

## SHEETMETAL – ENGINEERING – PLASTICS – EARTHMOVING – FORKLIFTS

### TECHNICAL SPECIFICATION

#### Complete Extrusion Lines for Production of PE 80/100 (50mm pipe)

#### TECHNICAL DATA OF PE 16-63 PIPE LINE

<b>1</b>	<b>JHE1-45-33B Single screw extruder</b>	
1.1	DC drive power EUROTHERM speed controller	45 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	45 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	4 4 1 6
1.7	Maximum capacity	150 kg/h (HDPE)
1.8	Automatic feeder and dryer	400 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.	
<b>2</b>	<b>JHE1-20-20 Co-extruder</b>	<b>1</b>
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)
<b>3</b>	<b>Spiral type die</b>	<b>1</b>
3.1	With the function of color striping Pipe diameters	Ø16 – Ø63
3.2	Number of heating zones	8
3.3	Capacity	150 kg/h
3.4	Thermostat for die core	1
3.5	Die cart	1
3.6	Dies for different pipe diameters: 50mm x 4,6 mm, SDR11 50mm x 3,0 mm, SDR17	1 set 1 set

3.7	Ring for 4-color marking	1
3.8	Co-extruder die adapter (is used for 4-color marking)	1
<b>4</b>	<b>STV63 Calibrator</b>	<b>1</b>
4.1	Pipe diameters	Ø16 – Ø63 mm
	Vacuum calibration chamber length	5500 mm
	Total length	5900 mm
	Vacuum pump power	3 Kw
	Water pump power	5,5 Kw
	Water-cooled gauges are made of non-ferrous metals	
	The calibrator is equipped with a spare vacuum pump	
4.2	Tools for HDPE pipes	
	50mm SDR11, SDR17,0	1
4.3	Holders for pipes of different diameters:	
	50	3
4.4	Sealing device (includes sealing board, rubber seal and holders)	
	50	1
<b>5</b>	<b>SC63 spray cooling tanks</b>	<b>2</b>
5.1	Pipe diameters	Ø16 – Ø63
	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
<b>6</b>	<b>R63 twin caterpillar haul-off unit</b>	<b>1</b>
6.1	DC drive power	4 <b>kBT</b>
6.2	Number of caterpillars	2
6.3	Caterpillar position adjustment - pneumatic clamping device	
6.4	Haul-off speed	0,3 – 16 m/min
6.5	Effective haul-off length	1200 mm
6.6	Maximum haul-off force	7.5 KN
6.7	Pipe diameters	Ø16 – Ø63
<b>7</b>	<b>Swarfless Pipe cutting unit</b>	<b>1</b>
7.1	Cutting power	2,2 Kw
7.2	Rotation power	1.5 Kw
7.3	Pipe diameters	Ø16 – Ø63
<b>8</b>	<b>SPS12double station winder(Italian Technology)</b>	<b>1</b>
8.1	Winding diameter	600-1200 mm
8.2	Winding speed	0,5 –20 m/min
8.3	Winding width	300 mm
<b>9</b>	<b>Length metering Ink Jet Printer</b>	
9.1	Metering accuracy	0.3%
9.2	Pipe diameter	10-250mm