

## SHEETMETAL – ENGINEERING – PLASTICS – EARTHMOVING – FORKLIFTS

### TECHNICAL SPECIFICATION

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

#### TECHNICAL DATA OF PE 40-125 PIPE LINE

<b>1</b>	<b>JHE1-60-33B Single screw extruder</b>	
1.1	DC drive power EUROTHERM speed controller	90 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	60 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 8
1.7	Maximum capacity	300 kg/h (HDPE)
1.8	Automatic feeder and dryer	400 kg/h
1.9	Control cabinet Seimens 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	Ø40-125mm
3.2	The die work surface has undergone tempering	
3.4	Capacity	300 kg/h
3.5	Thermostat for die core	1
3.6	Die cart	1

3.7	Dies for different pipe diameters: <b>2 dies made to your specifications</b> Die specification see below page.	1
3.8	Ring for 4-color marking, 6 color marking, 8 color marking	1
3.9	Co-extruder die adapter (is used for 4-color marking)	1
<b>4</b>	<b>STV125 Calibrator</b>	<b>1</b>
4.1	Pipe diameters	Ø40– Ø125 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 Tools for all size between 40mm-125mm pipes.	
4.3	Holder for pipes of different diameters: Holder for all sizes between 40-125mm pipes	
4.4	Sealing device (includes sealing board, rubber seal and holders) Sealing device for all sizes between 40-125mm pipes.	
<b>5</b>	<b>SC125 spray cooling tanks</b>	<b>3</b>
5.1	Pipe diameters	Ø40 – Ø125
	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
5.4	Sealing device (includes sealing board, rubber seal and holders) Sealing device for all sizes between 40-125mm pipes.	
<b>6</b>	<b>R125 twin caterpillar haul-off unit</b>	<b>1</b>
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	0,3 – 10 m/min
6.5	Effective haul-off length	1200 mm
6.6	Maximum haul-off force	7.5 KN
6.7	Pipe diameters	Ø40 – Ø125
<b>7</b>	<b>QG125 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	Ø40 – Ø125
7.4	Shavings collecting device	
8.	Length metering Ink Jet Printer	
8.1	Metering accuracy	0.3%
8.2	Suitable Pipe diameter	10-250mm
8.3	Heating Power	0.3KW
8.4	size	900x520x1450mm
<b>9</b>	<b>Stacker</b>	<b>1</b>
9.1	Stacker length	6000 mm
9.2	Automatic stacking	