

## Contract attached pages

NO.	Description	Qty
1	65/132conical twin-screw extruder	1 set
2	YFD240 vacuum forming table	1 set
3	YFY240 hauling off&cutting machine	1 set
4	YFF240Sr roll-over stand	1 set



## 5.65/132 conical twin screw extruder



- a. 1.extrusion system (screw and barrel)
- 2.screw diameter :  $\varnothing$  65mm, 132mm
- 3.MAX output: 120 ~ 220kg/h
- 4.Screw structure is designed for PVC powder, with conical engagement way, count-rotating, rotating speed: 1-34.7r/min
- 5.Screw material: high-quality alloy steel 38CrMoAlA, through high temperature nitrogen treatment, nitrogen depth: 0.5~0.7mm, surface hardness: HV740~940
- 6.Screw core temperature control: through screw core constant temperature device and Through the screw core department to automatically adjust the constant temperature device
- 7.Barrel material: high-quality alloy steel 38CrMoAlA, through high temperature nitrogen treatment, nitrogen depth: 0.6~0.7mm, surface hardness:  $\geq$  HV940
- b.8.control system of barrel temperature  
Heating zone: cast-aluminum heating ring + stainless steel surface cover + cooling fan
- 9.Cooling device: blower adopts air as media, providing precise temperature control
- 10.Heating zone quantity: 4, total heating power 21kw, temperature range 50~300°C

Power of cooling fan: 3\*0.25kw/set

Barrel outer temperature control adopts cooling fan to cool, and control temperature

fixed-amount feeding system

1.2.1. Use stainless steel feeding hopper

1.2.2 Fixed-amount feeding device: use screw feeding system to ensure material stable feeding

1.2.3 Power of feeding motor: 1.1kw, 3-phases asynchronous motor, connected with mini pin-cycloid gear box, motor rotating speed 10-1500r/min, feeding motor rotating range: 1-50r/min

1.2.4 Feeding device speed control: by ABB AC frequency converter

c) : vacuum exhausting device

1.1 Vacuum pump: direct-connecting water-ring vacuum pump 1 set

1.2 vacuum pump power: 1.5 Kw

1.3 Working mode of vacuum pump motor: 3-phase asynchronous motor

1.4 vacuum degree: 0~ -0.075 Mpa

d) transmission system

1.4.1 . Use high torque gear box

1.4.2 Water-cooling temperature lowering device

1.4.3 Material of gear box gear: 20CrMoTi, gear for speed control, adopts hard-tooth surface and helical surface combination, gear is nitrogen and grinding treatment.

1.4.4 Adopts German technique, with long service life, low noise and low heat

1.4.5 Horizontal gear box, main motor connects with gear box by coupler.

1.4.6 Distributing box: through hyperconical gear, from single axle output to double axle output.

e) main motor system

1.5.1 AC main motor

1.5.2 power of main motor: 37 kw , 380V, 50Hz

1.5.3 .Speed regulation of main motor: by ABB brand

f) extruder dimension and weight

6.1 dimension: 4100×2000×2500 mm

6.2 center height: 1000mm

6.3 weight: 4000Kg

g ) electrical control system

1.7.1 Modified electrical control cabinet

1.7.2 Adopt digital display controlling cabinet , humanized controlling

1.7.3 AC frequency converter is by ABB

1.7.4 SIEMENS AC contactor

1.7.5 Urgent stop device and warning system

h ) warning system range

1.8 Over-current protection warning extruder center height: 1000 mm

## 2. YFD 240 YFD 240 vacuum forming

- Forming table, stainless steel
  - Length:6m
  - Width: 1.1m
  - Vacuum pump 2 sets 5.5kw
  - Vacuum degree: 0 -0.09 Mpa
  - Pump and quantity: 4kw +1.5 kw each 1 set
  - Vacuum connection units 32 pieces Color: yellow
  - Water connection units 32 pieces Color: blue
  - Mold supporter: cast aluminium, T type channel, stainless steel
  - Air connection units: installed on the backplate, water connection units installed on the supporter
  - Electrical equipment operative surface with waterproof layer
  - Fan motor: 0.75kw
  - Forming table and hauling system are connected by flexible screw, motor power: 0.75kw
  - Forming table up and down adjusting: motor driving
  - Right and left adjusting: hand movement Front and back adjusting: motor driving
  - Temperature control: RKC
  - Contactor, breaker, relay: SIEMENS
- dimension: 5500×1060×1000 mm  
weight: 1700Kg

Function Description: This equipment automatically feeds the mixed materials into the screw barrel of the extruder, automatically controls the temperature according to the process temperature set according to the production needs, fully plasticizes the materials through the high-temperature and high-pressure melting of the screw, enters the mold cavity of the required products, and then produces the required qualified products through the vacuum cooling and shaping of the mold shaping section



Function Description: the molten plasticized materials extruded from the mold cavity enter the setting die of the equipment. Because the materials entering the setting die are still at high temperature, the materials need to be vacuum setting and water cooling to achieve the purpose of setting. The vacuum system of this equipment will tightly adsorb the outer wall of the materials entering the setting mold to the inner wall of the setting mold to ensure the dimensional accuracy of the products, and cool the products through the water cooling circulation system to achieve the purpose of setting. In addition, the blowing system of this equipment will remove the water on the surface of the products



### 3.YFY240 hauling off&cutting machine

- Double track
  - Each track driven by yurbo-dynamo, frequency conversion control track running synchronously
  - ABB converter Valid clamp length: 2000mm
  - Double track with the characteristics of high quality, wear-resisting, difficult to break, deform and ageing. Good clamping ability, harmless to profile.
  - Effective clamping width:300mm
  - Haul-off speed: 0.5 ~ 4.6m/min
  - Motor: 1.5KW
  - Max cutting width: 300mm
  - Max cutting width: 45mm
  - Forced dedusting: 0.75KW
  - Circular saw web, alloy steel, special for profile.
  - Equipped with rubber clamping device
  - Air pressure: 0.5~0.7 Mpa Pressure: 0.5-0.7MPA
  - Limit switch
  - Hauling and cutting united
- dimension: 3500×1060×1600 mm  
weight: 1650Kg



### 4. YFF240Sr roll-over stand

- Total length: 6m
- Automatic tilting by pneumatic and limit switch device.
- Frame: Can be disassembled, the contact part covered by rubber material.