

REPRESENTADA:



**南京海思**  
**NANJING HAISI**



### **GW50 PMMA PC Profile Extrusion Line**

The line consists of:

Item no.	Description of goods	Qty
1.	GW50/30 单螺杆挤出机 GW50/30 single screw extruder	1 set
2.	YF110 真空定型台 YF110 VACCUM CALIBRATION TABLE	1 set
3.	YF110 牵引机 YF110 haul-off	1 set
4.,.	无屑切割机 None-dust cutter	1 set
5.	YF110 翻料架 YF110 Stalker	1 set

#### ➤ 环境条件 **Environment Condition**

地点 Location	室内 Indoors
电源供应 Power Supply	无危险区域 No dangerous area
湿度 Humidity degree	≤95%
温度 Temperature	0-35℃

#### ➤ 工作条件 **Work Condition**

冷却水 Cooling Water	≤20℃, ≥0.3Mpa, ~3T/h
压缩空气 Compressed air	0.3m³/min, >0.5Mpa

#### **1. GW50/30 挤出机技术规格 GW50/30 single screw extruder**



1) 型号/Model No.

GW50/30

挤出量/Extrusion capacity

20-50kg/h

2) 螺杆/ Screw

—直径/ Diameter

50mm

—长径比/ L/D

30:1

—材质/ Material

38CrMoAlA

—表面处理/ Surface Treatment

渗氮, 抛光

—硬度/Hardness

HV800-900

—转速/Rotation Speed

10-70r/min

3) 机筒/ Barrel

—材质/ Material

38CrMoAlA

—内表面处理/ Inner Surface treatment

渗氮, 衍磨/ Nitrided, ground

—硬度/Hardness

HV940-1100

—加热控制区/ Heating control zones

5 个区/ 5 zones

—加热方式/ Heating method

陶瓷加热圈/Ceramics heating rings

—加热功率/ Heating power

3.5kw/区 × 5 区=17.5kw

—冷却系统/ Cooling system

机筒风机冷却/ By blower fan

—冷却功率/ Cooling power

0.18kw/只 × 5 只=0.9kw

4) 减速箱/ Gearbox

—箱体材质/ Material of the gearbox body

HT200

—齿轮形式/ Gear type

硬齿面斜齿轮/Harden tooth helical

gears

- |   |                              |
|---|------------------------------|
| — 齿轮材质/ Material of the gear                  | 20CrMnTi                     |
| — 齿轮表面热处理/ Heat treatment of the gear surface | 齿面淬火/ Quenching              |
| — 轴材质/ Material of the axes                   | 40Cr                         |
| — 冷却方式/ Cooling method                        | 带冷却管/ With the cooling tubes |

5) 热风干燥料斗、自动加料机及加料座/ Hot air hopper, material feeder and feeding base

- |                                   |                      |
|-----------------------------------|----------------------|
| — 干燥加料斗装料量/ Hot air hopper volume | 装料量 60kg/60kg        |
| — 加料斗材质/ Material of the hopper   | 不锈钢/ Stainless steel |
| — 自动加料机/ Material feeder          | 真空吸取方式，微电脑控制/ Vacuum |

feeding

- |                                       |   |
|---------------------------------------|---|
| — 加料座方式/ Feeding base                 | 带水套式冷却系统（循环水）/ With the water jacket cooling system |
| — 加料座材质/ Material of the feeding base | Q235  |

6) 驱动电机/ Driving motor

- |                           |                           |
|---------------------------|---------------------------|
| — 方式 / Method             | 交流电机/ AC motor            |
| — 功率/ Power               | 18.5KW                    |
| — 电机控制器/ Motor controller | 交流变频调速 ABB / ABB inverter |

7) 电器控制设备(仪表柜) Electrical control equipment (instrument cabinet)

采用日本进口品牌温控仪表，温控精度高，实现精确控温。低压电器如接触器为西门子品牌，空气开关及继电器均采用国内名牌厂家产品。模具预留 4 区。Japanese imported brand temperature control instrument, High temperature control accuracy, Achieve precise temperature control. Low voltage electrical appliances such as SIEMENS brand, Air switches and relays are used in domestic brand-name manufacturers. Mould reserved 4 area

### 3. YF 110 VACCUUM CALIBRATION TABLE / YF110 真空定型台



- 3.1 水箱水槽均为不锈钢材质。  
Calibration tanks and basin are made of stainless steel.
- 3.2 定型台长度: 3000 mm  
Table length: 3000 mm
- 3.3 定型台宽度: 980 mm  
Table width: 980 mm
- 3.4 定型台铝导轨中心距: 320mm  
Center distance of mould supporter guide : 320 mm
- 3.5 真空泵: 4 KW x 1 水环式真空泵 带消音装置及带整体式底板; 安装精度高、防震动、带过电流保护。(冬天必须放水, 以防冻坏)  
Vacuum pump power and quantity: 4 KW x 1sets Remarks: 1 sets of high quality vacuum pumps made in China with sound deadening device, integral floor panel and protective mechanism against over current and vibration. ( Water must be vented, prevent for frostbite )
- 3.6 真空度: 0 -0.09 Mpa  
Vacuum degree: 0 -0.09 Mpa
- 3.7 水泵功率及数量: 1.5 kw 一台  
Water pump power and quantity: 1.5 kw 1 set.
- 3.8 真空气嘴数量: 12 只 (黄色标注)  
Quantity of vacuum joint: 20Pcs (Color in yellow)
- 3.9 水嘴数量: 20 只 (蓝色标注)  
Quantity of water joint: 20 Pcs (Color in blue)
- 3.10 定型台面轨道材质形式及断面形式: 不锈钢水槽, 模具连接轨道用铸铝型材, 表面硬质阳极氧化处理或喷银粉漆, 托架与集水管为一体, 采用不锈钢方管, 耐磨耐腐蚀。  
Mould supporter: casting aluminum bar with T shaped slot for fixing mould tool.  
Supporting rack and water pipe are integrated, which is made of stainless steel tube.
- 3.11 气、水嘴接头位置及方式: 气嘴球阀在机身上方, 水嘴在水槽方管托架上  
Installation of air and water joint: Air joints are installed on guard plate and water joints are installed on supporting rack
- 3.12 电气控制柜及操作面板均有防水保护。  
Electric control cabinet and panel with waterproof covering.
- 3.13 涡流吹风机: 0.75kw. 用于吹干制品表面水渍  
Blowing device: 0.75kw air blower. For the drying of the surface of product.
- 3.14 定型台前后移动装置: 由丝杆连接定型台与牵引机, 丝杆减速电机功率 0.75Kw, 电动控制定型前后移动。  
Connection of Vacuum table and Haul-off: by lead screw bolt, drive by reduction motor of 0.75kw.
- 3.15 定型台上下位置调节: 电动升降, 由 2 台丝杆电机控制, 四部微型丝杆减速器传动。其他二个方向调节: 水槽水平倾斜度和定型台左右位置微调可手动调节。  
4-direction adjustment available: up and down automatic adjustment, front and back automatic adjustment, left and right adjustment manually, and deflecting adjustment manually.



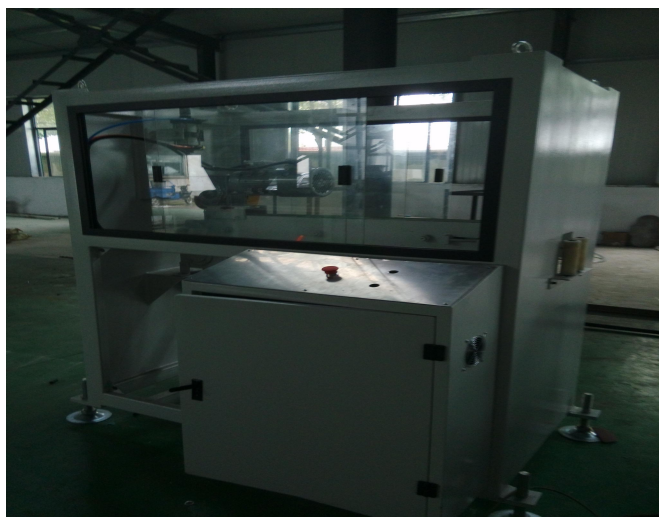
### 3.16 水槽水平倾斜度微调装置.

Fitted with a device for horizontal adjustment.

### 3.17 由真空表水温表显示各区的真空度及水温

Fitted with water temperature meter and vacuum meter.

## 4. YFY 110 Haul-off unit



### 4.1 牵引带数量: 2 条.

Quantity of haul-off caterpillar: 2

### 4.2 二条牵引带, 每部牵引带由减速电机驱动. 减速电机: 1.1 kw/台. 牵引带由变频器提供速度控制

Each haul-off caterpillar is drive directly by one reduction motor. Reduction motor power of 1.1 kw/set X 2 sets. Speed of caterpillar regulates synchronously by converter.

### 4.3 变频器生产厂家: /ABB

Controlled by one imported frequency converter /ABB Company.

### 4.4 牵引带高度气动调节.

Haul-off caterpillars lifting adjustment: By pneumatic.

### 4.5 气动元件工作压力: 0.5~0.7 Mpa

Working air pressure: 0.5~0.7 Mpa

### 4.7 牵引速度: 0.3~3 m/min 0.5~6 m/min

Haul-off speed: 0.3 ~3 m/min 0.5~6 m/min

### 4.8 牵引力

Drawing force: 4 T

### 4.9 牵引带高度可由控制面板上的气阀开关调节,用于开车时的微调。

Fitted with a device for tape adhesion, of which the position of roller can be adjusted flexibly by adopting clamping spring.

## 5 None-dust cutter / 无屑切割机



- 5.1 切割电机功率 Cutting motor power: 0.75 KW
- 5.2 切割最大宽度 Maximum cutting width: 63mm
- 5.3 切割程序控制由 Cutting program control **Mitsubishi** (三菱) PLC or other famous brand
- 5.4 切割时由胶块压紧装置提供准确切割精度. The cutting is provided by the plastic block pressing device to provide accurate cutting accuracy
- 5.5 切割工作台移动和刀片起落由汽缸控制和 PLC 程序控制. The cutting table moves and the blade is controlled by the cylinder control and PLC program or other famous brand
- 5.6 工作压力 working pressure: 0.5~0.7 Mpa
- 5.7 可以选择手动切割和自动切割模式. 限位开关计长 Can choose manual cutting and automatic cutting mode, Limit switch meter
- 5.8 切割机采用机械限位定长, 微动开关感应制品经过时, 机械挡块下压和移动压块一起移动, 保证切割精度, 最小切割长度 500mm 以上 Cutting machine with mechanical limit set length, After the micro switch sensor products, Press and move the block under the machine, Minimum cutting length 500mm above.

## 6. YF110 Stalker

- 6.1 翻料架长度 Stalker length: 2m
- 6.2 汽缸翻动, 机械限位开关计长 The cylinder, Mechanical limit switch meter
- 6.3 翻料架制品接触部分由橡胶块包覆, 利于制品美观. The contact part of the material is covered by the rubber block, Favor of product appearance
- 6.4 台面不锈钢材质 Mesa stainless steel material

## III. Utility specification 安装条件

### 1. Electricity 电力标准

- 1.1 标准: 380 V/3 相/60 Hz  
Designation: 380 V/3 Phrase/60 Hz
- 1.2 工作电压: 380V  
Line voltage: 380V
- 1.3 控制电压: 220V

Control voltage: 220V

1.4 保护措施: 接地

Protective measure: earth

1.5 或者按照客户工厂电压

Depends on customer factory voltage

**2. Compressed air / 压缩空气:**

2.1 有效工作压力范围: 0.4~0.6Mpa

Effective working pressure: 0.4~0.6Mpa

2.2 使用条件: 要求无尘、无烟、无油污

Quality: condensing-free, oil-free, dust-free, pre-filtered.

**3. Cooling water 冷却水**

3.1 有效工作压力范围: 0.2~0.4Mpa

Effective working pressure: 0.2~0.4Mpa

3.2 水温: 10 ~ 25 摄氏度.

Water temperature: 10 ~ 25 degree centigrade.

**Note :all the pictures just for conference**

Spare part list for free:

序号 No.	名称 Spare Parts	数量 Qty
1	热电偶 Thermal couple	5 件 5pcs
2	螺杆拆装工具 Dismantling tools for screw	1 套 1set
3	温度计 Thermometers	5 件 5pcs
4	减速机高速轴油封 Oil seal for gearbox	1 件 1pcs
5	磁插头 ceramic adapter-male	2 件 2pcs
6	高温导线 Anti-High temperature Wire for mould	8m
7	接触器 Contactor	1 pcs
8	断路器 switch	1 pcs

售后服务 After-sale service

1. 整机质保期一年，终身保修，海思公司调试人员出境后的费用（包括往返机票，买方国内交通、医疗及食宿费用等）及元器件材料费等由买方承担，但在质保期内，元器件材料费用由卖方承担。The guarantee period is 1 year and service is available lifelong. The cost caused by the seller's expert in customer's country (including shuttle trip ticket between China and the Buyer's, inland traffic, medical fees, lodging, dinner and so on) and the cost of the materials of the components will be covered by the buyer, but during guarantee period, the cost of the components will be covered by the seller.
2. 接客户服务电话即有相关技术人员 24-48 小时回复,并尽快处理。Our expert will answer any inquiry

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within 24-48 hours and it will be solved as soon as possible.

3. 提供整套技术支持资料及相关电器图纸（中文或英文）。The Seller supplies the complete technical support documents and the relative drawings of the electric components written in Chinese and English.

检测标准 Testing standard

1. 设备的验收标准按照国塑机械（上海）有限公司的企业标准验收合格。The acceptance standard of the good is fully accorded to the Company Standard of Nanjing Haisi Extrusion Equipment Co., Ltd.
2. 卖方提供主机、辅机操作说明书及电器原理图（变频器、压力传感器等）The Seller supplies operation manual for main extruder and accessory equipment and the principle drawings for the electric components.