

## SJ -65/28 PVC High Speed Corrugated Pipe Machine

### Project condition:

Warehouse/Workshop	Dimension (L*W*H): 11×2×3m Crane: Machine positioning
Temperature & Humidity	≤40°C, ≤85%
Power supply	3-phase,380V,50 Hz
Wire/cables:	Wires/cables from power supply to control cabinet of extruder
Cooling Water hose/pipe	Water supply to machines and pools
Compressor	Supply compressed air
Installation power	50Kw
Cooling Water	20°C, ≥0.3Mpa, ~5~6 M <sup>3</sup> /hr

### Material condition

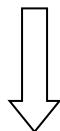
Raw material & formulation	PVC Granules
Extruder capacity	60-80KG/H
Pipe range	Φ 16-50mm(According to specification)

### Commercial Terms

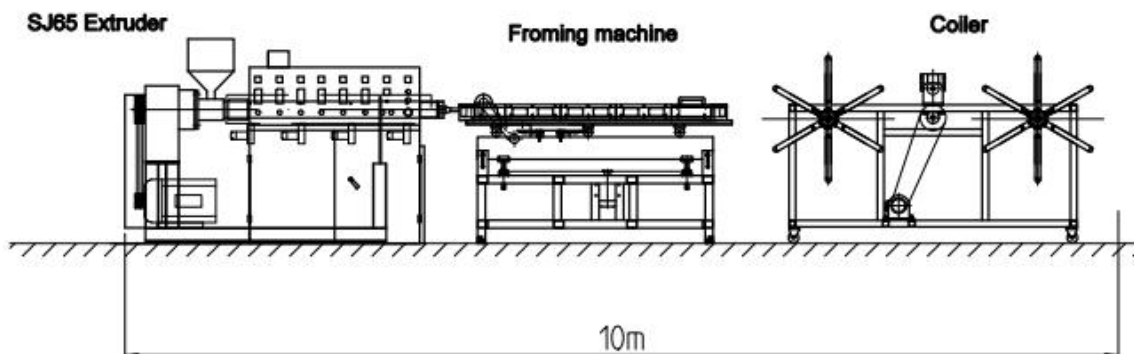
Payment Term	30% as down payment by T/T 70% by T/T before delivery and after inspection
Delivery Time	30 days since the date of receiving down payment
Warranty	12 months since the date of production in buyer workshop
Shipment	1x20HC container

### Main machine list

No.	Description	Quantity	Price	
1	SJ-65/28 Single Screw Extruder	1set	25000USD	
2	Hopper Dryer	1set		
3	Vacuum granules loader	1set		
4	Corrugated pipe forming machine (Water cooling+72pairs moulds	1set		
5	One set mould(72pairs) <b>(20mm+32mm Double cavity)</b>	1ses		
7	Double Station Coiler	1set		
8	Die head and moulds(72pairs) 22+25mm	2900USD/Set		1set
9	Die head and moulds(72pairs) 38mm	2900USD/Set	1set	2900USD/Set
10	Die head and moulds(72pairs) 50mm	2900USD/Set	1set	2900USD/Set
11	Spare parts tools	1set	Free	
Totally FOB QINGDAO PORT 33700USD				
12	10HP Water chiller	4100USD(Option)		



Specification Details



**Single Screw Extruder of SJ—65/28:**

Speed frequency regulator	ABB
Screw	<ol style="list-style-type: none"> <li>1.Screw diameter : 65mm</li> <li>2.The length and diameter ratio of screw : 28:1</li> <li>3.Material of screw: 38CrMoALA ,under nitrogen treatment</li> <li>4.The depth of nitrogen layer of screw: 0.4-0.6mm,hardness: HV&gt;740</li> </ol>
Barrel	<ol style="list-style-type: none"> <li>1.The material of barrel: 38CrMoALA,under nitrogen treatment</li> <li>2.The depth of nitrogen layer of barrel : 0.5-0.7mm,hardness: HV&gt;940</li> <li>3.Barrel heating : 4 heating section , Material of heating circle :stainless steel, heating power:4kw*4 sections</li> <li>4.Barrel cooling:3cooling section, cooling power:0.18kw*3sections(fan blower )</li> </ol>
Motor	Driving motor power :22kw
The capacity of extruder	60-80kg/h
Reduction gearbox	<p>Speed reducer is of hard tooth surface, and material of gear is 20CrMoTi under nitrogen, quenching and grinding treatment, and also equipped with outer cooling device.</p> <p>The device has strong loading capacity, stable transmission, low noise and high efficiency, etc.</p>
Reduction box	<p>Speed Reducer: Hard gears</p> <p>Gears material: 20CrMoTi hard gears and conical gears,</p>

	gears surface carburization
Electric parts	Temperature controller: Japan Omron brand ABB inverter SIEMENS /SCHNEIDER contactor



**Vacuum loading system**

Feeding type	Vacuum feeding
Capacity	80KG/H
Motor power	1KW
Length	3 Meter

**Hopper dryer**

Volume	25KGS	
Heating	Auto heating controller	
Heating power	1.5KW	
Temp	≤120°C	
Fan blower	0.25KW	

**Die Head and Mould 16-50mm**



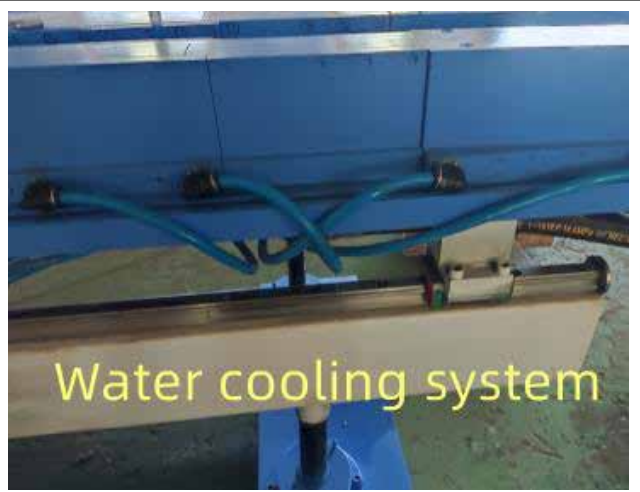
Material of mould	40Cr under forging , hardening and tempering treatment
Die head heating	One heating section ,material of heating circle is stainless steel
Quantity of mould blocks	72 pairs



The dimension of a piece of mould block	length 56.52*width 36*thickness 75mm
Perimeter of one set of mould	72*56.52=4069.44mm
Pipe range	16mm-50mm

**High Speed Forming Machine (Water cooling)(72Pairs moulds)**

The quantity of template :	1piece
Material of template :	Steel plate under treatment
Transmission mode	Transmitted by gear
The running mode of mould:	Around the running channel
Material of running channel :	Used special steel under nitrogen treatment
Lubricating system :	Auto oil lubricating system (controlled by motor )
Reduction gearbox :	Umbrella hard tooth surface reducer one set
Cooling mode :	Circulate water for cooling , two sides have 6 sections
Driving power :	4KW motor with speed frequency regulation
Counting mode	Shaft programmable code technology
Adjustment of forming machine	Machinery adjustment , motor power :0.4KW



**Double Position Winder**

Working position	Double working position
Arrangement of pipe	Auto line-arrangement device

Motor	The model of motor :moment electrical motor Output moment :5 N / m
The size of coiling disk	Inner 300mm*outer 900mm*width 300mm
Coiling mode	Inductive counting device



**Electrical Appliances:**

Low voltage electric applicant	SIEMENS
Temperature controlling device	OMRON intelligent temperature controlling device
Converter	ABB



**Spare parts:**

Die head heating circle	1 set	Die head wrench	1 pcs
Template (copper)	1 piece	attachment tools	1 set
Mould blocks	2 pairs/set	One-Touch thermocouple	2 pcs
Air tap	1 pcs	High temperature wire	10 meters
Chain	20 pcs	chain axle	20 pcs