

TECHNICAL SPECIFICATION EXTRUDER LINE 30MM



1. Extruder technical data

1.1 Screw



REPRESENTADA:
南 京 海 思
NANJING HAISI



-----Diameter:30mm

-----L/D=26:1

-----Material of screw: 38CrMoALA

-----Screw surface treatment: Nitrogen treatment on forgeable piece,fragility 1 level

-----thickness of nitrogen layer:0.5-0.6mm, hardness:HRC 800~900HV.

-----Screw and screw groove surface roughness $\leq 0.8\mu\text{m}$

-----Screw surface electroplated layer thickness:0.03mm--0.4mm

-----Screw design for polymer processing

-----Inner water input

1.2 Barrel

-----Material:38CrMoALA

-----Barrel inner-surface treatment:

Screw surface treatment:Nitrogen treatment on forgeable piece,fragility 1 level,thickness of nitrogen layer: 0.5-0.6mm,hardness:HRC 800~900HV.

-----Inner face roughness: $\leq 1.6\mu\text{m}$

1.3 Heating type: Cast porcelain heater,polished finish on inner face,stainless steel outside.
Temperature range from 0℃ to 400℃.

-----Heating zone and power: 3 zones,1.8kw/zone

1.4 Reducer

-----Reducer type:hard-toothed surface gear reducer,helical gear transmission

Gear is made of high strength low-carbon alloy steel with normalizing and quenching treatment, hardness HRC58-62, adopted numerical control grinding processing,products conform to the state professional standards-ZBJ190004

-----Thrust bearing: adopts Japan”NSK”product.

-----Driving motor

-----AC variable “ABB”inventor,”WN”Motor,4kw,Best brand in China.with thermal overload

Protection,totally enclosed,fan-cooled

-----Working type:Motor and reducer direct-coupled transmission.

-----Transmission system shield:Metal mesh shield,arrow indicates direction of rotation.

1.5 Electrical Control system

-----Comply with CE standard

-----Function panel settings:power indicator,main current/main voltage display,heating area current display,heating/stop knob switch,screw rotation speed display,operation panel,speed control knob,alarm switch and the buzzer,emergency stop button

-----Temperature control:total 4 points temperature control system,adopts Japan"OMRON"liquid crystal display temperature controller,

-----Temperature controller display measuring value and setting value at the same time,all heater electrical main circuits have current detection circuit function and display current value

-----Main cut-off switch:adopt"LS"product, CE certification.

-----Main AC contactor:adopt"SIEMENS"product, CE certification.

-----Variable-frequence adopts "ABB" inventor

-----Mold connecting flange.Flange form:square,four bolts fastening,loose leaf type opening and closing

1.6 Water strand pelletizing line

-----Water trough /water bath, stainless steel, 1.5 meter.

-----Air knife / drier, 0.75kw, together on water trough



-----Pelletizer / cutter, motor power 1.1kw.



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2. Spare parts & documents

2.1	Wheel box input and output shaft oil seal	6 pcs
2.2	O-ring seals	3pcs
2.2	Heater	1pc
2.4	Toolbox	1set
2.5	Instruction for assembling and operation	1pc
2.6	Instruction for electrical control cabinet	1pc
2.7	List of machine delivered	1pc
The Above spare parts should be offered to the buyer for free when the buyer orders the complete appliance.		

3. Engineering condition

- Electricity power:3-phase,380V, 50Hz(**Any difference, please tell**)
- Control voltage (transformed):220V AC
- Total consuming power:~5.5kw
- Industrial soft water: 50L/tank, $\leq 25^{\circ}\text{C}$
- Temperature of electrical control cabinet : $\leq 38^{\circ}\text{C}$, free of conductive dust
- No necessity to make special base, the machine put on even load-bearing ground

4. After-sales & tech-service

- Offer installation and operation guide
- Offer acceptance check and trial
- Train service to the operator from buyer
- Spare parts supply for long-term
- Long-term technical consult service
- Warranty period for one year (for free) No contain the quick-wear parts

5. Explanations

1) Validity of quotation

The quotation is valid until 1 month after date of its generation.



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2) Warranty:

Since the formal acceptance of users, from the date, the warranty period is one year.

After the warranty period, spare parts are provided at cost price.

If the damage is caused because of incorrect operation of customer self, we are not responsible for this damage.

Some spare parts such as screw component and electric heaters, are kind of consumer good. If need more, customers could purchase them from our company at cost price.

3) Delivery:

The transportation inside China is undertook by supplier, and unload cargo is done by the customers. According to the cargo list, customer signs the cargo list. The transportation and insurance is undertook by customer from board of Nanjing port to the factory. After the whole line transport to the factory, lay the machines according to the layout drawing, then inform the supplier for commissioning.

Customer should supply the water & electric cooperation. The supplier will make a course to teach the customer operate the machines.

4) Packaging:

Supplier will follow the customer's requirements (ordinary sea-worthy packing) to package the production line.