

3	Three-layer	110-150m/min	4	Five-layer working	
5	Seven-layer	-----	6	Maximum order	
7	Slitting accuracy	±1mm	8	Cross cutting	
Remark	The above speed indicators must meet the production width is 1800mm, the following paper standards are met, and the surface temperature of the heated parts of the equipment is guaranteed to be 175°C				
	face paper	100g/m ² --180g/m ²	Ring pressure index (Nm/g) ≥ 8 (water content 8-10%)		
	Core paper index	80g/m ² --160g/m ²	Ring pressure index (Nm/g) ≥ 5.5 (moisture content		
	inside finger	90g/m ² --160g/m ²	Ring pressure index (Nm/g) ≥ 6 (moisture content		
9	Corrugated				
10	steam	Maximum pressure	Common pressure	Dosage 4000kg/Hr	
11	electricity	AC380V 50Hz 3PH	Installed capacity ≈	Common power ≈	
12	compressed air	Maximum pressure	Common pressure	Dosage 1m ³ /min	
13	take up space	≈Lmin80m*Wmin10m*Hmin5m (Actually subject to the audited drawings provided by Party B)			

Customer-supplied part:

- 1 Steam heating system. It is recommended to equip a 4000Kg/Hr steam boiler with a set of steam pipes with a pressure of 1.25Mpa
- 2 Air compressor, air storage tank, air pipeline, glue delivery pipeline
- 3 The power supply and wires are connected to the operation cabinet and the line pipeline bridge.
- 4 Water sources, water pipelines, sewage recycling facilities, etc.
- 5 Civil engineering of water, electricity and gas foundation plane installation.
- 6 Base paper, corn (potato) starch, industrial caustic soda, borax and other materials for test run.
- 7 Oil, lubricating oil, hydraulic oil and lubricating grease for equipment
- 8 Accommodation and local transportation costs for installation and commissioning personnel. And provide installation tools and workers to cooperate with the installation.

Corrugated machine project list and price

WJ180-1800-I type five layer corrugated paperboard production line

Offer valid for 60 days

Offer date June 20, 2022

Paper	MAX 1500mm	
-------	------------	--

diameter	MIN. <u>300mm</u>
Paper width	MAX: <u>1850mm</u> MIN: <u>800mm</u>
Weight capacity	<u>3T</u>
Paper head size	Teeth 3 inches 4 inches
brake	Spur gear type 4 points pneumatic
Working air pressure	0.4---0.8Mpa

B、 Main performance characteristics:

- ★ It adopts full hydraulic drive to complete the operations of base paper clamping, loosening, moving centering, left and right translation, etc. The base paper lift is hydraulically driven.
- ★ The brake adopts a multi-point braking system, a chainring structure, equipped with a cooling fan, AirTAC pneumatic components, stable tension and long life.
- ★ Large-diameter spindle design, swing arm slides smoothly, high-frequency treatment inlaid steel guide rail, super wear-resistant.
- ★ Hydraulic cylinder is installed by twisting shaft, which does not bear radial force and is easy to maintain.

C、 Hydraulic system parameters:


Working pressure	Lifting hydraulic cylinder	Clamping Cylinder	Hydraulic station motor power	Solenoid valve working voltage
16---18Mpa	∅ 100×440mm	∅ 63×1300mm	3.7KW --380V -- 50Hz	220V--50 Hz

D、 Mainly purchased parts,raw materials and origin:

Serial number	Name of main parts	Brands or place of origin	Remarks
01	Main shaft	Day steel production	∅ 242mm
02	Swing arm	Production by own	Resin sand gray ironHT250
03	Wallboard	Jigang production	Q235AWelding parts
04	Bearing	C&U	
05	Main electrical appliance	SIEMENS	Contactora, relay, button
06	Hydraulic station	Shandong zaozhuang	Taiwan oil pump solenoid valve

1、 paper trolley、 track

A. Technical parameters:

Track length	6000mm	
Paper loading method	Manual	
Main frame	14 channel steel and \varnothing 20mm cold drawn round steel	

B. Structural feature:

- The track is buried as a whole, the main frame is welded with No. 14 channel steel and \varnothing 20mm cold drawn round steel, and the length of the ground rail is 6000mm.
- Each paper holder is equipped with two paper feeding trolleys, which can load paper from both sides at the same time. Push the roll paper into place.

C. Mainly purchased parts, raw materials and origin:

Serial number	Name of main parts	Brands or place of origin	Remarks
01	Track and paper trolley	TangShang or JiNan	NO14 channel steel. Q235A. steel strip
02	Bearing	C&U	

3.R09B Top paper preheat**A, technical parameters:**

Working width	1800mm	
Hot roll diameter	\varnothing 900mm	
Angle adjustment range	0-270 rotation	
Angular axis diameter	\varnothing 110mm \times 2	

Maximum steam temperature	200		
Maximum steam pressure	1.2Mpa		
working power supply	380V	50Hz	3PH
power of motor	250W short-term (S2) working system		
Equipment size			
Single machine weight			

B. Main performance characteristics:

- Used to preheat single-sided corrugated paper and face paper, increase the temperature, facilitate bonding, control moisture and smooth cardboard.
- The surface of each roller is finely ground and plated with hard chromium, so the surface friction is small and durable.
- Electric adjustment of wrapping angle: The wrapping angle can be rotated in the range of 0-270 to adjust the heating area of paper.
- Preheating roller adopts flat head design, which conforms to the national standard of Class I pressure vessel, and is attached with the certificate of pressure vessel.

C. Brand and origin of main components

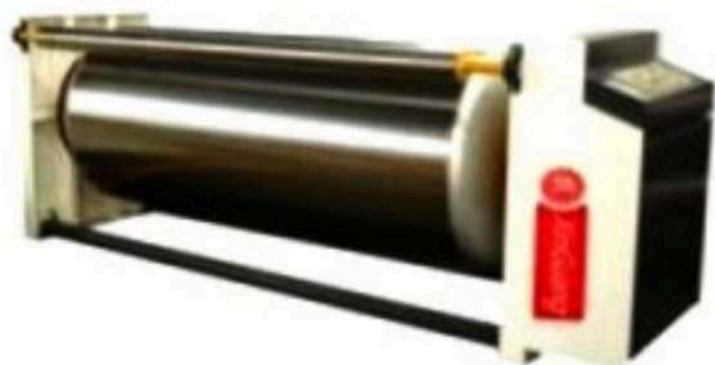
serial number	Master name	Brand origin	remarks
01	frame	Tanggung profile	Stress relief treatment of welded parts
02	Steam joint	Fujian Quanzhou Yujie	
03	Preheating cylinder	Hangang or Jigang	Q235B pressure vessel

			plates
04	rolling bearing units	FGJ	
05	RV gear reducer	Taiwan Chengbang or Wanxin	RV75
06	Main electrical appliances	SIEMENS	Contactora, relay, button
07	steam trap	Beijing hydrophobic valve factory	Floating ball type
08			

4.RG06B Core paper preheat

A, technical parameters:

Working width	1800MM
Hot roll diameter	φ 600mm
Angle adjustment range	0-270 rotation
Angular axis diameter	φ 85mm×2
Maximum steam temperature	200
Maximum steam pressure	1.2Mpa
working power supply	380V 50Hz 3PH
power of motor	250W short-term (S2) working system
Equipment size	
Single machine weight	



B, Main performance characteristics:

- Used to preheat single-sided corrugated paper and face paper, increase the temperature.

facilitate bonding, control moisture and smooth cardboard.

- The surface of each roller is finely ground and plated with hard chromium, so the surface friction is small and durable.
- Electric adjustment of wrapping angle. The wrapping angle can be rotated in the range of 0-270 to adjust the heating area of paper.
- Preheating roller adopts flat head design, which conforms to the national standard of Class I pressure vessel, and is attached with the certificate of pressure vessel.

C. Brand and origin of main components

serial number	Master name	Brand origin	remarks
01	frame	Tanggung profile	Stress relief treatment of welded parts
02	Steam joint	Fujian Quanzhou Yujie	
03	Preheating cylinder	Hangang or Jigang	Q235B pressure vessel plates
04	rolling bearing units	FGJ	
05	RV gear reducer	Taiwan Chengbang or Wanxin	RV75
06	Main electrical appliances	SIEMENS	Contactora, relay, button
07	steam trap	Beijing hydrophobic valve factory	Floating ball type
08			

5.RG-3-900 triple preheater

A, technical parameters:

Working width	1800mm
Hot roll diameter	∅ 900mm
Angle adjustment range	0-270 rotation
Angular axis diameter	∅ 110mm×2

Maximum steam temperature	200	
Maximum steam pressure	1.2Mpa	
working power supply	380V 50Hz 3PH	
power of motor	250W short-term (S2) working system	
Equipment size		
Single machine weight		

B. Main performance characteristics:

- ★ Used to preheat single-sided corrugated paper and face paper, increase the temperature, facilitate bonding, control moisture and smooth cardboard.
- ★ The surface of each roller is finely ground and plated with hard chromium, so the surface friction is small and durable.
- ★ Electric adjustment of wrapping angle. The wrapping angle can be rotated in the range of 0-270 to adjust the heating area of paper.
- ★ Preheating roller adopts flat head design, which conforms to the national standard of Class I pressure vessel, and is attached with the certificate of pressure vessel.

C. Brand and origin of main components

serial number	Master name	Brand origin	remarks
01	frame	Tanggung profile	Stress relief treatment of welded parts
02	Steam joint	Fujian Quanzhou Yujie	
03	Preheating cylinder	Hangang or Jigang	Q235B pressure vessel plates
04	rolling bearing units	FGJ	
05	RV gear reducer	Taiwan Chengbang or Wanxin	RV75
06	Main electrical appliances	SIEMENS	Contactors, relay, button

07	steam trap	Beijing hydrophobic valve factory	Floating ball type
08			

6. SF-18 Singer facer

A, technical parameters:

Working width	1800mm	
design speed	180m/min	
economic speed	100-150m/min	
Paper feed range	1850--850mm	
Maximum steam temperature	200	
Maximum steam pressure	1.2Mpa	
working power supply	380V 50Hz 40KW	

B. Main performance characteristics:

- ★ Adopt hood suction structure, equipped with high-pressure powerful fan. Maintenance-free, wide range of core paper
- ★ High-quality resin sand high-strength casting, good shock absorption effect, heavy-duty structure, nodular casting with corrugated roller and pressure roller sleeve, high strength and long service life.
- ★ The transmission unit is driven by synchronous belt, which has no oil pollution and is easy to maintain. The main power is driven by variable frequency motor, which is energy-saving, efficient and low in failure rate.
- ★ The coating roller unit adopts the overall outward-moving structure, which can be moved out of

the machine for maintenance, thus improving the work efficiency.

- ★ Equipped with spray humidity control device, the core paper can keep good deformation stability and avoid cracking.
- ★ Adopt automatic circulating glue supply system and double-cylinder pneumatic gluing device, which has good buffering effect. Electric adjustment of gap between coating roller and corrugated roller.
- ★ The coating roller is treated by hard chrome plating with pit reticulate. Uniform cots adopt copper scraper, and the glue quantity is controlled automatically or manually.
- ★ The corrugated roller is made of 50CrMo alloy steel, the diameter of the main corrugated roller is 346mm, and it is treated with tungsten carbide or hard chromium plating.
- ★ Glue width is adjusted electrically to adapt to the change of the width of the used base paper.
- ★ Power and operating parts are equipped with safety nets to ensure the safety of personnel when the machine is running.
- ★ The simple operation control system, touch screen operation interface, and the display of operation status, function selection, fault indication, troubleshooting and parameter setting with color drawings can show that the machine is fully functional, easy to operate and humanized.

C, main component parameters:

Component name	specifications	material	surface treatment
Corrugated roller	Main roller \varnothing 346mm	50CrMAo alloy steel	Treating tungsten carbide
pressure roller	\varnothing 370mm	45 #	Round grinding, chromium plating and polishing
glue roller	\varnothing 240mm	45 #	Round grinding pit reticulate chromium plating
Doctor gluing roller	\varnothing 142 mm	45 #	Round grinding and chrome polishing
Preheater roller	\varnothing 400mm	Q235B	Round grinding and chrome polishing
Paper guide	\varnothing 110 mm	45 #	Round grinding and chrome polishing

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roller			
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D. Main dynamic parameters:

name	power	voltage	frequency
main frequency motor	22KW	380V	50HZ
High-voltage suction motor	11KW	380V	50HZ
Rubber adjusting speed reducer	100W	380V	50HZ
Glue adjusting motor	200W*2	380V	50HZ
Rubber pump motor	2 2KW	380V	50HZ

E. Main component brands and places of origin:

serial number	Master name	brand name	remarks
01	frame	Self-produced	HT250
02	Rotary joint and metal hose	Fujian Quanzhou Yujie	
03	Main drive motor	hebeihengshui city	22KW variable frequency motor
04	RV gear reducer	Taiwan Chengbang or Wanxin	
05	bearing	C&U	
06	rolling bearing units	FGJ	
07	high pressure positive blower	Shanghai Yingfa	11KW
08	Pneumatic components	Taiwan AirTac	
09	solenoid valve	Taiwan AirTac	
10	low-voltage apparatus	Germany SIEMENS	Contactora, relay, button
11	PLC	Taiwan Delta or Huichuan	
12	touch screen	Taiwan Weilun or MCGS	

7. TQ15-2 Conveyor bridge**A. Technical parameters:**



			connected
02	Guardrail	Tiangang	Φ42mm Low pressure fluid pipe
03	Paper lifting belt	Shanghai	PVC conveyor belt
04	Cardboard conveyor belt	Hebei	Parallel transport rubber band
05	Adsorption frequency conversion fan	ShangHai Yingfa	
06	Frequency converter	TaiWan Delta	
07	Bearing	C&U	
08	Seat belt bearing	ZheJiang	
09	Paper width adjustment reducer	Shangdong jinbuhuan reducer	
10	Paper motor (frequency)	Hebei hengshui	
11	Conveying roller and paper roller, over paper roller	Tiangang Seamless steel pipe	
12	Low-voltage electrical appliances	SIEMENS	Contactora, relay, button
13			

8.GM-20 Double glue machine

A、Technical parameters:

Working width	1800mm
Design speed	200m/min
Economic speed	80-180m/min
Glue volume adjustment range	0.08-0.6mm
Number of anilox roller	32 线
Preheating cylinder temperature range	150—200
Working power	380V 50Hz 7KW
Air source system	0.4—0.9Mpa
Pressing method	Pneumatic



B、Structural feature:

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- The glue applicator is the corrugated paper conveyed by the flyover. After preheating and heating up, it is coated with glue again, and then it enters the double facer machine for gelatinization and lamination to produce three-layer cardboard.
- The frame is made of cast iron, with stable performance. The diameter of the preheater is 400mm, and the temperature of the paper is increased to facilitate the gelatinization of the glue. The double pressure rollers are designed to apply the glue evenly.
- The surface of the coating roller is quenched and tempered, the inner hole is processed, and the surface is finely ground for dynamic balance and engraved with pit pattern. Large-diameter glue roller dynamic balance treatment, copper plate scraping glue, glue uniform, save glue, save steam, flat cardboard
- The drive of the gluing unit is directly connected by the frequency conversion motor through the reducer, and the frequency conversion control ensures that the linear speed of the gluing roller is synchronized with the Double facer, and can operate independently. Adopt angle sensor, PLC, touch screen man-machine interface display. According to different paper quality and different speed, the glue amount is automatically controlled, and the roller gap is automatically adjusted according to different corrugation types, without accumulating errors.

C. Main component parameters:

Part name	Specification	Surface treatment
Craftsmanship		
Glue roller	∅ 268mm	Round grinding and pressing pit mesh chrome plating
Doctor glue roller	∅ 146mm	Round grinding chrome
Pressure roller	∅ 150mm	Round grinding chrome
Paper passing roller	∅ 110mm	Round grinding chrome
Preheating roller	∅ 400mm	Round grinding chrome

D. Main dynamic parameters:

Name	Power	Voltage	Frequency
Rubber roller active motor	3KW	380V	50HZ
Glue adjustment speed reducer	200W	380V	50HZ
Roller gap adjustment	200W	380V	50HZ

motor			
Rubber pump motor	2.2KW	380V	50HZ

E. Main parts brand and origin:

Serial number	Name of main parts	Brands or place of origin	Remarks
01	Glue roller and doctor glue roller	Tiangang	45# steel
02	Preheat roller	Tiangang or Jigang	Q235B Container board
03	Bearing	C&U	
04	Bearing with seat	ZheJiang	
05	Pneumatic Components	AirTac	
06	Low-voltage electrical appliances	SIEMENS	Contact. relay. button
07	Glue reducer	Taiwan city-state or Wanxin	
08	Main reducer	Taiwan city-state or Wanxin	
09	Touch screen	Taiwan Vinylon or MCGS	7.5 inch
10	PLC and inverter	Delta	
11	Timing belt	Germany OPTIBELT	
12	Trap	Armstrong. United States	Float

9. SM-F Double facer

A. technical parameters:

Working width	1800mm	
design speed	150m/min	
economic speed	80-150m/min	
Hot plate number	600mm×14 pieces	
Cooling section	4 meters	
Temperature requirement	160—200	
vapor pressure	0.8-1.3Mpa	
Gas source	0.5—0.6Mpa	

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pressure			
Pneumatic SHOES	8 Group		
working power supply	380V	50Hz	45KW
Equipment size			
weight			

B. Main performance characteristics:

- ★ Double facer is to glue the single-sided corrugated paper and the facial paper, heat the plate, gelatinize the glue, and finalize the design to produce flat cardboard.
- ★ The surface of the heating plate is ground, the width of the heating plate is 600mm, there are 14 heating plates in total, and the length of cooling and shaping is 4m. The inside of the hot plate is a clapboard isolation structure, which makes the steam flow in an S-shaped direction, and the steam-water separation function is obvious, thus improving the steam utilization rate. The heating plate is made of container plate, which conforms to the national first-class pressure vessel standard, and is attached with pressure vessel certificate and inspection certificate.
- ★ Hot plate adopts pneumatic platen structure. The lifting plate adopts pneumatic structure. Eight sets of spring pneumatic pressure plates are standard.
- ★ The heat-conducting piping of the heating plate is divided into several sections to control the temperature, with temperature display.
- ★ The upper cotton belt is automatically corrected and centered by the pneumatic valve, and the S-shaped cotton belt tensioning device is controlled by double cylinders. The tight amount is large.
- ★ The lower belt adopts pneumatic tensioning mechanism, which is simple and practical in structure. The lower conveyor belt can be automatically corrected and centered left and right, and can also be manually adjusted on both sides.
- ★ The surface of the driving roller is coated with wear-resistant adhesive, which is herringbone structure and has a medium height to ensure the flat output of cardboard.
- ★ The gear of the driving part is made of cast steel ZG-500, and the gear is lubricated by oil.
- ★ The electrical components are made of internationally renowned brands, and the devices work stably and operate reliably.
- ★ The main driving motor is frequency conversion motor, with large torque at low speed, wide

speed regulation range, energy saving and high efficiency.

- ★ The main skeleton is made of high-strength national standard profile, with firm structure and beautiful appearance, which is suitable for working at high speed.

C. Main component parameters:

Part Name	Specification	surface treatment
Roller		
Upper drive rubber roller	φ 700mm	Covered with wear-resistant rubber
Lower drive rubber roller	φ 400mm	Covered with wear-resistant rubber
Front and rear driven belt rollers	φ 215mm	round chrome polished
pinch roller	φ 85mm	round chrome polished
Forming idler	φ 86mm	round chrome polished
Upper belt tension roller	φ 155mm	round chrome polished
Upper belt deflection roller	φ 124mm	round chrome polished
Up and down belt press shaft	φ 130mm	round chrome polished

D. Main dynamic parameters:

name	power	Voltage	frequency
main drive motor	45KW	380V	50Hz

E. Brand and origin of main components:

serial number	main item name	brand or origin	Remark
01	main skeleton	Tiangang or Laigang	36 gauge channel steel and 16 gauge I-beam
02	drive wall panel	Handan, Hebei	Q345
03	heating plate	Tiangang or Jinan Steel	Q235B container board production
04	main drive motor	Hengshui, Hebei	45 KW variable

			frequency motor
05	cotton webbing	Shenyang	Cotton webbing thickness 9 mm
06	Trap	Beijing	float
07	Low voltage electrical appliances	SIEMENS	Contactors, Relays, Buttons
08	Pneumatic Components	AirTAC or Sono	
09	Inverter	Taiwan Delta or Huichuan	
11	bearing	C & U	
12	Pillow block bearing	Fujian Nanan FGJ	

10.FY-C NC slitter scorer

A, technical parameters:

Working width	1800mm	
design speed	200m/min	
economic speed	80-120m/min	
Mechanical configuration	5 knives, 8 lines and 15 seconds to change orders	
Minimum paper cutting width	160mm	
Minimum indentation distance	70mm	
Positioning accuracy of cutter wheel	±0.5mm	
The whole machine moves sideways.	±100mm	
Equipment size		
weight		

B. Main performance characteristics:

★ Synchronous servo motor controls the arrangement of knives and cables. Automatic reset. Precise size. Change order time 15 seconds. The two machines can be used together to change orders immediately without slowing down.

- Schneider PLC control system, adopts CANopen bus system, has the function of order management, and is equipped with a signal input interface for synchronizing with the dryer speed
- The human-machine interface adopts a 10.4-inch color touch screen, which stores 999 groups of orders, realizes automatic order change or manual order change, and automatic alarm for faults
- Two kinds of pressure line forms: convex to concave, convex to flat, the two pressure line forms can be automatically converted. The depth of the crimping wheel can be automatically controlled by the computer, and the line shape is good and easy to bend
- Using thin tungsten steel alloy knife, the blade is sharp and the service life is more than 8 million long meters. The sharpening is computer-controlled, automatic sharpening or manual sharpening, which can be sharpened while cutting, improving production efficiency
- It is driven by imported synchronous belt, and the thin knife seat and the line pressing seat are supported by linear bearings, so the positioning size is accurate, and there is no accumulated error.
- Slitting and crimping are driven by independent frequency conversion motor. The waste suction port is automatically positioned with the replacement order
- With gas storage tank and low pressure protection function

C. Main dynamic parameters:

name	power	voltage	frequency
The slitter and creaser servo motor	1.05KW	380V	50HZ
slitter frequency motor	5.5KW	380V	50HZ
Creaser frequency motor	7.5KW	380V	50HZ
Waste suction frequency motor	0.55KW	380v	50HZ

D. Brand and origin of main components:

serial number	Master name	Or brand origin	remarks
01	frame	Shandong Jigang	Q345
02	Guide rail	Tiangang	Q345
03	PLC programming controller	Schneider, France	CANopen bus system

Internet site: www.hh-xg.com

服务热线: 0317-7751118

04	HMI	Kinco, Germany	0.4 inches
05	Servo control of slitter	Kinco, Germany	1.05KW
06	Creaser servo control	Kinco, Germany	1.05KW
07	Proximity switch, photoelectric switch	Omron, Japan	
08	relay	Schneider, France	
09	Main frequency motor	Hebei Hengshui electric machine factory	5.5KW×2
10	Left and right traverse motor	Shandong jinzhan speed reducer	
11	Exhaust air inlet motor	Zhejiang produce	0.55kw
12	Electromagnetic valve, cylinder	Taiwan Air Tac	
13	bearing	HRB or C&U	
14	rolling bearing units	Zhejiang Wuhuan	
15	Tungsten blade	Sichuan boyan	∅ 260mm
16	Linear guide	Taiwan of China	Shangyin

11.NC-150 NC cutter

A. Technical parameters:

Working width	1800mm
Design speed	150m/min
Economic speed	80-130m/min
Min. cutting length	500mm
Max. cutting length	9999mm
Cutting accuracy	精度为±1mm.
Working power	380V 50Hz 25KW



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B. Structural feature:

- It can store 200 sets of orders, change the paper cutting specifications quickly and accurately, change orders without stopping, and can realize computer networking, which is convenient for production management.
- The drive gear of the cutter shaft adopts high-frequency quenching of precision forged steel material to realize backlash-free transmission. It adopts advanced keyless connection method and has high transmission precision.
- The blade of the cross-cutting machine adopts the structure of inlaid steel spiral knife with serrated knife type. Scissor-type shearing, low shearing force and long blade life.
- The front and rear paper feeding rollers adopt the method of pressing paper by the sun wheel, the conveying is smooth, the pressure is even, and it is not easy to crush the board or cause blockage.
- This model is energy storage type braking (non-energy consumption braking), low energy consumption in the production process, the average power consumption is 1/3 of the ordinary NC cutting machine, saving more than 70% of electricity, to achieve the goal of saving money.
- Precisely adjustable backlash-free gears to ensure precise meshing of the blade and balanced operation.
- Using oil bed type lubrication to distribute oil in each gear position for oil supply, lubrication and cooling.
- Knife roller: Made of high quality precision forged steel, after balance treatment, it has good stability.

C. Main dynamic parameters:

Part name	Specification	Surface treatment	Special treatment
Craftsmanship			
upper and lower knife roller	∅ 216mm	Conditioning	Dynamic balance
Front lower conveying roller	∅ 156mm	Round grinding chrome plating polishing	Dynamic balance
Rear lower conveyor roller	∅ 156mm	Round grinding chrome plating polishing	Dynamic balance
Paper passing shaft	∅ 160mm	Wrapped silicone	Dynamic balance
Output sun gear	∅ 160mm	Polyurethane	Intensive

D. Main dynamic parameters:

Name	Power	Voltage	Frequency
Main drive servo motor	18.5KW	380V	50HZ

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Front feed motor	1.5KW · Frequency adjustment speed	380V	50HZ
Rear feed motor	1.5KW · Frequency adjustment speed	380V	50HZ

E. Main parts brand and origin:

Serial number	Name of main parts	Brands or place of origin	Remarks
01	Box rack	Self-produced	HT250
02	Knife roll	Tiangang Precision Forging	42CrMo
03	Full AC servo motor	Shanghai Futian	18.5KW
04	Paper frequency conversion motor	HeBei YongShun	
05	Flying shear servo control system	Kobe, Germany	
06	Motion control board	Germany MKS-CT150	
07	Rotary encoder	Germany SIKI	
08	Timing belt	Obi, Germany OPTIBELT	
09	Tightening sleeve	XianYang ChaoYue	
10	Bearing with seat	ZheJiang	
11	Low-voltage electrical appliances	SIEMENS	Contactors, relay, button
12	Proximity switch	Omron Japan OMRON	
13	Frequency converter	Delat	
14	HMI	MCGS	
15	Sun gear	ShenZhen	

12.DM-LM automatic small gantry stacker

A, technical parameters:

Working width	1800mm	
design speed	150m/min	
economic speed	100-150m/min	
Maximum stacking length	3500mm	
Maximum	250mm	

stacking height			
working power	380V	50Hz	17KW
supply			
Equipment size			
weight			

B. Main performance characteristics:

- Servo-driven platform up and down, four-stage asynchronous servo conveying, automatic port stacking and discharging, imported high-strength belt output, and standard conveying frame on the paper side.
- Gantry type stacking. The order change time is 5 seconds, and it can be automatically counted, automatically crossed out, and automatically changed.
- Synchronized with the production management system, order management, centralized management, and automatic order change without slowing down.
- The waste of changing the order of production pipe is less than 700mm.
- Crawler-type stacking platform, AC servo control lifting, stable and neat stacking.
- When the stacking reaches the set number, the frequency conversion control will automatically and smoothly discharge the paper horizontally.
- The positioning of the tailgate is controlled by AC servo control, which can be adjusted automatically, quickly and accurately when changing orders.
- The rear baffle can be automatically shifted, suitable for stacking small orders.
- The conveying side is equipped with electric conveying frame as standard, and double-station trolley (optional).
- Independent sealed control cabinet, electrical equipment operates in a dust-free environment.
- Color touch screen display, convenient for on-site operation.
- Fully automatic operation control, improve efficiency, save manpower and reduce the labor intensity of operators.

C. Main dynamic parameters:

name	power	voltage	frequency
Main conveying motor	2.2KW	380V	50HZ
Suction motor	3KW	380V	50HZ
Transverse conveying	1.5KW	380V	50HZ

motor			
Rear baffle motor	1.1KW	380V	50HZ
Gantry motor	3.7KW	380V	50HZ

D. Brand and origin of main components:

serial number	Master name	Or brand origin	remarks
01	frame	Tiangang	Main channel steel No. 16
02	PU belt	Shanghai	
03	transducer	Taiwan Daida	
04	Transverse reducer	Shandong jinzhan speed reducer	
05	Proximity switch	OMRON, Japan	
06	PLC	Taiwan taida	
07	man-machine interface	MCGS	
08	rotary encoder	Wuxi ruipu	
09	contactor	Schneider, France	
10	Pneumatic components	Taiwan AirTac	
11	roll shaft	Seamless steel tube	
12	actuating motor	Shanghai	2.2kw
13	reducer	Wanxin	

13.ZJZ glue station system

A. Technical parameters:

Manual production	glue	0.8T	
Glue making method	Two-step method		
Main stirring	Horizontal stirring		
Carrier agitation	Vertical stirring		
Storage tank storage	1T		

Working power	380V 50Hz 10KW
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B. Main performance characteristics:

- Provide starch adhesive for single-sided corrugator, gluing machine and other glue equipment. Piped through the glue pump. The glue making device is composed of a carrier tank, a main body tank, a storage tank, and a glue feeding pump and a glue returning pump.
- Horizontal glue making machine can prepare main glue and carrier glue at the same time, and mix and stir, making large amount of glue. The glue in the storage barrels of the glue making room is transported by the glue pump to the storage barrels of each glue-using equipment to provide glue for the equipment.
- The glue making system adopts circulating glue supply, the remaining glue flows into the glue return square barrel, and the liquid level float is automatically controlled.

C. Main component parameters:

Part Name parameter	Specification	Material	power	special requirements
Horizontal main body glue mixer	1250mm×1000mm×900 mm	Q345	4KW	Hebei Hengshui
Carrier glue mixer	∅ 800mm×900mm	Q345	1.5KW	Hebei Hengshui
Single facer machine, gluing machine bucket	∅ 800mm×1000mm	Q345		
storage bucket	∅ 1200mm×1200mm	Q345	1.5KW	Hebei Hengshui
Glue pump motor	DN40	cast iron	2.2KW	Hebei Hengshui
Low voltage electrical appliances	Siemens SIEMENS			Contactors, Relays, Buttons

14. Steam system

A. Technical parameters:

1	steam consumption	About 1.2T/h
2	Equipped with heat source	2t/h
3	steam pressure	1.25Mpa

4	Maximum temperature in the pipe	170—200
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B. the main performance characteristics.

- Transfer heating energy for each heating equipment in the production line to keep the working temperature stable.
- Each unit is designed as an independent small unit steam supply system, which saves energy and is easy to adjust.
- Each group of drainage units is equipped with an emptying bypass and the equipment cools down quickly when production is stopped.
- Floating ball trap, self-contained emptying device, stainless steel check valve to prevent leakage.
- The flexible connection between the piping system and the rotary heating components is realized by metal hoses, so as to prolong the service life of the rotary joint.
- All steam pipes in the machine are made of seamless steel pipes to ensure the safety of use under normal pressure.



C. Brand and origin of main components.

serial number	name	brand or origin	Remark
01	Rotary joint, metal hose	Quanzhou Yuje	
02	Trap	Beijing	float
03	Globe valve, ball valve	China Yuanda	
04	check valve	Zhengzhou Yuming	
05			

Note: The pictures provided in this document are for reference only. Party B reserves the right to change the appearance without changing the technical performance.