

■ ROJECT SITUATION

1. Main Material: PVC powder, caco3 and chemical additives
2. Extruder type: SJSZ80/156 conical twin screw extruder
3. Extruder Design Output capacity: The Max is **about 8-10 Ton/ Day (24 hour)**, Cooling water temperature: $\leq 12-15^{\circ}\text{C}$ Air pressure: $\geq 0.3\text{Mpa}$
4. Electric power supply: 3phase, voltage and frequency according to customer's request (3-phase, 380V, 50 Hz)
6. Production occupied area: about 35m*3m*4m (L*W*H) apply for one line connect with mixer (for your reference)

■ GENERAL


Power Supply	380V 3Phase 50HZ
Raw Material	PVC CACO3 and other additives
Extruder Design Capacity	About 300-400 kg/h
Cooling Water	$\leq 12-15^{\circ}\text{C}$
Operator	1-2 persons per shift

■ MACHINE LIST

1. Automatic Material loader	1SET
2. SJZ80/156 Conical double screw Extruder	1SET
3. Mould (Width 1220mm, Thickness 2-5 mm)	1SET
4. 3-Roller Calendar with Hot Stamping & Lamination	1SET
5. Temperature Controller	1SET
6. Cooling frame with trimming device	1SET
7. Two-roller haul-off unit	1SET
8. Cutter	1SET
9. Auto Mechanical Arm Stacker (Robot)	1SET

■ TECHNICAL PARAMETERS

1) Automatic feeding system

Power of feeding motor	2.2KW	
Screw Design	Screw Loader NOT SPRING	
Material	stainless steel	

2) SJSZ-80/156 Conical Twin Screw Extruder



<p>Main Motor</p>	<p>SIEMENS BEIDE 75kw</p>	
<p>Motor Cooling</p>	<p>Cooling Fan</p>	
<p>Frequency converting control</p>	<p>DELTA Inverter</p>	
<p>Gearbox & Distributor case</p>	<p>DELING</p>	
<p>Screw & barrel</p>	<p>DEMAJI</p>	



Screw diameter	80/156
Material	38CrMoALA
Nitride depth	0.4-0.7mm
Barrel Material	38CrMoALA
Nitride depth	0.4-0.7mm
Barrel Heating	Cast aluminum heating
Heating Zone	Four zones
Heating Power	27kw
Cooling method	Air fan cooling
Cooling Power	4×0.25kw
Vacuum pump System	1 set
Vacuum pump Power	3kw
Dosing feeding device	Double Screw Design
Feeding Power	1.5kw



Electrically Control Cabinet	
Temperature meter	OMRON
Contactora & Relay & Break	SIEMENS & CHINT & SCHNEIDER
Frequency Inverter	DELTA

Each zone of heating, cooling and temperature detecting has its own connection area in cabinet. Just need to connect the integrated plug to the socket of cabinet, the work is easy and convenient.

3) Mould



Type	T-Type
Mould Material	50CrMnTi
Mould cavity processing	hard chrome plating and polishing ,The inner surface of Die-head is coated with chrome and is polished
Die Orifice effective width	1350mm
Nose heating	electric heating panel
PVC sheet	Width 1220 ; Thickness 2-5 mm ; Length 2440 mm
Heating power	About 32kw

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4) Three-Roller Calendar with hot Stamping & Film Lamination Machine



Design of three roller	Vertical type , (PVC sheet input from bottom and output from top)
Size of the roller	Φ 400× 1350mm
Process of three roller	coated with chrome, roughness≤0.025μm
Transmission ways of 3-roller	with ganged transmission, horizontal type gear box ,1.5KW×3sets
Moving Reducer	1.1KW
Lifting Motor	0.75kw * 2
Put the film control	Control instrument
Expander roller	1 set
Roller temperature control (3 zones)	Temperature Controller 1 set
Roller	2 mirror rollers , 1 bottom embossing roller
Hot stamping unit	1set
Film unit online	with pneumatic core shaft: 2pcs ; correction system : 1 unit

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5) Temperature Controller



3-Roller Heating

15kw * 3 = 45kw

6) Cooling frame with trimming device



Length of cooling frame	8000mm
Cooling roller material	Stainless steel
Cooling roller length	1350mm
Both edge trimming cutter	2 sets of knife
Trimming width	1220mm
Trimming thickness	1-5 mm

7) Two-roller Haul-off unit



Roller of Haul-off

Material	Rubber
Qty	2
Diameter	φ200mm
Length	1350mm
Clamping method	Pneumatic
Route	60mm
Motor	1.1kw (Frequency Control)
Composite Base Material Unit	
Base Material Max Diameter	Φ500mm
Base material max width	1300mm

8) Cutter



Max cutter width	1300mm
Motor	5.5kw
Cutting Speed	synchronously with three roller calendar speed
Cutting thickness	2-6 mm

9) Auto Mechanical Arm Stacker (Robot)



Lifting Motor	0.75kw with Electromagnetic Brake
Conveyor Motor	0.75kw
Driving Motor	0.75
Control	PLC Control , Touch screen
Sensor system	Photoelectric switch

2. SHRL-500/1000 heat & cooling mixer machine with Automatic Feeding System

Automatic feeding system		
Power of feeding motor	2.2KW	
Material	stainless steel	



MAIN TECHNICAL PARAMETER

Technical data	Heating mixer	Cooling mixer
Total Volum (L)	500	1000
Valid volum (L)	375	650
Qty of Strirrer Blade	3	1
Blade Material	Stainless Steel	Stainless Steel
Pot Material	Stainless Steel	Stainless Steel
Motor power (Kw)	75KW	11KW
Blade speed (rpm)	430 / 860	60
Mixing time per batch (min.)	8~10	5-8
Material temperature (°C)	≤120	≤45

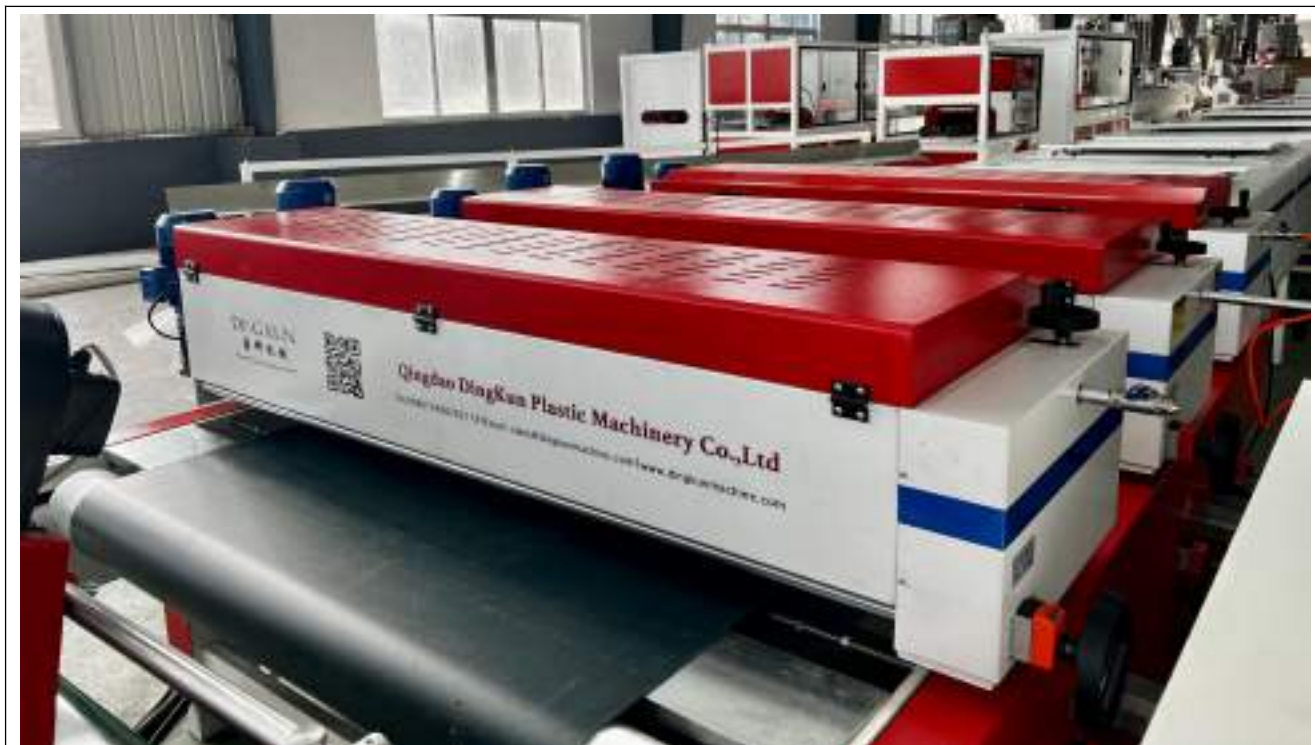
Heating/Cooling method	Self-friction / Electricity	Recycle Water Cooling
Discharging method	Pneumatic discharging	
Gas consumption (t/h)	5.8	
Max. Output (Kg/hr)	Max. Output: 700-800kg/hr	

3. SMF-500 Pulveriser Machine With Vibrating Screen

Model	SMF500
Motor Power	37 KW
Capacity (PVC)	200-300 kg/hr
Draft fan power	3kw
Cooling Type	Water Cooling
Powder size	60- 80 mesh
Vibrating Screen	1 set / ZDS-800
Motor power	1.1 kw
Blade Dia	500 mm



4. GT1300 UV Coating Line for PVC Sheet



1	Max. printing width	1300mm
2	Printing speed	2-10m/min
3	Electric heating power	24kw
4	UV curing power	9kw*3pcs=27kw
5	Transmission power	13.5kw

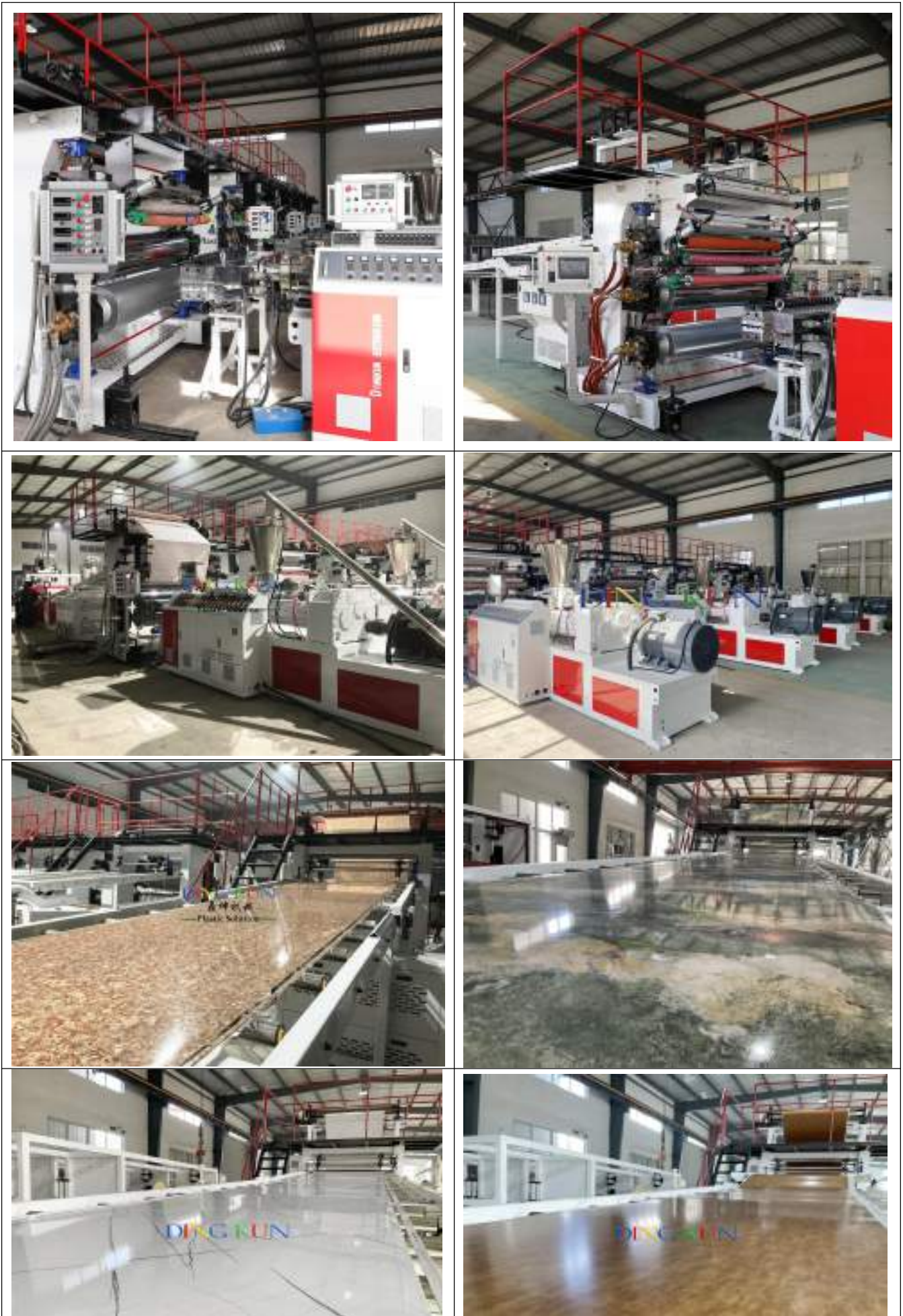
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6	Total power	69kw
7	Power supply	3phase,380V,50Hz
8	Visual sizes(L*W*H)	30400*2200*1600mm
9	UV lacquer consumption	if adopt 1st and 2nd rollers, coating UV lacquer 8~12g/m ² ; if adopt 2nd and 3rd rollers, coating UV lacquer 17-40g/m ² ; Normally 20kg/drum of UV lacquer can coat around 200pcs of sheets.

■ FREE SPARE PART LIST

NO.	SPARE PART	QTY	UNIT	APPLICATION
1	THERMOCOUPLE (4 METER)	2	PCS	EXTRUDER
2	HIGH TEMP PLUG	1	PC	EXTRUDER
3	HIGH TEMPERATURE WIRE	20	METERS	EXTRUDER
4	INTERMEDIATE RELAY	1	PC	EXTRUDER
5	CONTACTOR	1	PC	EXTRUDER
6	POTENTIOMETER	1	PC	EXTRUDER
7	AIR PIPE CONNECTOR	6	PCS	CALENDER
8	LIGHT PIPE	1	PC	CALENDER
9	BLADE	2	PCS	EDGE CUTTING UNIT
10	HEARTING ROD	1	PC	TEMPERATURE CONTROL
11	PROXIMITY SWITCH	1	PC	ROBOT
12	OPTOELECTRONIC SWITCH	1	PC	ROBOT
13	TRAVEL SWITCH	1	PC	ROBOT
14	CONVEYOR BELT	2	PC	ROBOT
15	TEE	1	PC	ROBOT
16	PU PIPE	10-20	METERS	
17	SOLENOID VALVE	1	PC	
18	TOOL BOX (SHORT INNER HEXAGON WRENCH 1 SET, ADJUSTABLE WRENCH, ALLEN WRENCH, CIRCUIT DIAGRAM...)	1	BOX	DINGKUN STANDARD

MORE PICTURES FOR REVIEW



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