

SHEETMETAL – ENGINEERING – PLASTICS – EARTHMOVING – FORKLIFTS

TECHNICAL SPECIFICATION

Complete Extrusion Lines for Production of 150mm PE pipes

TECHNICAL DATA OF PE 75-250mm PIPE LINE

1	JHE1-75-33B Single screw extruder	
1.1	DC drive power EUROTHERM speed controller	132 kw.
1.2	Gearbox Axis and gear wheels are made of alloy steel. Cogs are carbonized and hardened. The cogs' surface is polished. Working accuracy for the cogs is ISO6. The hardness of surface is HRC56-62. Bearings, stuffing boxes and other parts are made of high quality materials. The gearbox has high capacity, compact size, stability of work, low noise level and other advantages.	
1.3	Barrier screw diameter L/D ratio Construction – new, highly effective	75 mm 33:1
1.4	Material Grooved barrel Device for forced supply of material with water cooling	38CrMoALA
1.5	Die adapter Socket for melt pressure sensor Thermocouple	1
1.6	Heating zones Barrel heating zones Barrel cooling zones Die adapter zone Die heating zones	5 5 1 7
1.7	Maximum capacity	450 kg/h (HDPE)
1.8	Automatic feeder and dryer	800 kg/h
1.9	Control cabinet Computer control system (PLC), liquid-crystal display, English language menu, temperature control module. Functions: 1. Extruder and supporting units synchronization; 2. Automatic heating at switching on. Possibility of alarm system programming in all cases.	
2	JHE1-20-20 Co-extruder	1
2.1	DC drive power	2,2 Kw
2.2	Speed controlling – imported converter	
2.3	Screw diameter L/D ratio Screw and barrel material Maximum capacity	20 mm 20:1 38CrMoALA 3 kg/h (HDPE)
3	Spiral type die	1
3.1	With the function of color striping Pipe diameters	Ø110 – Ø200
3.2	The die work surface has undergone tempering	
3.4	Capacity Diameter x length Weight	450 kg/h Ø450x890 400 kg
3.5	Thermostat for die core	1
3.6	Die cart	1

3.7	Dies for different pipe diameters: 2 dies made to your specifications	1 set
3.8	Ring for 4-color marking	1
3.9	Co-extruder die adapter (is used for 4-color marking)	1
4	STV250 Calibrator	2
4.1	Pipe diameters	Ø75 – Ø250 mm
	Vacuum calibration chamber length	5500 mm
	Total length	5900 mm
	Vacuum pump power	4 Kw x2
	Water pump power	4 Kw x2
	Water-cooled gauges are made of non-ferrous metals	
	The calibrator is equipped with a spare vacuum pump	
4.2	Tools for HDPE pipes	
	150mm	1
4.3	Holders for pipes of different diameters:	
	150mm	3
4.4	Sealing device (includes sealing board, rubber seal and holders)	
	150mm	1
5	SC250 spray cooling tanks	3
5.1	Pipe diameters	Ø75 – Ø250
	Spray cooling area length	5600 mm
	Cooling chamber length	5800 mm
	Water pump power	5,5 Kw
5.2	Temperature controller for water	1
5.3	Water filter	1
6	R250 twin caterpillar haul-off unit	1
6.1	DC drive power	4 KW
6.2	Number of caterpillars	4
6.3	Caterpillar position adjustment - pneumatic clamping device	
6.4	Haul-off speed	0,2 – 6 m/min
6.5	Effective haul-off length	1400 mm
6.6	Maximum haul-off force	7.5 KN
6.7	Pipe diameters	Ø75 – Ø250
7	QG250 Pipe cutting unit	1
7.1	Cutting power	3 Kw
7.2	Rotation power	1.5 Kw
7.3	Pipe diameters	Ø75 – Ø250
7.4	Shavings collecting device	
8	Stacker	1
8.1	Stacker length	6000 mm
8.2	Automatic stacking	
9.	Length metering Ink Jet Printer	
9.1	Metering accuracy	0.3%
9.2	Suitable Pipe diameter	10-250mm
9.3	Heating Power	0.3KW
9.4	size	900x520x1450mm