

BEIER MACHINERY CO., LTD PE Dual Pipe Extrusion Line (G2)

(Pipe Diameters: 20-50mm)



(All pictures are 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 general terms and conditions of delivery and sale.

1. 1. Project evaluation: : A complete dual pipe extrusion line for the production of PE gas pipe from 20mm – 50mm to SDR17.6 and SDR 11 and ISO 4437:1997(E).

1.1 General information:

Raw material & formulation	Grades of PE for gas pipe production
Melt capacity	Maximum: 380 kg/h (depending upon pipe dimension and the material)
Central height	1000 mm
Haul-off speed	Max: HDPE $\geq 25\text{m/min} \times 2$; PP-R $\geq 15\text{m/min} \times 2$
Number of color stripes	1 or 2
Operation direction	From right to left (face to the operation panel)
Machine color	Standard color: RAL7016 (Anthracite grey) ; RAL9002 (Grey white)
Final product	

Pipe specifications and sizes:

No.	O.D. (mm)	Wall thickness	Wall thickness
1	20	SDR17.6	SDR11
2	25	SDR17.6	SDR11
3	32	SDR17.6	SDR11
4	40	SDR17.6	SDR11
5	50	SDR17.6	SDR11

1.2 Work conditions (Provided by the customer at the production site)

Warehouse/Workshop	<p>Construction of foundations, construction works, earthworks, and wall works.</p> <p>Supply of cranes, fork-lifts or other lifting equipment. Mounting materials and tools.</p> <p>Dimension: 40m (length) × 2.5m (width) × 2.5m (height)</p>
Temperature/ Humidity	0-35°C / ≤95%,
Power supply	460/3/60
Wire/cables/water hose	<p>Wires/cables: From the power supply to the control cabinet of this production line and all electrical cables from the control cabinet to each machine.</p> <p>Water hose: Supply water to machines and reservoirs.</p>
Cooling Water	<p>Without dissolved or suspended minerals as phosphor, 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 OdH;</p> <p>Reflux: without pressure</p>
Lubrication oil	Exxon mobil
Compressor	Supply compressed air
Ancillary staff	1 Person

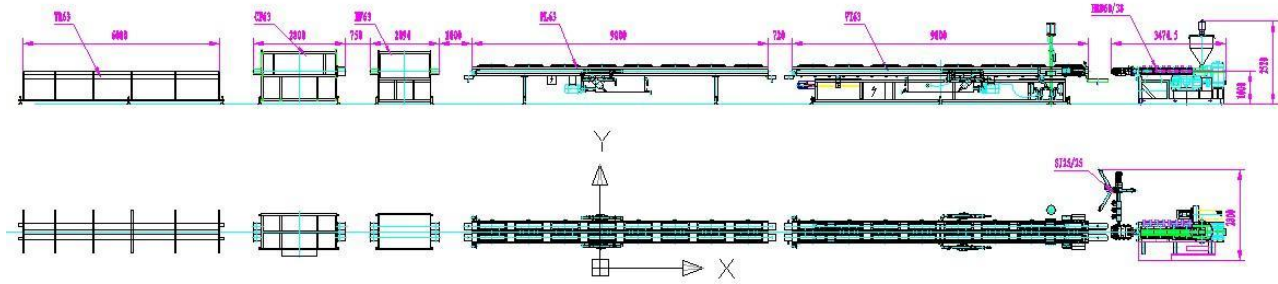
1.3 Energy consumption

Installation power	195KW (Production power consumption: 80%)
Cooling Water	10 M ³ /hr
Compressed air	0.6m ³ /min, 0.4~0.8Mpa

1.4 Main commercial terms

Project	PE dual gas pipe production line (20-50mm)
Price in US dollars List Price	FOB Shanghai INCOTERMS 2000
Payment terms	<p>50% down payment by W/T</p> <p>50% by W/T before delivery and after inspection/trial</p>
Delivery time	90 days from the date of receiving the down payment
Packaging	Wood pallet covered by plastic film
Warranty period	13 months from the date of the bill of lading

1.5 Flow line and configuration



1.6 Machinery list and price:

No.	Name	Qty.	Price (USD)
1	Vacuum feeder	1set	
2	BRD60/38 single screw extruder (PLC system)	1set	
3	SJ25/25 Co-extruder	1set	
4	Die head	1set	
5	Disk vacuum calibrator	1set	
6	BR-VT/63/9Vacuum tank	1set	
7	BR-SB/63/9 Spray cooling tank	1set	
8	BR-HC/63/2 Haul-off	1set	
9	BR-CF/63 chip-free cutter	1set	
10	BR-TB/63 Tip table	1set	
Total amount EX works INCOTERMS 2000			
Inland freight cost to Shanghai port (1*40'GP+1*20'GP)			
Packaging cost			
Total FOB Shanghai port			

Remarks:

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. Technical data

2.1 PE dual gas pipe production line (20-50mm)

No.	Name	Photo of machine	Technical specifications
1	Vacuum loader		<p>Capacity: 300kg-400/hr Motor power:2.2KW Hopper : stainless steel</p>
2	BRD60/38 grooved fed throat extruder	 <p>Screw: Screw diameter: $\Phi 60\text{mm}$ L/D ratio: 38/1 Screw material: 38CrMoAlA Surface finish: $Ra \leq 0.8\mu\text{m}$ Surface treatment: Nitride processing to a thickness: 0.6mm, Hardness:860HV Polished</p> <p>Barrel: Barrel material: 38CrMoAlA Inner processing: Nitride with a 3h thickness: 0.4~ 0.6mm Inside finish: $Ra \leq 1.6\mu\text{m}$ Heating zones: 5 Electric Heaters: Cast aluminum with stainless steel covering Heating power: 22kw Cooling power: 0.25KWx5 zones Cooling: Air blow</p>	<p>Melt capacity:300-400kg/h</p>

		<p>Drive motor: Motor power: AC 110KW</p> <p>Electrical cabinet: Speed regulators: Eurotherm (Parker) PLC for extruder and extrusion line control: Siemens 10.4" screen Air Switches: LG Relays: Omron Temperature controller: Siemens, control precision: $\pm 1^{\circ}\text{C}$ With melt pressure transducer</p> <p>Self protection system: Over current protection of the motor Over temperature protection of the motor Over pressure protection of the screw</p>	
<p>3</p>	<p>SJ 25/25 Striping Co-extruder</p>	<div data-bbox="501 875 922 1272" data-label="Image">  </div> <p>Screw: Screw diameter: 25mm L/D: 25:1 Screw material: 38CrMoAlA. Surface treatment: Nitride with a thickness: 0.4~0,7mm, Polished</p> <p>Barrel: Barrel material: 38CrMoAlA Inner processing: Nitride with a thickness: 0.4 ~ 0.7mm Heating zones: 2 zones Heating mode: Cast aluminum with stainless steel covering Heating power: 1.2KW×2 =2.4KW Cooling power: 0.04KW×2 =0.08KW Method of cooling: air blow</p> <p>Drive motor: Motor power: AC 1.5KW</p>	<p>Melt capacity: 1-2kg/h</p>

			<p>Including pipe die head & calibrators</p>
<p>4</p>	<p>Die Head</p>	<p>Material: Body: Made from 40Cr. Inner surface is polished Calibration sleeve: copper Heating power: 9.5KW</p> <p>Diameter specifications: Φ20, 25, 32, 40,50, 63mm</p> <p>Calibrators: One for each size.</p>	
<p>5</p>	<p>Disk vacuum calibrators</p>	 <p>Water cooling system Easy to check the pipe roundness through the glass cover</p>	<p>Dual pipe calibrators</p>
<p>6</p>	<p>Vacuum Calibration tank</p>		<p>Tank body & structure Water supply system Electrical cabinet</p>

		<p>Dimensions: Length: 9000mm</p> <p>Vacuum pump: Power: 3KW x2pcs.</p> <p>Water pump: Power: 7.5KW x 2pcs</p> <p>Three direction adjustment: Forward and Back ward : 1000mm motor power 0.55KW Up and down: ±50mm manual screw adjustment Left and right : ±50mm manual screw adjustment</p> <p>Material of the inside pipe holders Nylon rollers</p> <p>Tank material: Main body: Stainless steel, Front/back sealing device: silicon seal Water level adjustment: stainless steel floating ball Water temperature adjustment: expansion valve Pipeline: Galvanized pipe with stainless steel valve connections Sprayers: ABS.</p> <p>Large capacity water filter</p> <p>Expansion valve instead of a solenoid valve</p> <p>Flux control gauge ensures even and precise cooling for the calibrators.</p> <p>High level water box ensures a stable water supply</p>
7	<p>BR-SB/63/9 Spray cooling tank</p>	<div data-bbox="424 1256 995 1675" data-label="Image">  </div> <div data-bbox="1011 1256 1457 1675" data-label="Text"> <p>Tank body & structure Water supply system Electric cabinet</p> </div> <p>Dimensions: Length: 9000mm</p> <p>Tank Material : Main body: Stainless steel, Front/back sealing device: silicon seals Water level adjustment: flooding Water temperature adjustment: thermo-mechanical valve Sprayers: ABS.</p>

		<p>Pipe holders Nylon roller or nylon plate</p> <p>Water pump: Power: 7.5KWx 2pcs. Large capacity water filter</p>
8	<p>BR-HC/63/2 Dual Haul-off</p>	 <p>Basic structure & Electric cabinet</p> <p>Pipe range: 20-63mm Claw effective length: 1000mm Maximum traction force: 2000N Traction speed: 1-25m/min. Motor power: 0.75KW x 2pcs</p>
9	<p>BR-CF/63 Chip-free cutter</p>	 <p>The blade rotates around the pipe and cleanly cuts-off the pipe. Quiet operation. PLC controlled. Motor power: 1.5KW*2 Maximum thickness cut: 18mm</p>
10	<p>BRD-TB/63 Tilt table</p>	 <p>Length: 6000mm Cylinder delay controlled or Moving plate method. Easy for pipe packing.</p>

2.2 Spare parts included

No.	Name	Qty.	Application
Machine parts:			
1	Oil seal	1 pc.	Gearbox high-speed shaft
2	Screw unload tool	1 set	Unloading the screw
3	Calibration sleeve sprayers	5 pcs.	Calibration sleeve
4	Seal	10m	Vacuum tank and spray tank
5	Sprayer	40 sets	
6	Blades	2 pc.	Cutter
Electrical parts:			
1	Thermocouples (3m)	3pcs.	Extruder
2	Vacuum meters	2 pcs.	Vacuum tank
3	AC contactors	2 sets	Electrical cabinet
4	Small circuit breakers	2 sets	

2.4 Equipment not included in the quotation

No.	Spare part	Qty.	Application
1	Electric heaters	1pc	Barrel
2	Electric heater bands	1set	Die head
3	Cast aluminum heaters	1 set	Extruder
4	Pipe Printer	1set	Printing information of the pipe producer

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,

Beier Machinery Co., Ltd.