

LSS90/50-1200 Three-layer Co-extrusion Sheet Production Line

Process material: PS、PP

Max sheet width: 900mmadjustable

(layer A -10%, layer B - 80% , layer A - 10%)

Sheet thickness range: 0.25~2.0 mm

Line speed range: 3-20 m/min

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LSS 90 single screw Extruder



Driving motor power:75kw Screw type:Separate type Screw L/D
33: 1 max extrusion capacity:180-200KG/H Heating zone:5 Heating
power: ~40Kw



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LSS50 single screw extruder



Driving motor power :11kw Screw diameter:50mm

Screw L/D 32:1 Screw type: Separate type

Heating zone 4 Heating power: 15kw Cooling zone 4

Dryer of material :Weight of batch for material: 150 kg motor power:18.5kw



Computer control of the whole line: —HMC-II system, **Siemens PLC S7-300 system adopted, 10"color operation panel**, advanced control system internationally

While our competitors not use Simens system or use lower class with less stability and not so durable

Cables: 3 phase ,4 cables

We only use international famous brands for all electrical parts to guarantee the stability working for the extrusion lines





Main electric part supplier:
Inverter of main motor : ABB
Thermo regulating meter: RKC
Contactor: Siemens
Breaker: Siemens
Solid state relay: CELDUC, France



With double –position Hydraulic pressure auto-change sieve plate device 2 sets, one set for 90 extruder, the other for 50 extruder

Sieve plate exchange mode - Hydraulic pressure auto-change sieve plate without stopping machine

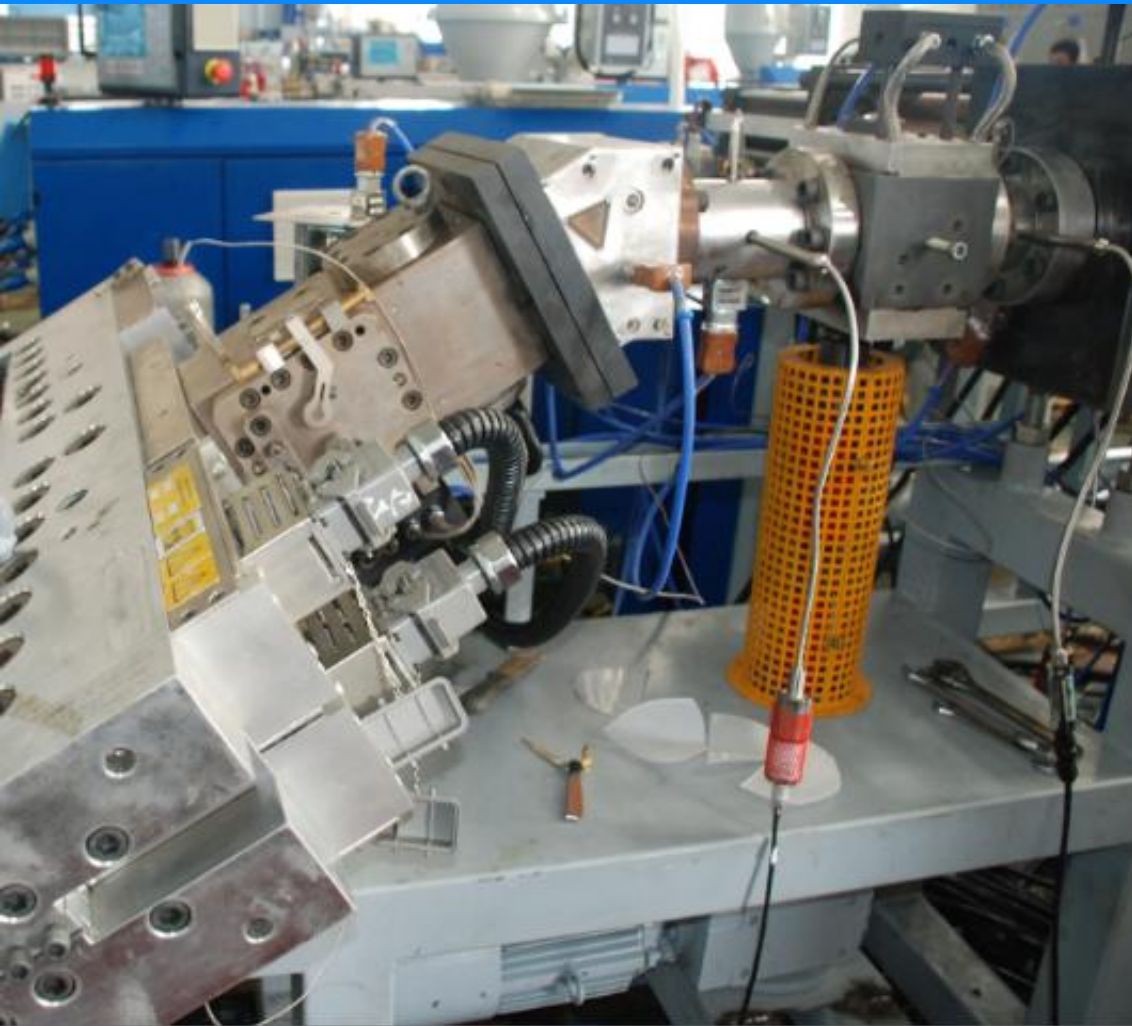
Voltage: 220V

Electric-thermal rod heating power: 4 kW x 2, enclosed wire connection

Sieve plate material 38CrMoA1A ,double position.

Hydraulic pressure control system, composite of Motor, oil pump, oil tank, switch box ,pressure regulator valve ect..

Sealing adopted tin bronze



Melting pump for extruder LSS-90-33

Motor power : 7.5 kW

Motor type: Variable frequency

Speed adjusting mode frequency control of motor speed ABB

Melting pump for extruder LSS-50-32

Motor power: 2.2 kW

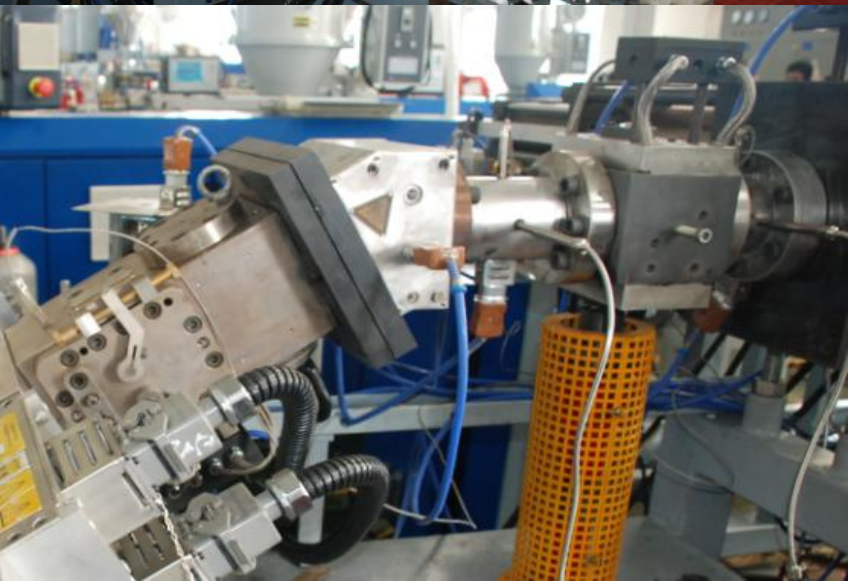
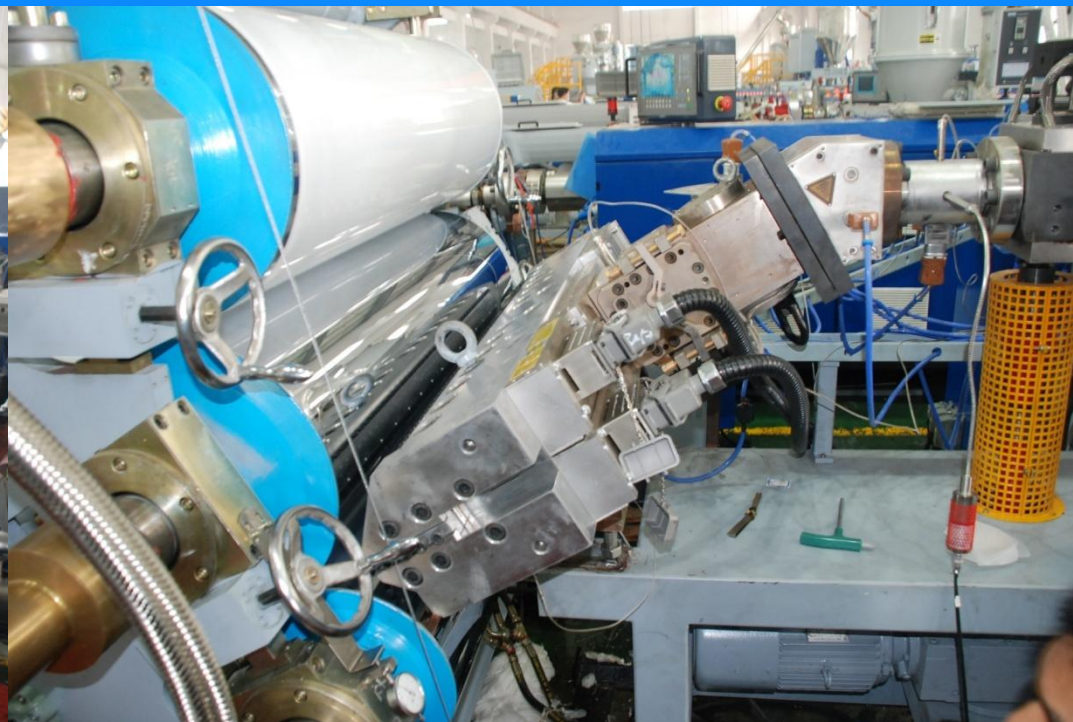
Motor type: Variable frequency

Speed adjusting mode frequency control of motor speed ABB



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T-Mould include co-extruder distributor

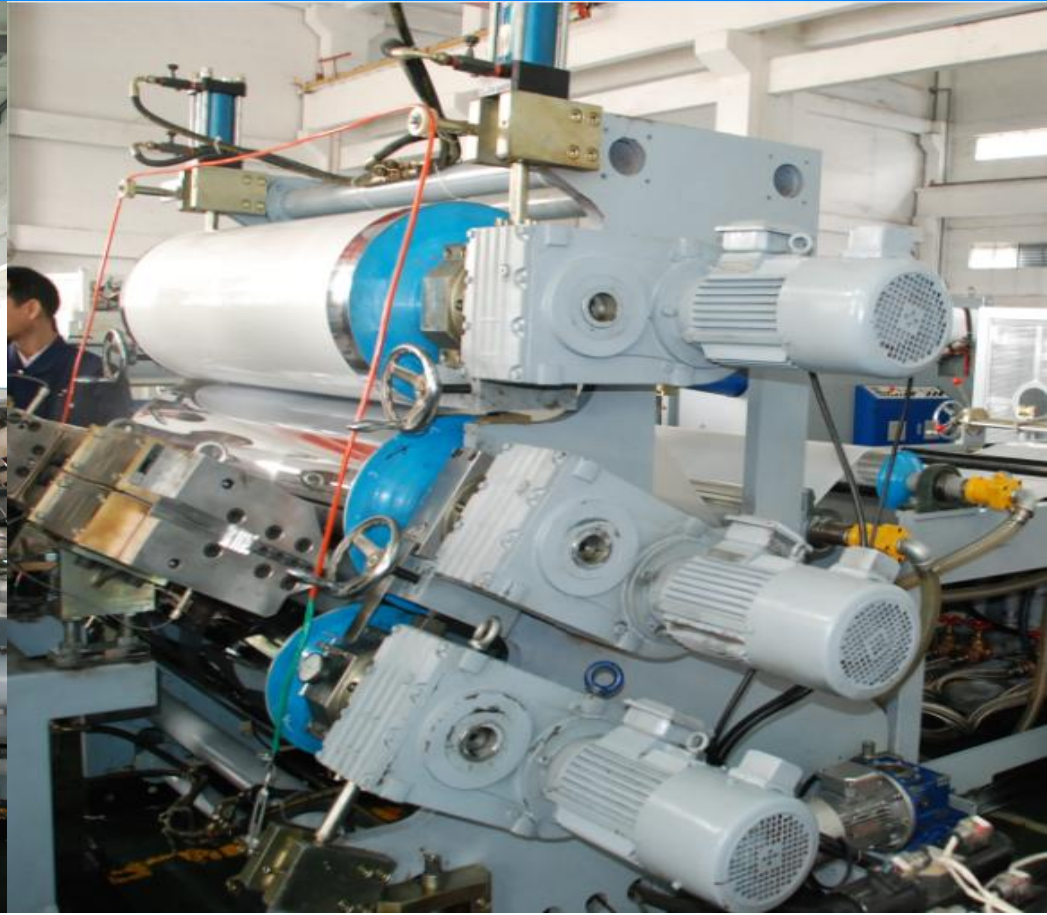


Mode T-type die head cloth rack type – 1 set
 Available width of sheet: min 530 mm – max 900 mm
 For PP, HIPS, GPPS
 Width of die head: 1100 mm
 Have 3 layer distributor, thickness can be adjustable – 1 set
 Mould die set material : 5CrNiMoV steel with hard chrome surface plating, Thickness 0.03 - 0.04 mm
 Method of adjustment for width : Outside plug up
 Adjustable thickness range: min 0.2 mm – max 2.0 mm
 Heating mode Stainless steel heating rod control by 5 sects
 heating voltage 220V, 50Hz, power of each sect: within 4 kW
 W/ bearing under mould

Mode of wire connection: with protecting cap totally enclosed



LIANSU Tri-barrel polishing machine



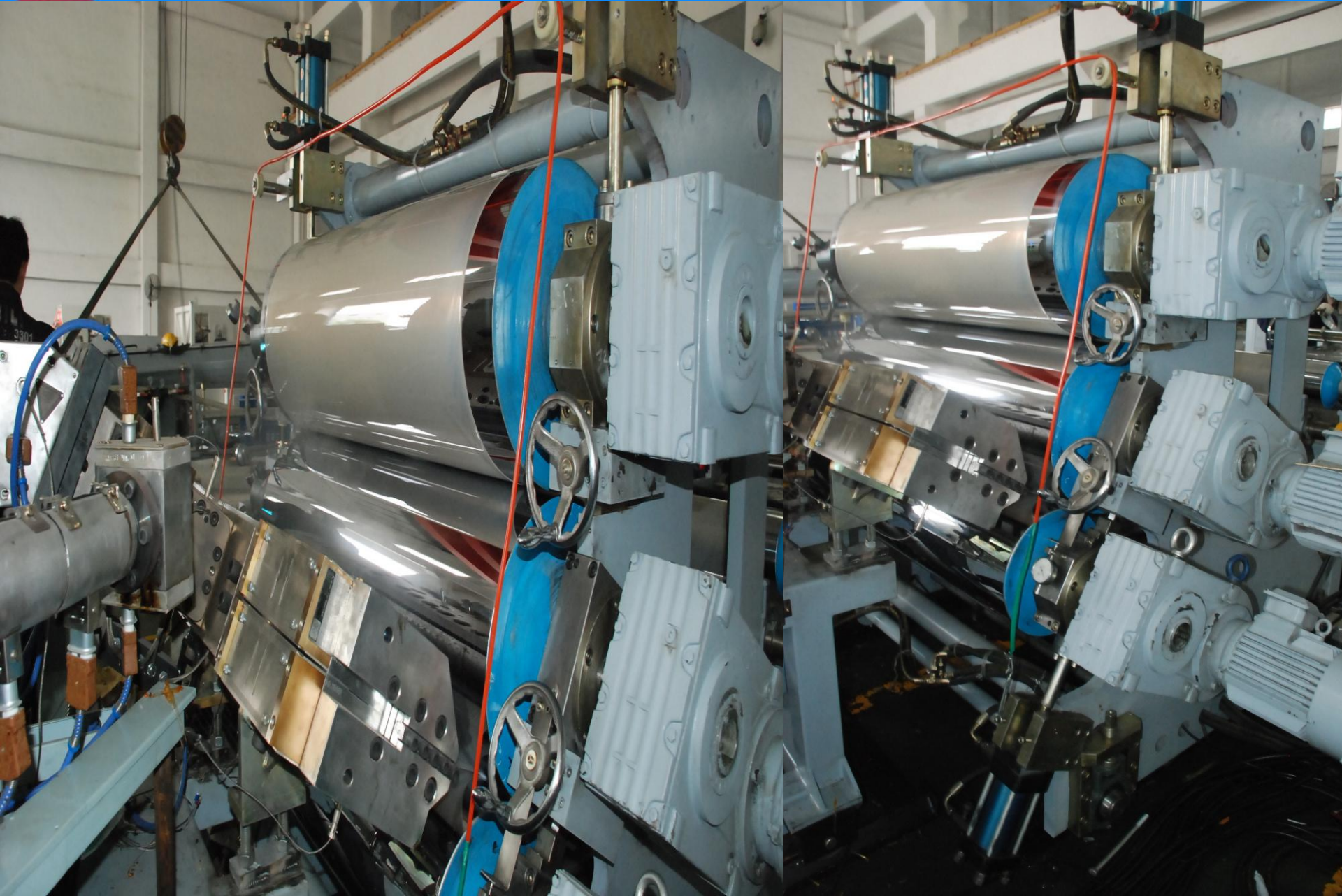
Press roller: Ø 316 mm x 1200 (W) mm,
 rigidit:HRC49-51
 Middle roller: Ø 415 mm x 1200 (W) mm,
 Cooling roller: Ø 415 mm x 1200 (W) mm
 Additional cooling roller Ø 160 mm x 1200 (W) mm
 Roller line speed: V max = 24 m/min
 Cooling medium: oil, Driving motor: 2.2 kW x 3

Precision mirror polishing: 12
 Thickness of chrome: 0.10 - 0.12 mm
 Drive mode inverter
 Type adopt stand tri-barrel mode L type
 W/ hydraulic pressure station motor power: 1.5 kW
 W/Tri roller independent motor with spiral gear box
 Speed adjust: AC motor and Hamsam gear
 Width of polishing rolls: 1200 mm



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Tri-barrel polishing machine





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Three roller heating exchange



Oil circulation temperature control system

Heating power: 3 x 6 kW

Oil pump power: 2,2 kW x 1, 3 kW x 2



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Cooling convey device



Steel roller: \varnothing 80 mm x 1200 mm

Material: aluminium

With movable support frame

Saw motor cutting unit with speed adjustable function





PS sheet With brown color testing 10% cristal GPPS + 90% OPS with HIPS also with brown masterbatch (OPS 60% +40% HIPS)

Edge cutting device: 1set



Hauling rubber roller: \varnothing 205 mm x 1200 (W) mm, 2 pcs

Gap adjust method: air cylinder

Speed: inverter

Motor: 2,2 kW

Haul speed: $V_{max} = 24$ m/min



Waste material winder (Moment motor 2N*M) - 2 Sets

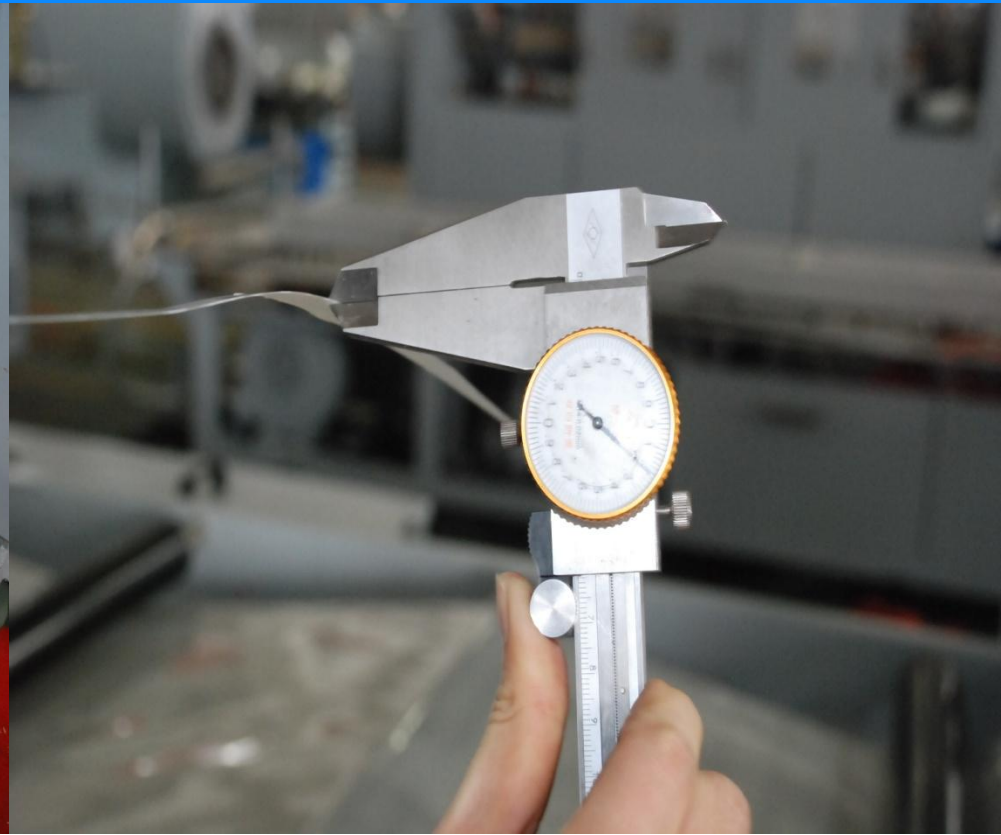


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Double position winding unit



Winding motor ≥ 12 Nm
Change mode: manually
Overturn motor: 3 kW
Thickness for sheet:
0.2-2 mm
Delivered with two shafts
diam. 75 mm
Maximum winding
Diameter: 800 mm
Maximum winding width:
1100 mm



Product specification

Extrusion line produces two types of sheet:

Polymer 3-layers sheet from polypropylene (PP)

Polymer 3-layers sheet from high impact polystyrene (HIPS) sheet

Ranges of sheet width: min 530 mm – max 900 mm

Thickness of Sheet: min 0.2 mm – max 2.0 mm

for HIPS (layer A -10%, layer B - 80% , layer A - 10%)

Thickness of Sheet: min 0.35 mm – max 1.5 mm for PP (layer A -10%, layer B - 80% , layer A - 10%)

For other information of the machine, please refer to the machine specification.

Look forward to a Win-win business

