

PP hollow three-layer plastic building formwork production line

	<p>1. Overview: PP, PE hollow three layer co-extrusion composite plastic construction template production line, is our company according to foreign advanced equipment technology, by our company independent research and development of the eighth generation of new polyethylene, polypropylene (PE, PP) class waste plastics and calcium carbonate filling co-extrusion composite process production of hollow three layer co-extrusion composite plastic construction template production line. Now has applied for the national patent, cross square hollow three-layer composite plastic building template production line patent no.: ZL2016 2 0772538.9, cross square hollow three-layer composite plastic building template patent no.: ZL2016 2 0748275.8. Cross square hollow three-layer composite plastic building template advantages are: low cost, light weight, continuous use of more than 50 times. Waste board material can be crushed and reused and many other advantages.</p>
1. Conditions of use:	<p>1) Power supply: 380v / 50 HZ / 3P + N + E</p> <p>Covering an area: length X, width X, 35 meters, X5 meters, X4 meters                  Total installed capacity: about 420KW actual electricity consumption: about 280 KW</p> <p>It is recommended that the transformer shall be no less than 315KVA</p> <p>2) Cooling water: temperature is below 30°C, pressure is 2-4kg / cmG, water flow is 40 Lm<sup>3</sup> / hr, water consumption is 1.5m<sup>3</sup> / hr</p>

	3) Compressed air: pressure 0.6-0.8MPa, gas consumption 1.5m <sup>3</sup> / hr	
	4) Installation site: indoor (temperature 0℃ -40℃, relative humidity 10% -80%)	
2. Specifications :	Material: PP raw material, recycled particle material	
	Width: 915mm Length: infinite length	
	Thickness: 14-16mm	
3. Production:	Extrusion capacity of 350-450kg / h, width 915 mm X, length 1830 mm X, 15 mm thick, (about 8.8kg / m <sup>2</sup> ) design daily output of about 600-800 sheets. The ordering party shall provide the raw materials for test and deliver the preliminary test acceptance in the contractors factory.	
4. Design line speed:	0.2-1.5m/min	
2. Quantity and price of equipment composition:		
order number	device name	quantity
1.	SJ 120-33 exhaust single screw extruder (special for core layer)	A
2.	Dual-station hydraulic quick net changer	A
3.	Melting measurement pump	A
4.	Hydraulic station (two	A

	mainreplacement)	
5.	SJ 90-33 single screw extruder (upper and lower layer is common)	A
6.	Dual-station hydraulic quick net changer	A
7.	The ABA co-extrusion distributor	A
8..	ABA co-extrusion molds	ones set way
9.	Vacuum cooling setting table	ones set way
10.	Cooling pressure leveling forming machine (upper and lower roller type, 6 groups of 12 rollers)	ones set way
11.	Longitudinal saw blade edge cutting device	ones set way
12.	Roll roller cooling directional bracket	ones set way
13.	Traction machine (upper and lower rubber roller type, 6 group of 12 rolls)	A
14.	Transverse saw blade cutter (upper cutting structure)	A
15.	Accumulation platform	A
16.	Stainless steel hopper and screw feeder for extruder	Two sets
17.	Electrical control cabinet and all electrical appliances	full set

18.	mixing machine	Two
19.	A 20HP water chiller	A
20.	SWP500 Crusher	A
Equipment price: one million and 8 million 1.08 million Preferential price: 980,000 RMB		
3. Detailed configuration:		
1. SJ 120-34 single screw exhaust extruder (for co-core layer)		My company makes it
Screw barrel		Zhejiang Zhoushan
material quality		38CrMoA1A
depth of nitration		0.5-0.7mm
Screw hardness		≥HV740
Machine cylinder hardness		≥HV940
draw ratio L/D		33:1
Screw diameter		120mm
Boiler heating area		Area 6
Total heating power		About 18KW
Heating method		Cast aluminum heater for heating
cooling-down method		Fan cooling
cooling power		6×0.37kw
maximum speed		90prm
Drive the motor		Siemens (Bay de) motor
frequency control		The frequency converter is an

	ABB inverter
power of motor	110KW
reduction box	Changzhou single screw special hard gear face gear box
Rodent form	Slant tooth surface
heat treatment	Nitrogen grinding teeth
type of attachment	Motor and reducer directly connected type
With stainless steel hopper and screw feeder	Made by our company
2. Dual-station hydraulic quick network changer	Made by our company
Hydraulic changing device	Double work station, single plate net replacement
Quality of the hydraulic network changing equipment	High-quality mold steel nitriding treatment
3. Melt metering pump	
Melting measurement pump	250cc
pressure pickup	Before the pump, before the net and after the pump to use the domestic famous brand
transmission power	11kw
4 Hydraulic station (two main networks)	
The maximum pressure on the system	31.5Mpa (Accumulator)

	pressure limit)
power of motor	2.2KW
5. SJ 90-33 Single screw exhaust extruder (upper and lower layer)	Made by our company
Screw barrel	Zhejiang Zhoushan
material quality	38CrMoA1A
depth of nitration	0.5-0.7mm
Screw hardness	≥HV740
Machine cylinder hardness	≥HV940
draw ratio L/D	33:1
Screw diameter	90mm
Boiler heating area	5 District
Total heating power	About 15KW
Heating method	Cast aluminum heater for heating
cooling-down method	Fan cooling
cooling power	5×0.25kw
maximum speed	90prm
Drive the motor	Siemens (Bay de) motor
frequency control	The frequency converter is an ABB inverter
power of motor	75KW
reduction box	Changzhou single screw special hard gear face gear

	box
Rodent form	Slant tooth surface
heat treatment	Nitrogen grinding teeth
type of attachment	Motor and reducer directly connected type
With stainless steel hopper and screw feeder	Made by our company
6. Dual-station hydraulic quick network changer	Made by our company
Hydraulic changing device	Double work station, single plate net replacement
Quality of the hydraulic network changing equipment	High-quality mold steel nitriding treatment
7. The ABA co-extrusion distributor	Huang Yan
Coextrude the distributor material	High quality mold steel
Chrome plating treatment inside the coextruded distributor	Polished to mirror
The upper and lower layers of the co-extrusion distributor adjust the thickness	0.2 mm -1.2mm
Number of heating zones of the coextruded distributor	Zone 2, 6KW
8..ABA Co-extrusion mold	Huang Yan
Mold material	High quality mold steel
Chrome plating treatment inside the die	Polished to mirror
Mold opening width	L=1020mm

Final qualified product width	915mm
Final qualified product thickness	14-16mm
Number of heating areas of mold	Area 7
9. Vacuum cooling setting table	Made by our company
Number of vacuum cooling set formwork	Three-level stereotypes, up and down 3 to 6 pieces, vacuum pumping, cooling water circulation
Specification of vacuum cooling set template	1200mm X 800mm
Vacuum cooling to set the template material	Mold steel, surface coated with hard chrome finish treatment
Three sets of vacuum extraction systems	Two 7.5KW vacuum pumps One 11KW vacuum pump
Cooling temperature control system	120HP water cooler and control the temperature of 3 pairs of 6 set templates
Pneumatic lift	Upper cooling set template moves up and down
Longitudinal moving device	1.5KW motor, manual adjustment
10. Cooling and pressure leveling forming machine (upper and lower roller type, 4 groups of 8 rollers)	Made by our company



structural style	Up and down 2 only for 1 group, 8 roll 5 group roll type
Number of pressure roller	Eight
Press roller diameter X effective length	180 mm X1200mm
Lightweight roller material	Mold steel, surface coated with hard chrome finish treatment
The wall of the pipette roller is thick	20 mm
Speed regulation of roller	Passive type, driven by the tractor operation
Pneumatic lift	Move up and down the roll
11. Longitudinal blade type edge cutting device	A set
Vertical blade total bearing	Two sets
Longitudinal blade	Left and right a set of cut edge total bearing, each with 1 piece of blade.
breadth	Manual adjustable
Saw cutting edge form	The micro reducer adjusts the blade lift and cuts the edge
12. Roll roll cooling of directional tray	Made by our company
Stainless steel roller	Φ70 mm X 1200 mm
length	2000 mm mm
bearing unit	A set

13. Tractor (upper and lower rubber roller type, 6 groups of 12 rollers)	Made by our company
Rubber roller material	acrylonitrile-butadiene rubber
The number of rubber roller	12 Six pairs
specifications	Φ210mm X1500mm
power of motor	5.5kw
frequency control	The frequency converter is an ABB inverter
driving mode	Chain, gear drive
hauling speed	0.2-1.5m/min
Pneumatic lift	Move up and down the roll
14. Transverse saw blade cutter (upper cutting structure)	Made by our company
Saw cut thickness	6-18 mm
Maximum cut width	1300 mm
Use a disc alloy saw blade	The pneumatic press is clamped
drive	Special saw-cut motor
power of motor	2.2KW
frequency control	The frequency converter is an ABB inverter
15. Storage material platform	
Length control	The metometer automatically

	controls the lateral cutting	acc
Platform specifications	3000mm X1300mm	ess
16. Stainless steel hopper and screw feeder for extruder	Made by our company	ory
Pending method	Spiral material	equ
power of motor	3KW	ipm
Stuff material	stainless steel	ent
<b>Storage box material</b>	stainless steel	:
17. Electrical control cabinet and all electrical appliances	Made by our company	
electrical control cabinet	Qin type control cabinet	
PLC touch screen	siemens	
Temperature control module	siemens	
contactor	siemens	
Frequency conversion governor	The frequency converter is an ABB inverter	
air switch	Chint brand	
Button, switch indicator light	Chint brand	
18. Jigger	Made by our company	
capacity	800 KG	
Stir the motor	3KW	
stirring method	Spiral up and down	
19. 20HP air-cooled water chiller:		
source	3 phases 380V and 50 HZ	

aggregate capacity	16KW	5.
Cold media	Freon	Aft
control method	Computer PC version of the self-optimization microprocessor	er- sal es
control accuracy	PID±1° C	ser
chilling temperature	10° C-30° C	vic
20. SWP500 crusher	Made by our company	e
Number of fixed knife	Two pieces	co
Number of flying knife	Three pieces	m
particle size after cracking	5 mm -8 mm	mit
power of motor	22KW	me
Broken quantity	400-600KG	nt an

**d service plan:**

1. All products are three guarantees with a term of one year. During the warranty period, all the costs of technical services shall be borne by the contractor. After the warranty period, only the material cost shall be charged, including lifelong supply of accessories, lifelong service and lifelong maintenance.

**2. Pre-sales service:**

After both parties sign the contract, the installation drawing provided to the contractor. The ordering contractor shall provide itself according to the installation drawing provided by the contractor

For auxiliary facilities other than equipment, make preliminary preparations for

equipment installation; water, electricity and gas routes shall be laid according to the requirements of installation drawings

Go to the designated location and prepare all the materials required for production.

3. After-sales service:

After the delivery of the equipment, the contractor shall send 1-2 technical personnel to guide the installation of the equipment.

Provide free training and technical formula; If the timemaker needs help, extend the working hours of the service staff until the church.

6. The following matters outside the price range shall be solved by the ordering party according to the actual situation:

1. Technical requirements for the facilities of the customized party workshop

Requirements for electronic control parameters:

order number	name	specifications
1	Power supply voltage	380V $\pm$ 10% 3-phase 5-wire system
2	supply frequency	50Hz $\pm$ 1%
3	IP grade	IP43
4	control voltage	AC220 V
5	ambient humidity	0-40 $^{\circ}$ C
6	relative humidity	80%, with no condensation
7	Install the altitude	$\leq$ 1000 M

2. Water use requirements:

External circulation water source:

According to the site situation, the cooling water tower or building 25~50m<sup>3</sup> pool can be configured

outside the wall of the workshop, and the pump pumps water to form external circulating water.

number	name	unit	data
1	aqueous medium		running water
2	Water flow		6m <sup>3</sup> /h
3	head of delivery		45m
4	water gage		Not less than 0.16MPa
5	Pump power	Kw	According to the water flow and head configuration