

BEIER MACHINERY CO., LTD

Soft PVC Regrind Flake Strand Pelletizing Line

(Capacity: 500kg/hr)



(The picture is only for reference)

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Thank you very much for your inquiry. We are pleased to offer you the following based on our enclosed terms and conditions of delivery and sale.

1. Project evaluation: For the production of SPVC pellets from regrind flake at 500 kg/hr.

1.1. General information:

Raw material & formulation	Soft PVC Regrind flake, including some TPO & TPU 1. Humidity: less than 1% 2. Clean grind flake Particle size: Φ 8-14mm 1.27 g/cc melt density Minimum bulk density of 35 lbs./cu.ft.
Final product & Melt capacity	SPVC pellets at 500kg/h (depending on the feedstock)
Central height	1m
Operation direction	From right to left (face to the operation panel)
Machine color	Standard color: RAL7016 (Anthracite grey) ; RAL9002 (Grey white)
Picture of the final product	

1.2 Work conditions provided by the customer at the installation site.

Warehouse/Workshop	Construction of foundations, construction works, earthworks, and wall works. Supply of cranes, fork-lifts or other lifting equipment. Mounting materials and tools Dimension: 22m (length) x3.5m (width) x3.5m (height)
Temperature & Humidity	$\leq 40^{\circ}\text{C}$,
Power supply	460V/3-Phase/60Hz
Wire/cables/water:	Wires/cables: From the power supply to the control cabinet of this production line. All electrical cables from the control cabinet to each machine. Water: Supply water to the machines and reservoirs.
Cooling Water	Without dissolved or suspended minerals as phosphor,

	<p>sulphur, iron, etc.</p> <p>Inflow temperature T1: max. 15°C;</p> <p>Outflow temperature T2: T2=T1+5°C;</p> <p>Hardness: 5-8 °dH;</p> <p>Reflux: without pressure</p>
Lubrication oil:	Exxon mobile
Compressor	Supply compressed air
Ancillary staff	1 Person

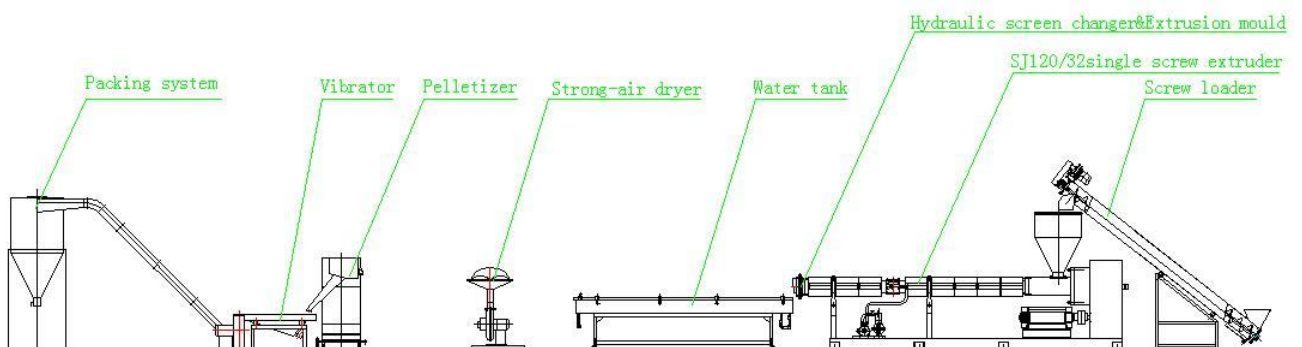
1.3 Energy consumption

Installation power	Peak: 246 KW. Operating power consumption: 80%
Cooling Water	1M³/hr
Vacuum	-0.095MPa

1.4 Commercial terms

Project	Soft PVC strand pelletizing line
Payment terms	50% down payment by W/T 50% by W/T before delivery and after inspection & trial
Delivery time	90 days from the date of receiving the down payment
Packing	Wood pallet covered by plastic film
Warranty period	13 months from the date of the bill of lading

1.5 Flow line picture



1.6 Machinery list and price:

No.	Name	Qty.	Price (\$)
1	Screw loader	1set	
2	SJ120/24 single screw extruder with an Xaloy designed and manufactured screw	1set	
3	Hydraulic screen changer & strand die	1set	
4	Water cooling tank	1set	
5	Strong-air dryer	1set	
6	Pelletizer	1set	
7	Vibrator/pellet screener	1set	
8	Packaging system	1set	
Total EX Works INCOTERMS 2000			
Inland transportation cost to Shanghai port (1×40'GP)			
Packing cost			
Total FOB Shanghai port			



Remarks:

1) If a PLC is required for the extruder and line control, add:


2) Beier Machinery will set-up the complete extrusion line for testing, before shipment to the customer. All costs relating to the test materials and compounds are the responsibility of the customer.

2.1 Technical data

Item	Machine	Photo of machine	Technical specifications
1	Screw loader		<p><i>Flake feeding</i></p>
		<p>Motor power: 3KW Part contacting the raw materials: stainless steel ABB or HITACHI frequency inverter control</p>	
2	SJ120/24 single screw extruder		<p><i>Barrel:</i> <i>Drive motor:</i> <i>Venting system:</i> <i>Electric cabinet:</i> <i>Self protection system:</i></p> <p>Barrel: Inner processing: nitride with thickness: 0.4 ~ 0.7mm Heating zones: 6pcs, Heating power: 57KW Heater: Cast Aluminum+ stainless steel covering Cooling air fans: 0.37KW × 6sets Designed Screw: Xaloy designed and manufactured Efficient barrier screw with a spiral UCC mixer, an offset removable nose and bored for screw cooling. Made from 4140HT base material, Colmony 56 weld on the flight lands and .001” chrome plate.</p> <p>Drive motor: Motor power: 160KW, AC motor</p> <p>Electrical cabinet : UL approved components Frequency converters: ABB inverter Contactors: Schneider Air Switches: Schneider Relays: Omron Temperature controllers: RKC or Omron</p>

		<p>Self protection system: Over current protection of the motor Over pressure protection of the screw</p>
3	<p>Hydraulic screen changer & die head</p>	<div style="display: flex; justify-content: space-between;"> <div style="width: 30%;">  </div> <div style="width: 65%; text-align: right;"> <p><i>Polymer filtering</i></p> </div> </div> <p>1. Screen changer (polymer filtering) Screen changer has melt pressure and temperature transducers Maximum pressure: 15MPa Decompression valve protection system Heating power: 8KW Oil pump power: 2.2KW</p> <p>2. Die head—Strand type Die material: 38CrMoAlA Number of strands: To be determined</p>
4	<p>Water tank</p>	<div style="display: flex; justify-content: space-between;"> <div style="width: 30%;">  </div> <div style="width: 65%; text-align: right;"> <p><i>Strand cooling</i></p> </div> </div> <p>Tank length:5000mm Basic material: stainless steel</p>

<p>5</p>	<p>Strong-air dryer</p>		<p><i>Strand drying</i></p>
		<p>Motor power: 3KW Part in contact with the pellets: Stainless steel</p>	
<p>6</p>	<p>Pelletizer</p>		<p><i>Strand cutting</i></p>
		<p>Motor power: 5.5KW Speed controlled by ABB or HITACHI frequency inverter Material of the rotary blades: High-quality alloy steel</p>	
<p>7</p>	<p>Vibrator</p>		<p><i>Pellet screening</i></p>
		<p>Motor power: 0.2KW X2 Part in contact with the pellets: Stainless steel</p>	

8	Packaging system		<i>Final product packaging</i>
	<p>Loading blower: Motor power: 4KW Material of the conveying pipeline: Stainless steel.</p> <p>Silo: Material of the storage silo: Stainless steel Silo frame: carbon steel Volume of silo: 1.25m³</p>		

2.2 Spare parts included in this quotation

No.	Name	Qty.	Application
1	Cutting blade	1set	Pelletizer
2	Pressure sensor	1pc	Die
3	Thermocouples	2pcs	Barrel
4	Oil seal for the gearbox frame	1pc	Gearbox
5	Low voltage circuit-breaker, small AC contactor	One for each	Electric cabinet

3. After-sales service

3.1 Technical documents

All labels on machines and lay-out drawings, electrical diagrams and user manuals, will be in English.

3.2. Arrangement for inspection, installation and testing

- a. After all the ordered equipment has been delivered to the customer's factory; the Buyer is responsible for all preparation work, e.g. electrical supply, water supply, labor and cranes, etc.
- b. BEIER will prepare visa applications for their engineers, who are responsible for the supervision of the machine installation and testing at the Buyer's factory.
- c. The Buyer will buy a round-trip air ticket for the engineers, if the visa application is approved. The buyer is also responsible to bear expenses generated, e.g. visa formalities, meals, accommodation and an allowance of USD125.00 per day for each engineer.
- d. Engineers will give free training to personnel in the buyer's factory.
- e. If the buyer does not request installation and commissioning by the Seller's engineers within four months from the date of the bill of lading, it will be taken that all the supplied equipment has been successfully tested by the buyer.

3.3. Quantity and quality guarantee

a. Quantity/Quality Discrepancy to destination port during transportation:

In case of quality/quantity discrepancies to the destination port the customer should file claims within 30 days from the arrival of the goods at their destination. The insurance company and the shipping company will be responsible for any discrepancies or product damage caused by the shipping company or other transportation organizations.

b. Guarantee period and after-sales services: 13 months from the date of the bill of lading.

During this guarantee period, BEIER will provide spare parts at no charge in cases of quality discrepancy caused by us. If the malfunctions are caused by incorrect operation of the equipment, BEIER will provide the buyer spare parts at cost price.

c. Long-term service:

BEIER will charge the buyer cost price of spare parts beyond one year and provide long-term technical guidance.

3.4. Validity: Three months from the quotation date.

Kind Regards,

Rich Kim

Beier Machinery Co., Ltd.