

Hebei Greens Building Material Technology Development Co., Ltd

2.2.9	成型台 forming table	1	<p>不锈钢台面(厚度 6mm), 不锈钢立腿(高度可调), 2套振动辊 1.5kw (FC)×2, 搅拌机中心到成型机~4.5m 减速机国茂.适应厚度 7---15 毫米。</p> <p>1. platform: stainless steel, 6mm in thickness 2. leg: stainless steel, adjustable 3. vibrating roller: 2 sets 1.5kw x 2 (FC) 4. ~4.5m from center of mixer to forming machine. Gear motor: GUOMAO 7-15mm thickness</p>	<p>振动辊电机为变频控制, 转速与旋转方向可控, 将料浆最大程度的摊开, 消除大的气泡</p> <p>1. vibrating motor: inverter control 2. slurry will be scattered quickly 3. break big bubble</p>	2.2
2.2.10	成型机 forming machine	1	<p>挤压式成型机, 气缸下置; 板厚调整电机: 0.55kw×2, 带上板气动抬起机构, 边胶机构及折边机构等 减速机国茂.</p> <p>1. extruder type; cylinder under the plate; thickness adjusted by motor: 0.55kw x 2; 2. with pneumatic lifting device for upper plate 3. with gluing device and edges treatment structure etc. gear motor: GUOMAO</p>	<p>厚度可通过数字显示仪显示, 边胶装置采用自动上胶, 通过传感器检测胶水液位面, 减少人工</p> <p>1. thickness: digital display 2. gluing: level detected by sensor; easy operation</p>	12
2.3.1	凝固皮带机 setting belt	1	<p>皮带速度 Vmax=30m/min, 长度~120 米×1 条, 功率~ 15kw 1 台 (FC), 带清洗节 0.75kw, 带气动压轮 3 组, 带压平板及档边板 4 套, 带喷雾装置及湿边装置各 2 套 减速机国茂. 皮带厚度 14mm, 皮带宽度 1350mm</p> <p>1. max. speed of belt: 30m/min; length: ~120m x 1 set. 2. power ~15kw x 1 (FC) with washing section 0.75kw 3. with pneumatic impressing wheel: 3 group 4. with impressing plate and baffle 4 sets 5. with mist spray device and wet edges device: 2 sets for each. gear motor: GUOMAO 6. Belt thickness: 14mm; belt width 1350mm</p>	<p>皮带采用山东兖州康迪泰克, 皮带清洗是清洗皮带正面, 反面采用刮板方式清洗</p> <p>1. belt brand: Conti Tech (Shangdong Yanzhou). 2. belt washing means cleaning face side. back side will be cleaned by blade.</p>	25
	楔边带 Tapper belt	1	<p>共 255m, 两段 255m in total length; 2 parts</p>	<p>不是纯橡胶的, 里面带夹层 Not 100% rubber. Cotton etc inside</p>	
2.3.2	输送辊道 conveyor roller	1	<p>速度 Vmax=30m/min, 长度~ 20 米, 不锈钢辊 φ76mm*2mm, 功率~ 5.5kw (FC) 减速机国茂</p> <p>1. max. speed: 30m/min 2. length: ~20m, stainless steel roller φ76mm*2mm 3. power: ~5.5kw (FC). gear motor: GUOMAO</p>		5
2.3.3	切断机 cutter	1	<p>双伺服切断机, 电机功率 2.3Kw×2 (FC) 成品板尺寸: 长度 2000-3000mm; 宽度</p>	<p>伺服电机减速机为创升</p>	5.5



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			1200-1220mm with double servo-motor; power 2.3kw x 2 (FC); final gypsum board: length 2000-3000mm; width 1200-1220mm	reducer brand of servo motor: chuang sheng, 切断机要有计数功能 With counting function	
2.3.4	加速皮带 accelerating belt	1	长度 ~ 11.4m, Vmax: ~ 90m/min, 分成 2 段, 3kw×2 (FC), 减速机国茂 1. length: ~11.4m; 2. max. speed: ~90m/min; 2 section, 3kw x 2 (FC). gear motor: GUOMAO		3
2.3.5	1#横向输送机 1# cross	1	进出板辊道长度: ~ 10.8 米, 进板辊道: 2.2kw (FC), 出板辊道 2.2kw (FC), 横向皮带分 3 段, 3kw×3 (FC), 翻版机构: 5.5kw (FC). 进出 辊架升降: 2.2kw×2, 不锈钢辊 减速机国茂 1. roller length of board feeding and discharging: ~6500mm 2. board feeding: 2.2kw (FC); board discharging: 2.2kw (FC) 3. horizontal belt: 3 section, 2.2kw x 3 (FC) 4. board overturn: 4kw (FC) 5. lifting of roller frames: 2.2kw x 2; stainless steel rollers. gear motor: GUOMAO		12
2.3.6	湿废板输送机 waste wet board reject	1	将湿废石膏板输送至生产线外的湿废板堆处 4kw. 长度 13 米 move waste wet board into certain place; 4kw. length 13m	接 1#横向进板辊道后 面 connect with the end of board feeding roller table	3.5
2.4.1	分配机 tipple	1	长度 ~ 10m, 皮带机功率: 4kw 升降电机功 率: ~ 5.5kw 减速机国茂 length: ~10m; belt conveyor: 4kw; lifting motor: ~5.5kw; gear motor: GUOMAO	加合并小辊 add close rollers 分配机也要有计数功 能 With counting function	7
2.4.2	干燥机 dryer 干燥机线速度: 1.5m/min Line speed of dryer: 1.5m/min	1	热风直接加热型干燥机: 3 个热风循环区, 10 层辊道, 纵向气流, 顶置式风道, 分层辊道传 动, 铰链隔热门, 重力张紧. 每个区 20 个热电 偶, 与 PLC 连接. 蒸发能力: ~ 10t/h. 封闭段长度: ~ 80m; 高度~6.7 米, 宽度~3.38 米. 风道~1600 x 1600mm 带保温 进端长度 16 米, 电机: 3kw×10 台 (FC), 主传 动 5.5kw×5 台 (FC); I 区风机 ~ 75kw×2 台(80000 立方/时/台); II 区风机 ~ 90kw×2 台(10000 立 方/时/台); III 区风机 ~ 75kw×2 台(80000 立 方/时/台); 变频控制, 出端长度 14 米, 电机: 1.5kw×10 台 (FC)	进板考虑追板装置, 减 速机国茂 1. board feeding think about the follow up device 2. gear motor GUOMAO 含两套管道式燃烧器 燃烧器能力: 300 万 kcal + 400 万 kcal+ 200 万 kcal With three sets pipe type gas burners 3 x 10 ⁶ Kcal/h + 4 x 10 ⁶ Kcal/h + 2 x 10 ⁶ Kcal/h	



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		<p>保温门厚度 12cm, 顶门厚度 12cm, 底门厚度 12cm。全部带保温。</p> <p>保温门内侧用镀锌板厚度 2mm; 外侧用钢板厚度 2mm, 喷银色耐高温漆。干燥机每边 34 个门; 两边共 68 个门。</p> <p>2 个烟囱。</p> <p>1. Technology of dryer: Hot air direct heating</p> <p>2. hot air circulation zones: 3 zones. 10 layer, longitudinal airflow; air channel on the top, roller conveyor each layer, insulated door with hinges, spring tension device. 20 temperature sensors each zone, connect with PLC.</p> <p>3. evaporation capacity: ~10t/h. closed section length ~80m; height ~4.18m, width ~3.38m. Air channel ~1600 x 1600mm with insulating</p> <p>4. feeding motor 3kw x 10 (FC); main drive 5.5kw x 5 (FC)</p> <p>5. I zone: fan ~75kw x 2 (air volume of each fan 80000 m³/h); II zone: fan ~90kw x 2 (air volume of each fan 100000 m³/h), III zone: fan ~75kw x 2 (air volume of each fan 80000 m³/h); frequency control</p> <p>Dryer door thickness: 12cm; bottom cover thickness: 12cm; roof cover thickness: 12cm. All with insulating.</p> <p>Use galvanized plate (2mm thickness) on inside of dryer.</p> <p>Use steel plate (2mm thickness) on outside of dryer. Then painting high temperature-resistant paint (silver color).</p> <p>Dryer door: 34 pcs each side. Total 68 dryer doors for the dryer.</p> <p>2 chimney.</p>	<p>燃烧器可以控制</p> <p>Proportional adjustment for the burners control.</p> <p>烘干室颜色: 银色 the color of dryer is silver</p>	
2.4.3	出板机 board discharging	<p>1</p> <p>总长: 15m; 斜置 9 层辊道; 3kw×8 台; 皮带机: 4kw×1 台</p> <p>1. total length: 15m</p> <p>2. 8 decks rollers (inclined): 3kw x 8; belt conveyor: 4kw x 1</p>		12
2.5.1	收集皮带机 collecting belt conveyor	<p>1</p> <p>长度: ~ 5.4m; 分 2 段; 2.2kw×2 台 (FC)</p> <p>length~5400mm; two section; 2.2kw x 2 (FC)</p>		4
2.5.2	2#横向输送机 2# cross	<p>1</p> <p>入板辊道供横向输送最大板长: 6m (单列); 进板辊道: 3kw (FC); 横向皮带: 3kw (FC); 横向升降: 2.2kw;</p> <p>1. max. board length: 6000mm (single row)</p> <p>2. board feeding roller: 3kw (FC)</p> <p>3. horizontal belt: 3kw (FC)</p> <p>4. horizontal lifting: 2.2kw</p>	<p>减速机国茂</p> <p>gear motor: GUOMAO</p>	3.5



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2.5.3	2 横挡板部装 Subassembly baffle of 2# cross	1	气动 pneumatic		0.5
2.5.4	干废板辊道 dry waste board reject	1	长度~6米, 电机~4kw, 高度可调节 Length ~6m; motor ~4kw; height adjustable		9
2.5.5	合片机 face to face	1	皮带机 2.2kw×2 台 (FC) ; 合片机构 4kw; belt conveyer 2.2 x 2 (FC); face to face device 4kw	适应 5m 的石膏板, 合 片减速机国茂 suitable for 5000mm gypsum board; gear motor: GUOMAO	4
2.5.6	3#横向输送机 3# cross	2	皮带机长度: ~1.75m, 3kw (FC) ; 横向辊道: 2.2kw×1 台 (FC) , 举升 2.2kw 1. belt conveyer length: ~1750mm, 3kw (FC) 2. horizontal roller: 2.2kw x 1 (FC) 3. lift 2.2kw	减速机国茂 gear motor: GUOMAO	5
2.5.7	选片输送辊道 conveying roller of option board	2	长度: ≥3.3m; 4kw (FC) length:≥3.3m; 4kw (FC)		3
2.5.8	选片推入装置 pushing device of option board	2	1.5kw; 上夹棍带气动升降, 可正反向传动 1.5kw; upper roller with pneumatic lifting device for forward and reverse transmission		2.4
2.5.9	选片堆垛台 stacker of option board	1	台面尺寸: 1.2m×3.0m; 液压升降平台液压 站: ~3.0kw platform size: 1200 x 3000mm hydraulic station of lifting platform: ~3.0kw		1.5
2.5.10	切包边机 booker (edges cutter)	1	适合 1.8m-3.0m 板长的切包边功能。主锯 7.5kw×2 台 (FC) ; 预切锯: 1.5kw×2 台; 带 气动升降机构; 接板皮带: 0.75kw×2 台 (FC) 送板主传动链条: 5.5kw (FC) 带全套新型包 边机构; 减速机国茂 1. suitable 1.8m to 3.0m board. main saw: 7.5kw x 2 (FC); pre-cutting 1.5kw x 2; with pneumatic lifting structure 2. board feeding belt: 0.75 kw x 2 (FC) 3. main driving chain of discharging board: 5.5kw (FC), with whole set new type edge taping device 4. gear motor: GUOMAO		2
2.5.11	包边皮带机 wrapping belt conveyor	2	皮带机长度: ~1.35m, 1.5kw (FC); belt conveyer length: ~1350mm, 1.5kw (FC)	减速机国茂 gear motor: GUOMAO	4
2.5.12	储板皮带机 belt conveyor (board storage)	2	分 2 段皮带 1.65m+1.25m; 2.2kw×2 (FC) ; 带气动挡板; 其中 1 段皮带机带气动升降机构; 1. two section: 1650mm + 1250mm; 2.2kw x 2 (FC); 2. with pneumatic baffle; and 1 section with	减速机国茂 gear motor: GUOMAO	5



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			pneumatic lifting structure		
2.5.13	堆垛前皮带输送机 Belt conveyor before stacking	2	皮带机长度: ~1.37m, 4kw (FC), 带四组横向推板装置 (板垛对齐横向推板) Belt conveyor ~1.37m, 4kw (FC), with 4 group pushing devices (transverse)	减速机国茂 gear motor: GUOMAO	6
2.5.14	升降式链板输送机 chain scraper conveyor (lift type)	2	液压堆垛台面尺寸: 1.2m×3.0m; 最大负荷: 5t; 行程: 1.1m; 链板输送机: 3.0kw (FC) 1. platform of hydraulic stacker: 1200 x 3000mm; max. load: 5t; travel: 1100mm 2. chain scraper conveyor: 3.0kw (FC)	减速机国茂 gear motor: GUOMAO	12
2.5.15	定位对准装置 positioning and alignment device	2	包括可以调节的纵向气动对准装置及横向气动对准装置, 外形: ~5.2×3.1m; 允许码垛石膏板宽度: 1180~1220mm; 允许码垛石膏板长度: 2.0~3.0m; 码垛石膏板层高度: 1.1m; 纵向推板气缸: φ100-160, 2台, 纵向挡板电机: 0.75kw (变频) 国茂链条速度 20m/min 横向调整方式: 手动 1. pneumatic alignment device (horizontal and longitudinal): adjusted; dimension: ~5200 × 3100mm 2. available width: 1180~1220mm 3. available length: 2000~3000mm 4. available height: 1100mm 5. longitudinal cylinder for pushing boards: φ100-160, 2 pcs 6. longitudinal motor for blocking boards: 0.75kw (FC); GUOMAO 7. chain speed: 20/min 8. horizontal adjusting mode: manual		7
2.5.16	进板辊道 board feeding rollers	2	长度: ~4.5m; 1.5kw (FC) length: ~4.5m; 1.5kw(FC)	放置废旧石膏板或木托 put waste board or wooden pallet	3
2.5.17	板垛输出轨道 pallet discharging track	2	分2个独立机架; 长度: 4.5m×1; 3kw×1台; 2 separately frame work; length: 4500mm x 1; 3kw x 1	减速机国茂 gear motor: GUOMAO	4
2.5.18	缠绕包装机 Orbital packing system	1套 1 set	6件/h, <3500kg/件, 垫块输送机链条输送速度 10m/min, 变频调速。链板输送机 10m/min, 薄膜输送速度为 6-10m/min 电气控制采用 S7-1200 6pcs/h, <3500kg/pcs; conveyor of cushion	6面包装 6 sides packing 总功率~30KW Total ~30kw	55



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2.5.18	缠绕包装机 Orbital packing system	1套 1 set	6件/h, <3500kg/件, 垫块输送机链条输送速度 10m/min, 变频调速。链板输送机 10m/min, 薄膜输送速度为 6-10m/min 电气控制采用 S7-1200 6pcs/h, <3500kg/pcs; conveyor of cushion	6面包装 6 sides packing 总功率~30KW Total ~30kw	55

