precision: uniform velocity ± 1 mm, non-uniform velocity ± 2 mm
4. Design speed: 120m/min

► **Motor:**

1. Main motor: 12.5kw Ac synchronous servo
2. Feeder motor: 3 kw (Frequency control the speed)
3. Lubricating oil pump motor: 0.25kw

Right Angle Stacker



► **Structure & Features:**

1. Welded by 14 # channel steel, electric to adjust the size of the board, pneumatic to control the output on transverse direction, output speed can be adjusted electrically.
2. Corrugated sheet can be controlled output by foot switch when the amount or height of stacking corrugated sheet reaches the needs.
3. Longitudinal joint paper adopts wide conveyor belt conveyor.

▶ **Common Spec:**

- 1、 Max length of stacking:3000mm
- 2、 Max height of stacking: 200mm

▶ **Spec of Motor:**

1. Main feeding frequency variable motor: 3KW Frequency conversion motor
2. Transverse direction motor: 1.5KW Three-phase asynchronous motor
- 3.Traveling motor: 1.5KW Three-phase asynchronous motor

※ **Glue Making System**



1. Supply the glue for the single facers and double glue machine which use glue water
2. The glue in the glue storage tank are transported by the glue pump to the device.
3. The storage tank and glue supply tank are with mix device, to avoid the glue becoming into the sediment.
4. Glue making device: Main Glue mixer, Vice Glue Mixer, Glue storage tank, glue feeding pump, glue return pump.
5. Glue making system adopts the recycle glue supplying, the rest glue returns back, the glue from the return tank is transported to the tanks of each glue using device, to make the functions of the recycle and saving be true, and avoid the glue becoming into the sediment.
6. After the work finished, rest glue of each glue using devices are draw to the glue return storage tank to prepare for the next time using.
7. Horizontal glue machine can mix the main glue and carrier glue at the same time, and mix and stir, the production of glue is large.

8. Responsible for technique guidance, and glue making way.

Steam System

► Structure & Features:

1. To supply the heating energy for the various heating parts of the line, and keep the working temperature steady.
2. Each groups are deigned to be single steam supply system, temperature control by separately, energy saving and adjust conveniently.
3. Temperature controlled by adjusting the steam pressure, and with pressure gauge.
4. To long the using line of the rotary joints, the pipe system and rotary heating parts are connected by metal flexible pipe to realize the flexible connection
5. All the steam pipes are made of seamless steel pipe, to make sure the safety under the normal pressure.



► Common Spec:

1. Suitable boiler: 2t/h
2. Suitable boiler pressure: 1.25Mpa
3. Temperature inside of pipe: 170—200°C
4. steam consumption: about 1.5-2.5T/h