

东莞市强辉发泡机械科技有限公司

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QHF-2017-13 Horizontal Continuous Auto-foaming Production Line

Main technique parameters and equipments

(1) The whole machine parts specifications:

- | | |
|--|---|
| 1, Foaming controlling Platform (standard) | L3m×W2.52m×H0.7m |
| 2, Oven declining board (standard) | L6.8m×W0.98m~2.4m |
| 3, Oven side links (standard) | L18m×W2.4m×H1.2m |
| 4, Oven machine frame (standard) | L18m ×W4m×H3m |
| 5, Oven inner conveyer line (standard) | L18m×W2.4m×H0.83m |
| 6, Foam block cutter machine (standard) | W2.4m×H1.30m (knife belt with cross type) |
| 7, R.S Pulling system with plastic | one set |

(2) Main technique specification:

- 1, Dimension: Total length 35m×Total width 4m×Total Height 3m(From the table to the Block cutter)
- 2, Foaming material Group: 13 groups, man-machine interface, both manual and computerized control.
- 3, Foaming width: 980mm~2350mm
- 4, Foaming height: Max 1300mm
- 5, Foaming density: 8Kg/m³~100kg/m³
- 6, Foaming speed: 2000r/min~7000r/min
- 7, Max total output: 300kg/min
- 8, Material spraying way:
 - ① The way of down sprayer head (upper, down, front, back can be adjusted)
 - ② The way of trough overflow pipe.
- 9, Controlling way of foaming:
 - ① PLC controlling, can continuously foaming two different formulas in one time
 - ② All inverter controlling foaming and work in phase with the production line
 - ③ Oven declining board height and width can be adjusted by control box.
 - ④ Oven side links width can be adjusted by control box.
- 10, Mixing-head motor: 37kw
- 11, Total power: About 90kw

(3) Main collocates and material chooses:

1,Material pot types: (The work pressure in the pot is normal pressure)

Type	Use	Specification	Qty
Big material tank	PPG	5m ³ /δ5mmA3 steel plate, with temperature controlling, stirrer, filter system	1
Big material tank	POP	5m ³ /δ5mmA3 steel plate, with temperature controlling, stirrer, filter system	1
Big material tank	PPG + CaCo3	5m ³ /δ5mmA3 steel plate, with temperature controlling, stirrer, filter system	1
Big material tank	TDI	5m ³ /δ5mm A3 steel plate, with temperature controlling, stirrer, filter system	1
Big material tank	Flame retardant	2m ³ /δ3m stainless steel, with filter system	1
Big material tank	MC	2m ³ /δ2mm stainless steel, with filter system	1
Small material tank	Si	180L/δ1mm stainless steel	1
Small material tank	A-33	180L/δ1mm stainless steel, with stirrer system	1
Small material tank	T9	180L/δ1mm stainless steel, with stirrer system	1
Small material tank	H2O	180L/δ1mm stainless steel	1
Small material tank	Color	180L/δ1mm stainless	1
Small material tank	Anti-yellow	180L/δ1mm stainless steel	1
Small material tank	Black	180L/δ1mm stainless steel	1
Floor powder mixing tank	PPG, Powder	1.5m ³ /δ3mmA3 steel plate, with stirrer system	1
Filter tank	PPG, Powder	1.5m ³ /δ4mmA3 steel plate	1

2, Transducer Types

Model	Power/kw	Use	Qty	Brand
FC360	37	Mixing head	1	Danfoss
FC-051P	7.5	POP、PPG+CaCo3	2	Danfoss
FC-051P	5.5	PPG	1	Danfoss
FC-051P	4	TDI	1	Danfoss
FC-051P	2.2	MC , Flame retardant	2	Danfoss
FC-051P	1.5	Black	1	Danfoss

FC-051P	0.75	Water, Ann, Si, Tin, Color , Anti-yellow	6	Danfoss
FC-051P	0.75	Spray head	1	Danfoss
FC-051P	5.5/3.7/1.5	Oven inner conveyer line, side conveyer line, cutting machine	3	Danfoss
FC-051P	7.5	Conveyer belt	1	Danfoss

3, Motor types

Model	Power/kw	Use	Qty	Brand
Y200L-2	37	Mixing head	1	Guangdong
Y132-6 Horizontal	7.5	PPG+CaCo3、POP	2	Guangdong
Y132-6 Horizontal	5.5	PPG	1	Guangdong
Y132-6 Vertical	5.5	Oven inner conveyer line, Terra-tank mixing	2	Guangdong
Y132S-4 Horizontal	4	TDI、Flame retardant	2	Guangdong
Y100-4 Vertical	2.2	Oven side board width	1	Guangdong
Y100-4 Horizontal	2.2	MC , black	2	Guangdong
Y100-6 Horizontal	0.75	Water, Ann, Si, Tin, Color , Anti-yellow agent	6	Guangdong
Y100-4 Vertical	2.2	CaCo3, PPG, POP material mixing	3	Guangdong
Y100-4 Vertical	1.5	TDI Mixing	1	Guangdong
Y100-6 Horizontal	7.5/2.2	PPG, CaCo3 loading	2	Guangdong
Y100-4 Horizontal	2.2	TDI Loading	1	Guangdong
Y100-4 Vertical	1.5	Oven side links	2	Guangdong
Brake motor	0.75/1.5	Knife belt cutting machine running	2	Guangdong

4, Decelerator motor types

Name	kw /speed rate	Use	Qty	Brand
Cycloid gear decelerator	5.5/1:43	Oven inner conveyer line	1	Joint Venture
Cycloid gear decelerator	5.5/1:23	PPG tank mixing	1	Joint Venture
Decelerate motor	0.2/1:25	Oven declining board/ equip the film lift	10	Joint Venture
Cycloid gear decelerator	1.5/1:71	Side conveyer line,	2	Joint Venture

Cycloid gear decelerator	2.2/1:43	Adjust side conveyer width,	1	Joint Venture
Cycloid gear decelerator	1.5/1:23	Synchronized cutting machine running	1	Joint Venture
Cycloid gear decelerator	2.2/1:43	PPG、POP、CaCo3 loading tank mixing	3	Joint Venture
Cycloid gear decelerator	1.5/1:43	TDI, material tank mixing	1	Joint Venture
Cycloid gear decelerator	1.5/1:35	Cutting machine running	1	Joint Venture
Cycloid gear decelerator	0.75/1:23 0.75/1:17	Band knife cutting machine walking	1	Joint Venture

5, Gear pump types:

Model	Specification	Use material	Qty/set	Brand
K124	200L/min	PPG	1	Viking Pump
KK32	200L/min	POP	1	Viking Pump
L32	300L/min	PPG+CaCo3	1	Viking Pump
NB-80	120L/min	TDI	1	Shanghai
NB-32	30L/min	MC	1	Shanghai
NB-32	25L/min	Flame retardant	1	Shanghai
GPY-6	6L/min	Si	1	Japan
GPY-5.8	6L/min	A-33	1	Japan
GPY-5.8	6L/min	T9	1	Japan
GPY-11.5	12 L/min	H ₂ O	1	Japan
GPY-12	12 L/min	Colour	1	Japan
GPY-12	12 L/min	Anti-yellow	1	Japan
GPY-12	12 L/min	Black color	1	Japan

6, Pump of loding material

Model	Specification	Use	Qty/set	Brand
KCB-83.3	200L/min	PPG Loding	1	China
CB-13	200 L/min	POP,PPG+CaCo3 loding	2	China
NB-63	120 L/min	TDI loding	1	Shanghai
NB-32	30 L/min	MC loding	1	Shanghai

KCB-55	25 L/min	Flame retardant loading	1	China
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7, Pneumatic, flow meter equipments types

Model	Pass Caliber	Use	Qty	Brand
K-301L/75DA cross valve	G2"	PPG, PPG+CaCO ₃ , Foam	3	Korea
K-301L/63DA p cross valve	G1"	TDI	1	Korea
K-301L/32DA cross valve	G½"	Other small material, Flame retardant, Anti-yellow	9	Korea
DK800 glass flow meter	20-200 L/h	AIR	1	China
FA10-15 glass flow meter	40~400L/H	H ₂ O	1	China
FA10-25F glass flow meter	150~1500L/H	MC	1	China
FA10-25F glass flow meter	600~6000L/H	TDI	1	
Transducer speed adjusted head	Φ25*2000mm	foam	1	China

8, Electronic control, pneumatic equipments types:

Name	Specification	Qty	Brand
Vertical electric control box, Cutting Machine box, Flow meter box	L2000×W900×H1600mm	3 sets	QHMACH
Man-machine interface	MP277-10.4	1	Japan
PLC	CPU226+EM223	1set	Siemens
AC contactor	3TS-3001-OXMO	19	Schneider
AC contactor	3TF3311-OXMO	1	Schneider
Low pressure high disjunction fuse	RT14-10 (match 6A fuse)	4 sets	China
Middle relay (with seat)	MY4NJ-24V DC	50sets	Japan
Electromagnetism valve	4V210-06	14	Taiwan
AC Contact switch	300A	1	China
Air switch	DE47-63	1	China
Pressure meter		2	China

Electric appliances assistance material		1 group	China
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9, other assistant equipments

Name	Use	Specification	Qty	Factory
Mixing head assembly	Mixing material	Φ110mm	1	Qianghui Machinery
Premixing assembly	Gas, Si mixing	Φ63mm	1	Qianghui Machinery
Cold-hot water machine	Material temperature controlling	Refrigeration 10HP,electro thermal 36kw	1	China
Air compressor	pneumatic	7.5kw/12kg/c m ²	1	China
Filter	''	0.8m ³	1	China
Extraction fans (not included the Exhaust duct)	exhaust	1.5kw	3	China

10, All kinds of valve, pipe and spare parts

No	Item	Material	Specifications	Qty	Amount
1	Produce-line frame, conveyer line	Square tube	100*100*5 etc.	8t	
2	The whole produce-line	Steel	6.3#-16#,4#,5#	1.5t	
3	The whole produce-line oven frame	Steel board	δ3	600kg	
4	Horizontal conveyer line board	Steel board	δ1.5*2200*100	650pcs	
5	''	Links	Pitch100mm	220m	
6	Oven side links conveyer line	Galvanized steel sheet	δ1.2*1220*50	670pcs	
7	''	Links with side round	Pitch 50.8mm	135m	
8	The whole produce-line link board	Steel board	δ3-δ6	1200kg	
9	Oven declining board	MDF	δ20	10pcs	

10	Horizontal conveyer line	Nylon plate	δ10*40	110m	
11	Paper collect frame	Cylinder		2pcs	
12	Declining board frame	Driver roller	Φ76*2400	20pcs	
13	The whole produced-line	Sprocket, gear, screw, even coupling		1set	
14	The whole produced-line	Bearing	UCF210ect	1set	
15	The whole produced-line	Screw	M6-12ect	12000pcs	
16	Before, after paper collected frame	Channel		3sets	
17	Paper release frame			1	
18	Oven head board	Height density fiberboard	δ0.4	60m ²	
19	Straight line guides		Φ25mm*2000mm	1set	
20	No end of paper		Cycle automatically sent cotton		
	Total :				

11. Notes :(Technical Support and Machine Performance)

After the installation of the equipment the buyer assists us to carry out the foaming testing. Both parties are responsible for the on spot testing, in accordance with the high/medium/low density formulas. This equipment mostly produce the British high-slow rebound, shoes slow rebound, electronic cotton, chest mainly cotton, Anti-yellow up to 3-5class meet the international standards, hardness from 20-200 degrees, power add 10% -25%, the lowest density 8-100, all kinds of furniture's sponge, we also can according to the buyer's requirements offer various kinds of formulations.

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