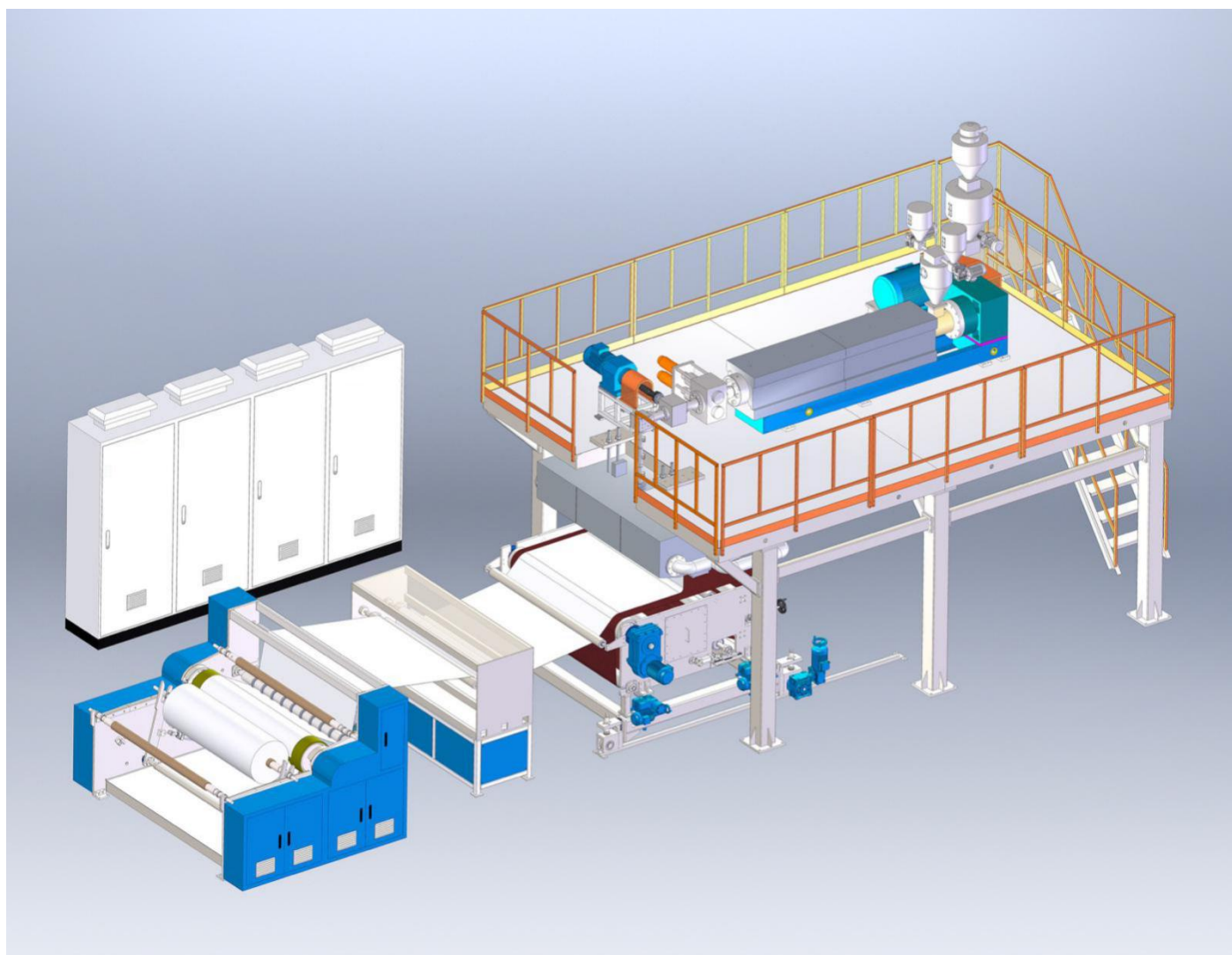


# 1600mm 聚丙烯熔喷法非织造布

## 生产线技术配置

1600mm PP Melt-blown Nonwoven Fabric Production line  
technical configuration



图片仅供参考 / Photo for reference ONLY

## 一、概述 Overview

公司介绍 company introduction :



locating

at Jiangsu zhongguancun technology industrial park, Liyang city, Jiangsu province, a high-tech manufacturer specializing in research and development of plastic extrusion equipment. The factory area is of 400 acres; We have a high qualified R&D and experienced mechanical and electrical engineer team as well as advanced processing foundation and normative assembly shop. Our enterprise spirit is "Attentive, Enduring, Quick and Orderly", keeping on exploring of new extrusion field. Mostly welcome to new and old customers to visit us for investigation, guidance and cooperation. We are happy to offer powerful support!



brands in Chinese plastic machinery industry.

Our customers are all over China, and we have customers in Russia, India, Korea, Indonesia, Middle East, South America, Spain, Italy and other countries and areas. Our machines are well accepted by our customers.

本设备以丙纶熔喷原料为主原料，辅以静电助剂母粒和色母粒等添加剂，生产不同颜色、不同性质以及适应不同用途的丙纶熔喷非织造布。

The equipment uses polypropylene melt-blown raw materials as the main raw material, supplemented with additives such as electrostatic auxiliary masterbatch and color masterbatch, to produce polypropylene melt-blown nonwoven fabrics with different colors, different properties and suitable for different uses.

我们的优势：

目前我们的设备在中国稳定性和做出的产品质量是最好的，因此被国内最大型的生产企业所选用。

原因：

- 1、我们公司二十多年的技术积累，由中国院士带队研发生产的熔喷布机器销往全球，设备稳定，强大的售后技术支持团队给我们的客户提供最大的保障。
- 2.核心部件我们是自己生产加工，加工过程严格把关，保证部件质量。
- 3.产品成熟容易安装和调试。
- 4.提供原材料及配套服务。



5.附送一套核心部件，保证故障产生后能迅速解决恢复生产。

Our advantages:

At present, our equipment has the best stability and product quality in China, so it is selected by the largest manufacturing enterprises in China.

The reason:

- 1, our company more than 20 years of technical accumulation, led by a team of Chinese academicians to research and develop the production of melt-spraying cloth machines are sold to the world, equipment stability, strong after-sales technical support team to provide the greatest protection for our customers.
2. We produce and process the core parts by ourselves, and strictly control the processing process to ensure the quality of the parts.
3. The product is mature and easy to install and debug.
4. Provide raw materials and supporting services.
5. A set of core components is attached to ensure that the fault can be quickly resolved and production can be resumed.

1、使用条件 Conditions of usage	380V/3P/50Hz
2、制品应用 Products application	熔喷过滤材料、口罩过滤材料 Melt Blown Filtration Material, Facial Mask Filtration Materials
3、使用物料 Raw Material	聚丙烯切片原料（熔喷专用料）



	PP chips (special materials for melt-blown) MFI=1200~1800 g/min 推荐1500g/min Recommended 1500g/min
4、制品宽幅 Product width	Width: 1600mm
5、产品克重范围 Product gram weight range	25-80g/ m <sup>2</sup>
6、挤出能力 Extrusion capacity	1-1.5吨/24小时, 随着产品克重的变化, 生产线产能有相应变化 (1-1.5 tons/24 hours, as the product gram weight changes, the production line capacity changes accordingly)
7、最高机械速度 Max. mechanical speed	0-50m/min
8、纤维细度 Fiber fineness	2-5μm
9、装机功率 Installed power	约 560KW About 560KW

<b>二、设备清单 Equipment List</b>	
1、自动配料上料装置 Automatic Dosing & Feeding Unit	1 台 / 1 unit
2、螺杆挤出机 Screw Extruder	1 台 / 1 unit
3、换网器 Screen Changer	1 台 / 1 unit
4、计量泵 Metering Pump	1 台 / 1 unit
5、熔体管道 Melt Distribution Pipes	1 台 / 1 unit
6、组合式熔喷模头 Die Assembly	1 台 / 1 unit



7、工艺热空气系统 Heated Air System	1 台 / 1 unit
8、空气加热机 Air Heat	1 台 / 1 unit
9、抽吸风机 Exhaust/Suction Fan Blower	1 台 / 1 unit
10、连接风管 Connecting Air Duct	1 台 / 1 unit
11、成网机 Web-forming Collector	1 台 / 1 unit
12、驻极处理系统 Electret Processing Equipment	1 台 / 1 unit
13、收卷机 Winder	1 台 / 1 unit
14、电器控制系统 Electric Control System	1 台 / 1 unit
15、熔喷模头清洗装置 Melt blown Die head Cleaning unit	1 台 / 1 unit
16、备品备件 Spare parts	若干 / Several

### 三、详细技术配置 Detailed Technical Specifications

#### 1、自动配料上料装置 Automatic Batching, Measuring and Dosing Unit

原料温度 Raw Material Temperature	所有原料常温 80 度以下 All material below 80 °C
原料性质 Material Type	所有原料为颗粒状 Pellets
安装位置 Installation Location	挤出机下料口上方 Above the feed opening of the extruder
配比能力 Matching ability	组份Component 1: 100% 组份Component 2: 1~50% 组份Component 3: 0.5~3%



真空上料系统 Vacuum feeding system	1套 1set
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<b>2、螺杆挤出机 Screw Extruder</b>	
螺杆机筒 Screw and Barrel	
材质 Material	38CrMoAlA
渗氮深度 Nitride Layer Thickness	0.5-0.7mm
螺杆硬度 Screw Hardness	HV>=740
机筒硬度 Barrel Hardness	HV>=940
长径比 L/D Ratio	30:1
螺杆直径 Screw Diameter	90mm
机筒加热区 Barrel Heating Zones	5 区 5 section
总加热功率 Total Heating Power	约 35KW About 35KW
加热方式 Heating Mode	铸铝加热 Cast Aluminum
<b>驱动 Driving Motor</b>	
电机 Motor	交流电机 AC
变频器 Converter	汇川品牌 Inovance Brand
电机功率 Power	45KW
减速箱 Gearbox	
箱体材质 Case Material	QT200
齿轮形式 Gear Type	斜齿轮 Helical Gear
齿轮材质 Gear Material	20CrMnTi



齿轮表面热处理 Gear Heat Treatment	齿面淬火 Quenching
推力轴承 Thrust Bearing	国产优质轴承 High quality bearing
润滑系统 Lubricating System	压力润滑系统 Pressure Lubricating System
冷却系统 Cooling System	内冷却和强制循环冷却 Internal cooling and forced circulating cooling
转速 RPM	20-80r/min
机筒外面带保温外罩 External Heat Insulating Cover on Barrel	
<b>3、换网器 Screen Changer</b>	
结构形式 Structure	双工位柱式 Double Column Double Position Type
换网驱动 Screen Changer Drive	液压系统驱动, 手动控制 Hydraulic System, Manual Operation
加热方式 Heating method	内置式加热棒加热 Built-in heating rod heating
温度测量 Temperature measurement	K 型热电偶 K type thermocouple
压力传感器 Pressure Sensor	SAND Brand
<b>4、计量泵 Measuring Pump</b>	
规格 Specification	50CC
驱动电机 Driving Motor	美国 FALK 品牌变频减速电机 FALK Inverter Control Reducer Motor
速度控制 Speed control	丹佛斯品牌变频器 Danfoss Brand Inverter Control
驱动电机功率 Driving Motor Power	3 KW





加热方式 Heating Mode	内置式不锈钢加热棒加热 Built-in stainless steel heating rod for heating
压力测量 Pressure measurement	熔体计量泵前配意大利杰弗伦品牌压力传感器，闭环控制挤出机的转速，保持挤出量的稳定；计量泵后配成都先达品牌的压力传感器，显示计量泵输出压力 The melt metering pump is equipped with GEFTRAN Brand pressure sensor from Italy, which controls the rotational speed of the extruder in a closed loop to maintain a stable extrusion volume; the metering pump is equipped with SAND brand pressure sensor to display the metering pump output pressure
<b>5、熔体管道 Melting Distribution Pipes</b>	
材质 Material	无缝不锈钢钢管 Seamless Stainless Steel Pipe
加热方式 Heating Mode	采用加热圈加热 Heating with heating ring
<b>6、组合式熔喷模头和喷丝板 Combined melt-blown die head and spinneret</b>	
模体总长 Die Head Length	1940mm
模头有效出料长度 Effective discharge length of die head	1702mm
加热功率 Heating power	约16KW About16KW
喷丝孔直径 Diameter of spinneret	0.30mm
喷丝孔长径比 Spinneret ratio	10: 1



喷丝板数量 Number of spinnerets	1套 1 set
喷丝板将溶体转变成细流，经高温高速气流牵伸后形成超细纤维 The spinneret transforms the melt into a fine stream, which is formed into ultra-fine fibers after being drawn by a high-temperature and high-speed air stream	
<b>7、工艺热空气系统 Heated Air Manifold System</b>	
罗茨鼓风机型号 Roots blower model	3L53WC
升压 Boost	70Kpa
进口流量 Flow	38.3m3/min
功率 Power	75KW
罗茨风机 Roots blower	提供高压空气，以使牵伸空气的速度达到工艺要求的范围， 通过变频器，可以方便改变罗茨风机输出的空气流。 Provide high-pressure air to make the speed of the drafting air reach the range required by the process. Through the inverter, the air flow output by the Roots fan can be easily changed.
<b>8、空气加热机 Air Heater</b>	
加热功率 Air Heater	230KW
输送管道材质 Tank and airflow pipe	不锈钢 Stainless Steel
保温形式 Heat Insulation Mode	外包保温层 Outsource insulation
空气加热罐 Air heating tank	将罗茨风机输出的空气进行加热，以达到工艺要求的温度 Heat the air from roots fan to reach the required temperature
<b>9、抽吸风机 Suction Blower</b>	



抽吸风量 Suction air	17000-30000m <sup>3</sup> /min
风压 Wind pressure	3KPa
功率 Power	75KW
<b>10、连接风管 Connecting Air Duct</b>	
材质 Material	镀锌风道 Galvanized air duct
<b>11、成网机 Web-Forming Collector</b>	
线速度 Line speed	0-50m/min
网帘材质 Web Curtain Form	PA材质 PA material
网带宽度 Width	1500mm
喷丝调节距离 Spinning adjustment distance	80-300mm
安装形式 Installation Mode	水平移动 Horizontal Moving
驱动功率 Drive rate	5.5KW
<b>12、驻极处理设备 Electret Treatment Equipment</b>	
输入电压 Input Voltage	220V/50HZ
最高输出电压 Max. Output Voltage	50KV
处理宽度 Treatment Width	1300mm
<b>13、收卷机 Winder</b>	
线速度 Line speed	0-50m/min
切边装置 Side Trimming Device	8 把圆刀 8 round knives
传动功率 Transmission power	电机 7.5KW Motor7.5KW
气胀轴 Expanding Axle	纸管内芯 3 英寸 Paper core 3 inch
<b>14、电器控制系统 Electric Control System</b>	



操作屏 Screen	西门子品牌 Siemens brand
PLC	西门子品牌 Siemens brand
变频器 Converter	汇川品牌 Inovance brand
接触器 Contactor	西门子品牌 Siemens brand
继电器 Relay	欧姆龙品牌 Omron brand
低压断路器 Low Voltage Breaker	ABB或 LS、正泰品牌 ABB or LS, SAND brand
空气开关 Air Switch	施耐德或ABB、LS 品牌 Schneider or ABB, LS brand
按钮、开关指示灯 Push Button, Indicator	施耐德 Schneider brand
<b>15、熔喷板清洗装置 Die Head Washing Unit</b>	
煅烧炉 Calciner Dimension (Φ600×2200、15KW)	一台 1 Set
超声波清洗机 (3kw)	一台 1 Set
<b>16、备件清单 Spare Part</b>	
挤出机加热圈 Extruder Heating Ring	1 件 1piece
热电偶 Thermal Couple	5 件 5 pieces
螺杆拆卸工具 Screw Dismantling Tools	1 套 1 set
电磁阀 Solenoid Valve	2 个 2 pieces
接触器 Contactor	2 个 2 pieces
继电器 Relay	2 个 2 pieces
空气开关 Air Switch	2 个 2 pieces
换网器加热棒 Screen changer Heating rod	6 个 6 pieces
计量泵加热棒 Metering heating rod	4 个 4 pieces



刀片 Knifes	10 个 10 pieces
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#### 四.服务承诺 After Sales Service

<p>1. 向定做方派技术人员安装、调试设备。</p> <p>1. Send technicians to install and debug the equipment.</p>
<p>2. 定做方根据提供的地基安装图，自备辅助设施,做好设备安装的前期准备工作，并积极配合承揽方人员的工作。水、电、气路根据安装图的要求铺设至指定位置，备齐生产所需的所有材料。</p> <p>2. The custom-made party prepares auxiliary facilities according to the provided foundation installation drawings, prepares for the preliminary installation of equipment, and actively cooperates with the work of the contractor's personnel. The water, electricity, and gas lines are laid to the designated location according to the requirements of the installation drawings, and all materials required for production are prepared.</p>

#### 五.商务 Business

1、交货时间 Delivery time	<p>合同生效后30天加工完成</p> <p>30 days after the contract takes effect</p>
2、运输方式 Transport	<p>承揽方代办运输，运费由定作方承担</p> <p>The contractor undertakes the transportation, and the freight shall be borne by the ordering party.</p>
3、付款方式 Terms of payment	<p>预付80%合同生效，发货前全款付清</p> <p>80% down payment by T/T, 20% balance payment</p>



	before shipping by T/T.
4、质保期 Warranty	12个月 12 months
5、设备价格 Equipment prices	