



PROFORMA INVOICE

No.:KSB202305

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The Seller: GUANGZHOU KEBO MACHINERY CO., LTD

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The Buyer:

The Buyer agrees to buy and Seller agrees to sell hereinafter goods, Details see as below:

Coil Cutting Production line

Brand: Hengli

Model: BS3

Year of made: 2017

Technical Specifications

Material:	Tinplate, TFS and aluminum in tempers normally associated with standard can making materials
Sheet thickness range:	0.13-0.50mm
Sheet width range:	500-1100 mm
Sheet length range:	500-1100 mm
Max Tolerance:	±0.15 mm
Max Line speed:	50 meters per minute
Max Cutting strokes:	60 cuts per minute
Max. Coil Weight:	13.5 ton
Coil O.D. range:	915-1800 mm
Coil I. D. range:	400-520mm
Max Stacking Weight:	2100 kg
Max Stacking Height:	460 mm

Note: Machine speed may vary according to sheet length, material gauge and temper.

Scope of Supply

KOSOBO COMPANY LIMITED

Add. : Unit 4, 7/F Bright Way Tower No.33 Mong kok Rd HL HK

Tel:+852-28150191 Fax:+852-27779733



Automatic Hydraulic Uncoiler

The machine is cantilever type, mandrel of which expands/contracts through oil hydraulic system.

Payoff Direction : From above or from below

Mandrel: Three expansion arms, hydraulic tightening

Expansion Range: 400-440mm, with six arc plates of 40mm thickness which expand the range to 520mm.

Max coil O.D : $\Phi 1800$ mm

Max coil weight : 12T

Power consumption : 7.5 Kw (frequency control)

External dimension : 6520×1420×3400 mm

Approximate weight: 5200kg

Hydraulic loading cart

Hydraulic loading cart is composed of cart, stander, hydraulic system and elevating saddle, etc. The forth and back moving of the cart is controlled by hydraulic motor, and the saddle elevating is controlled by oil cylinder. All the actions are controlled through buttons on operation desk.

Type : Oil hydraulic system

Moving on rail : Drive : hydraulic motor drive

Speed : 3m/min

Coil loading : ≤ 12 T

Elevating stroke : 500mm

Max coil O.D (最大卷料外径): $\Phi 1800$ mm

Power consumption (电机功率): 2.2 Kw

External dimension (外形尺寸): 1060×1220×1090 mm

Approximate weight (大约重量): 1900kg

Feeder

Feeder is used for keeping the level of the strip same with flattener, then it send the head of the strip to flattener.

External dimension (外形尺寸): 1595×1256×1710mm

Approximate weight (大约重量): 800kg

Flattener

The machine is for removing coil curvature through repeated winding process for further downstream processing.

Machine structure (机器结构): The upper bank of rolls can be tilted at entrance or exit, with overshoot roll for fine adjustment.

Diameter of rolls (辊子直径): 55mm

Quantity of rolls (辊子数量): Upper bank: 8 rolls, plus 1 overshoot roll

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Lower bank: 10 rolls
Flattener Drive (校平机驱动): AC Variable Frequency Drive via 5.5KW
Motor
Lowering adjust (下压调整): Exit overshoot roll adjust singly. Lowering indicator on the operation side.
External dimension (外形尺寸): 2195×1593×1831 mm
Approximate weight (大约重量): 2000kg

Transition stander

The device is used for buffering and transiting the strip from flattener to scroll cutter. Pinhole detector will be placed on the stander.

External dimension (外形尺寸): 1490×2075×1737 mm
Approximate weight (大约重量): 1000kg

Shear with Servo Feeder

The shear is a mechanically underdriven unit capable of accepting pressing type tooling. The machine utilizes a driven lower roll via AC servo motor to produce a desired cut length.

Type of Shear (剪切形式): Four post type. Underdriven via clutch/brake capable of accepting both scroll or straight cut tooling(with extra seal).
Type of Feeding (送料形式): Intermittent feeding
Tooling (模具): Straight or Scroll
Cuts per minute (每分钟可剪次数): 60 strokes/min
Max cut thickness (最大剪切厚度): 0.13~0.50mm
Max cut width (最大剪切宽度): 1100mm
Shear Motor (剪切电机): 5.5 Kw frequency control
Feed Servo Motor (送料伺服电机): 7 Kw
External dimension (外形尺寸): 2950×1675×1778 mm
Approximate weight (大约重量): 4500 kg

Belt conveyor

This device is used for receiving sheets from Sheet discharger and conveying sheets to the stackers.

Belt (皮带): Endless belt
Power consumption (电机功率): 0.75 Kw × 2 units
External dimension (外形尺寸): 2635×1668×1400 mm
Approximate weight (大约重量): 1500 kg

Stacker – 2sets



The stacking system is to run in automatic mode, piling to a specific preset count, and transferring once the count is reached.

Sheet Transfer (片料转移): Automatic

Stack discharge direction (送出方向): Operator side 操作者方向:

Capacity (承载能力): ≤ 2.1 T

Power consumption (each stacker): 0.75Kw (air blower)+0.75Kw (upper)+
0.75Kw (lower)

External dimension (each stacker): 2800×1668×1400mm

Approximate Weight (each stacker): 1500kg

Hydraulic elevating platform – 1 sets

Hydraulic elevating platform is for collecting sheets. It will immediately decrease a certain distance once a preset number of sheets have been collected, until the stack is finished.

Elevator (升降机): Scissor mechanism with hydraulic cylinder

Elevator Rolls (升降机辘子): Driven by geared AC motor

Capacity (承载能力): ≤ 2.1 T

Power consumption (each platform): 1.5Kw (elevating)+ 0.75Kw (rollers)

External dimension (each platform): 1590×1070×400mm

Approximate Weight (each platform): 1000kg

Die handling cart

Die handling cart is for changing dies.

External dimension (外形尺寸): 1673×518×1335mm

Approximate weight (大约重量): 500kg

Electric control system

Operation desk dimension: 900×550×1300mm

Operation desk approximate weight: 250kg

Electrical cabinet dimension: 2700×600×2000mm

Electrical cabinet Approximate Weight: 400kg

Mitsubishi PLC

Mitsubishi frequency-conversion controller

Mitsubishi servo control system

Isolation transformer

Mitsubishi man-machine interface

Carbide Straight die – 1 set(used)



Line Environmental / Operating Requirements

Power supply:	AC 3 phase 5 wires (with neutral and earth)
Voltage:	380V±10%
Single phase Voltage:	220V±10%
frequency range:	49~50.5 Hz
Temperature:	below 40°C
Humidity:	Below 80%
Pneumatic supply:	consumption≥1 m ³ /min, pressure 0.6~0.8MPa

Brand name of the components

PLC:	Mitsubishi
Servo feeding motor:	Mitsubishi
Bearings at key parts:	SKF
Touch screen on Control Desk:	Mitsubishi
Low voltage electrical components:	Schneider