

70Extrusion production line with the specifications

Number	name and model	Qty. (set)	unit price	total price	note
1	1600 pay-off (1600被动是放线架)	1	4,840.00	4,840.00	
2	1.5M Vertical dance round (1.5米涨力缓冲架)	1	1,330.00	1,330.00	
3	30 color extruder (30立式注条机)	1	4,660.00	4,660.00	
4	70 extruder (70挤出机)	1	13,500.00	13,500.00	2Screw
5	Drying hopper + suction machine (干燥料斗+吸料机)	1	1,500.00	1,500.00	
6	U7 crosshead (U7免对机头)	1	12,500.00	12,500.00	
7	1.8 meters activity sink (1.8米活动水槽)	1	1,830.00	1,830.00	
8	Diameter of the detector (外径测试仪器)	1	2,500.00	2,500.00	
9	10M cooling water tank (10M单层冷却水槽)	1	4,830.00	4,830.00	
10	500double wheel capstan (500双轮引取机)	1	4,830.00	4,830.00	
11	Spark tester (火花实验机)	1	1,620.00	1,620.00	
12	2000Take-up (2000收线机)	1	9,200.00	9,200.00	
13	Electrical control cabinet (电器控制箱)	1	10,500.00	10,500.00	
FOB SHANGHAI IN USD			73,640.00		

Application: suitable for wire and cable insulation extrusion.

1. **The main accessories brand:**

- 1) motor: Siemens ac motor;
- 2) temperature control table: Japan RKC ;
- 3) Bearing the brand: SKF, NSK.
- 4) Machine color: navy;
- 5) Production line direction: according to customer's production

2. **The main specifications and performance:**

- 1) using conductor: twisted structure or single conductor;

- 2) complete outer diameter: 1.0 mm - 7.0 mm ;
- 3) extrusion materials: PVC, PE, XLPE;
- 4) 70 extruder extrusion quantity: 140 kg/h. (open the nose, soft PVC).
- 5) line speed: Max200 m/min.
- 6) machinery center height: 1000 mm.

3. Component technical specifications:

1. 1600 pay-off

- 1) The use of the spool size: Φ 1200- Φ 1600 mm;
- 2) Tension: 5KG magnetic powder clutch;
- 3) Lifting: electric lift;
- 4) The electric clamp clamping;
- 5) linear speed: MAX200M/min
- 6) to adapt to the wire diameter: 1.0 mm - Φ 7.0 mm;

2. Vertical dance round

- 1) form: set 2 meters;
- 2) roller diameter: 250 mm; Round number: 4 + 5 pills;
- 3) to adapt to the wire diameter: Max 7mm;
- 4) carrier material: aluminum;
- 5) Tension: mechanical spring buffer buffer.

3. 30color extruder:

- 1) power: 2.2kW AC motor;
- 2) screw: 38CrMoA1A, diameter of 30mm, length diameter ratio of 18:1;
- 3) Screw cylinder: 38CrMoA1A;
- 4) screw speed: 10-50r/min;
- 5) the use of electric voltage 220V, screw barrel 2 sections, each section of cast aluminum heater for heating, heating power 1.3kW; mouth 1 section, stainless steel heater, power 100W;
- 6) cooling: axial flow fan 2 units, each power 20W, neck natural cooling;
- 7) lifting: manual lifting, the effective distance of 100mm, to adapt to the center for high 1000mm extruder;
- 8) total power: $2.2+2*1.3+0.02*2+0.1 = 4.94kW$;

4. 70 extruder

- 1) motor: 30kw ac motor;
- 2) reduction gear box, gear grinding gear (copy) Italian type ZLYJ200 - II, extruder dedicated reduction gear box;
- 3) the screw: 38 crmoala, phi 70 mm, length to diameter ratio 25:1, cooled temperature constant;
- 4) screw tubes: 38 crmoala;
- 5) the screw rotation speed: 10-110 rmin;
- 6) the glue quantity: 140 kg/h (open the nose, soft PVC);
- 7) electric heating: use voltage 220 v, screw tubes 5 segments, cast aluminum heater heating, each period of heating power 4.5 kW. Machine with 1, stainless steel heating bar heating, heating power 110 w 9 *;
- 8) machine clip form: 2 chip machine clip;
- 9) cooling method: screw cylinder cooling high-pressure centrifugal fan 5, fan power 370 w. Natural cooling machine.

5. Drying hopper + suction machine:

- 1) charge: 100 kg;
- 2) dry heating: 2.8 kW;
- 3) fan: 90 w;
- 4) regular automatic shutdown 0 ~ 99 hours;
- 5) provide clearance drying way to achieve energy saving;
- 6) in the VAT and all parts inside adopt the stainless steel material;
- 7) transmission capacity: 300 kg/h.
- 8) transporting pipe inner: 38 mm;
- 9) stainless steel hopper;
- 10) with air filter;
- 11) assembly magic eye detection, installed directly with the injection machine into the mouth.

6. U7 crosshead:

- 1) type: U7 from double color head;
- 2) to form: double note, single note, double, single color;
- 3) applicable wire diameter: 1 - \varnothing 7 mm;
- 4) electric heating: 2 points temperature measuring, natural cooling;

7. 1.8 meters activity sink:

- 1) material: stainless steel;
- 2) water tank cover plate material: 2 mm stainless steel;
- 3) slot length: 1.8 m lash type;
- 4) flip compressed air blow dry

8. Diameter of the detector

- 1) type: DDM - 3020;
- 2) effective measuring range: 20 mm;
- 3) recommend measuring range: 0.1-16 mm;
- 4) the accuracy of measurement: + / - 0.003 mm;
- 5) exposure time: 200 us/or less time
- 6) control interface output: - 10 v - + 10 v.

9. 10 m single-layer cooling water tank

- 1) material: stainless steel;
- 2) long slot: 10 meters of monolayer;
- 3) cooling length: 10 meters

10. 500double wheel capstan:

- 1) power: 5.5 kW ac motor;
- 2) style: double tank;
- 3) to adapt to the line speed: Max200m/min;
- 4) to adapt to the wire diameter: Max Φ 12 mm;
- 5) casters chakra: phi 510, cast aluminum oxide processing, dynamic balance correction;
- 6) case material: stainless steel;

11. Spark tester:

- 1) the highest voltage: 10 kv;
- 2) product biggest diameter: 20 mm;
- 3) electrode length: 90 mm;

12. 2000Take-up

- 1) The use of the spool size: Φ 1600- Φ 2000mm;
- 2) Power: 60N torque motor;
- 3) Lifting: electric lift;
- 4) The electric clamp clamping;
- 1) to adapt to the wire diameter: Max Φ 10.00 mm;
- 2) to adapt to the line speed: Max200m/min;

13. Electrical control cabinet

- 1) Power supply:415V, 3, 50HZ;
- 2) System:

- a) Electric temperature control: a total of 7 section temperature control;
- b) Power control: control by the general switch and shunt switch;
- c) Motor operation control: driven by frequency to control the motor;
- d) Indicator control: 7 precise temperature control temperature control of the 7 district;
- e) Accessories: linkage control gauge, sparks machine and other ancillary fittings complete combination in the whole system, higher degree of automation.

3) Control instructions:

- a) Voltage: voltage display table;
- b) Electric heating temperature controller (day RKC): measuring point accurate temperature control of the 7 regions in the range of - 2 DEG C within the set temperature value, in different temperature settings to meet the different requirements of the process;
- c) Electric current meter: intuitive to each temperature zone heating display, stick out a mile;
- d) Cooling fan control: control by RKC temperature control meter, the temperature curve becomes flat;
- e) Winding machine: tachometer tachometer driven by frequency output signal, the meter display linear synchronous with the output of frequency converter;
- f) Extrusion and drawing linkage ratio, single acting control requirements, rapid response, timely response: extrusion and drawing control, by the selection switch is convenient and rapid, linkage adjusting proportion adjustment by a knob, fast reaction speed, response time;
- g) Each part movement indicating lamp: every part of the indicating lamp eye-catching display, real-time condition of correct reaction;
- h) Control box: open a door lighting, lighting for automatic light box, cabinet operation, more conducive to safety;
- i) The control box through the fan: the door closed, fan automatic operation, ventilation, make the operation more reliable electrical cabinet;
- j) Counter, control loop: counter accepts pulse signal meter counter sent, code length and the ratio of the number of pulses can be adjusted freely, can conveniently and accurately gauge length, and also with the meter prediction function, make the operator more handle a situation with ease.
- k) Suction, hopper dryer, no material alarm control: automatic suction feeding, automatic control of material drying degree, automatic alarm, no material, accuracy and greatly increase the effective work to reduce the labor intensity of operators.

NO	name/model	Qty (Set)	note
1	Operating instructions	1	
2	The inverter specifications	1	
3	PLC instruction	1	
5	Production line installation drawing	1	
6	heater	1	
7	thermocouple	2	
9	Tool box	1	

