

# BEIER MACHINERY CO., LTD

## PVC Pipe Production Line

*(Pipe Diameters: 10"-24")*



*(The picture is only for reference)*

---

**No.32 Zhenxing Road, Zhangjiagang City, 215600, Jiangsu Province, China**

**Contact person:**

**Website: [www.beieramerica.com](http://www.beieramerica.com)**

---

**In: Canada, U.S.A. & Mexico**


**Contact person: Fraser Reid**

**Tel: 773-234-3795 E-Mail: [Fraser@beieramerica.com](mailto:Fraser@beieramerica.com)**

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. Project evaluation**

**1.1 General information**

Raw material & formulation	PVC resin powder & CaCo3, Lubricants, Stabilizers, Pigments, Antioxidants
Melt capacity	Max: 800kg/h (depending upon the pipe dimension and the material)
Central height	1m
Haul-off speed	Maximum 1.2m/min
Machine color	Standard color: RAL7016 (Anthracite grey) RAL9002 (Grey white)
Picture of final product	

**1.1.1 Pipe specifics and size list:**

**Schedule 40 Dimensions**

Nom. Pipe Size (in.)	O.D.	Average I.D.	Min. Wall	Nom. Wt./Ft.	Max. W.P.
* 10	10.750	9.976	0.365	7.966	140
* 12	12.750	11.889	0.406	10.534	130
* 14	14.000	13.073	0.437	12.462	130
* 16	16.000	14.940	0.500	16.286	130
* 18	18.000	16.809	0.562	20.587	130
* 20	20.000	18.743	0.593	24.183	120
* 24	24.000	22.544	0.687	33.652	120

**Schedule 80 Dimensions**

Nom. Pipe Size (in.)	O.D.	Average I.D.	Min. Wall	Nom. Wt./Ft.	Max. W.P.
10	10.750	9.493	0.593	12.635	230
12	12.750	11.294	0.687	17.384	230
14	14.000	12.410	0.750	20.852	220
16	16.000	14.213	0.843	26.810	220
18	18.000	16.014	0.937	33.544	220
20	20.000	17.814	1.031	41.047	220
24	24.000	21.418	1.218	58.233	210

**1.2 Work conditions (Provide by the customer)**

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 (M): 37(Length)x2(width)x2(Height)
Temperature & Humidity	≤40°C, ≤95%
Power supply	460/3/60
Wire/cables/water hose	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. Water delivery: Supply water to the equipment and reservoirs.
Cooling Water	Without dissolved or suspended minerals as phosphor, sulphur, iron, etc. Inflow temperature T1: max. 15°C; Outflow temperature T2: T2=T1+5°C; Hardness: 5-8°dH; Reflux: without pressure
Lubrication oil	Exxon mobile
Compressor	Supply compressed air
Ancillary staff	3 People

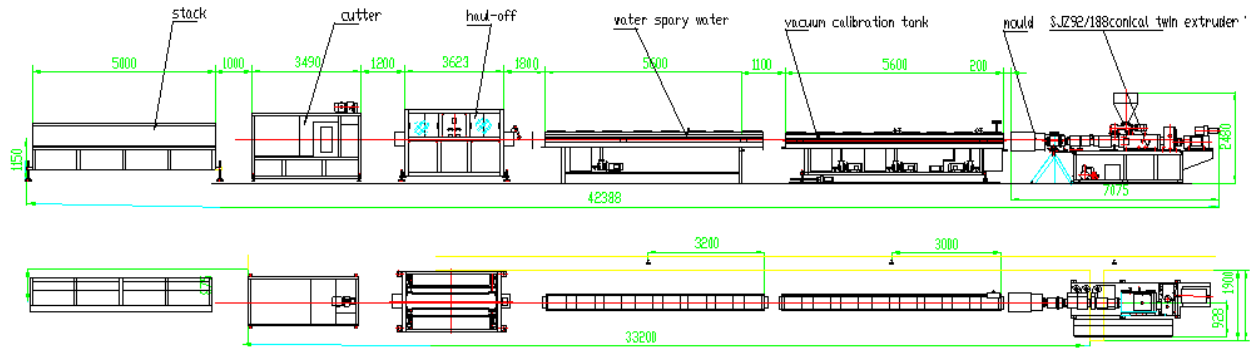
**1.3 Energy consumption**

Installation power	310 KW
Cooling Water	≤20°C, ≥0.3Mpa, ~15M <sup>3</sup> /hr
Compressed air	0.6m <sup>3</sup> /min, 0.4Mpa-0.8Mpa

**1.4 Main commercial terms**

Project	10"-24" PVC pipe production line
Price	FOB Shanghai INCOTERMS 2000
Payment terms	50% down payment by W/T 50% by W/T before delivery and after inspection
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 picture**



**1.6 Machinery list and unit prices:**

No.	Machine	Qty.	Unit Price (USD)
1	ZJF700 material feeder	1 set	
2	BRP110/28 parallel twin-screw extruder & electrical panel	1 set	
3	Pipe Dies and All Tooling	2 sets	
4	Vacuum Calibration tank	1 set	
5	Spraying cooling tank	1 set	
6	Haul-off (six claw)	1 set	
7	Planetary cutter	1 set	
8	Tilt Table	1 set	
Total price EX Works INCOTERMS 2000			
Inland transportation cost to Shanghai port (2×40'GP+1×20'GP Container)			
Packaging cost			
Total amount FOB Shanghai INCOTERMS 2000			\$403,325.00


**Remarks:**

Beier Machinery will set-up and trial the pipe extrusion line in their facility for customer acceptance, before shipment. All material costs for the trial are the responsibility of the customer.

2. Technical data

2.1 10"-24" PVC pipe production line

No.	Name	Photo of machine	Technical specifications
1	<b>ZJF700 feeder</b>		Rated transmission capacity: 1000kg/h
		Motor power: 2.75 KW Spring diameter: Φ59 Material: Stainless steel	
2	<b>BRP110/28 parallel twin-screw extruder</b>		Melt capacity: 850 kg/h
		<p><b>Screw:</b></p> Diameter parallel:110 mm Material of the screws: 38CrMoAIA, treatment by alloy process L/D: 28:1 Capacity: 800 kg/h Surface treatment: Nitride with thickness: 0.5 ~ 0,7mm, hardness: HV740~940, Polished Screw speed (counter rotating): 1-38 rpm <p><b>Barrel:</b></p> Inner processing: Nitride with thickness: 0.5 ~ 0.7mm, hardness≥HV740~940 Heating zones: 6 Heating mode: Cast Aluminum heater covered with stainless steel Heating power: 46.5KW Range of temperature control: 50~300℃ Cooling mode: Blower 3 Sets*0.37kw <p><b>Gear box:</b></p> Material: 20CrMoTi <p><b>Drive motor:</b></p> Motor power: AC 90 Kw <p><b>Dosing feeding system:</b></p>	

		<p>Material of hopper: stainless steel                  Motor: 0.75Kw                  Feeding sleeve with water recirculation cooling system</p> <p><b>Vacuum dehumidifying system:</b>                  Vacuum pump: 1 set                  Power: 1.5kw                  Vacuum degree = 0 ~ 0.075 Mpa</p> <p><b>Thermostat:</b>                  Heating power: 6kw                  Range of temperature control: 50~300°C                  Motor power: 0.75kw                  Work pressure: ≤0.2 Mpa</p> <p><b>Adaptor: (Interflow Section):</b>                  Material: #40 steel Chrome plated, inner convergent flow type                  Connection method with the die: Clamping block and bolt                  Melt pressure sensors and thermocouples</p> <p><b>Main electrical suppliers:</b>                  Extruder and the extrusion line control: Siemens PLC S7-200 with a 10.4" touch screen.                  Inverter: Hitachi, ABB or Schneider                  Contactor: Siemens                  Air Switch: Schneider                  Relay: Omron</p> <p><b>Self protection system:</b>                  Over current protection of the motor                  Over pressure protection of the screws</p>
<p>3</p>	<p><b>Pipe Dies</b></p>	<div data-bbox="422 1411 1013 1792" data-label="Image">  </div> <p data-bbox="1053 1579 1468 1624">Including calibration sleeves</p> <p><b>Material:</b>                  Made from 40Cr.                  Inner surface polished</p> <p><b>Diameter specifications &amp; wall thicknesses:</b> As per the "Pipe specifications and size list"</p>

		<p><b>Heating:</b> Quantity of heating zones: 30 Heating power:120KW</p>	
4	<p><b>Vacuum calibration tank</b></p>		<p>Vacuum system Water spray system Adjustment &amp; carriage movement system</p>
		<p><b>Dimensions:</b> Length: 5600mm Two chambers</p> <p><b>Vacuum pump:</b> Power: 4 KW×2</p> <p><b>Water pump:</b> Power: 5.5KW×2</p> <p><b>Three directions adjustment:</b> <b>Forward and Backward movement:</b>1.5KW motor <b>Range:</b> ±400mm <b>Up and down:</b> left and right manually adjusted <b>Range:</b> Up and Down: ±50mm <b>Left and right movement:</b> ±50mm <b>Tank material:</b> Stainless steel <b>Tank cover material:</b> Duralumin <b>Seal:</b> silica gel anti-friction panel and Q235 galvanized panel <b>Inner pipe support:</b> Nylon wheels <b>Water temperature and level control:</b> Controlled electronically and with stainless steel ball floats <b>Vacuum gauge:</b> 0.03-0.06Mpa <b>Spray nozzles:</b> ABS</p>	
5	<p><b>Spray cooling tank</b></p>		<p>Water spray</p>

		<p><b>Dimensions:</b> Length: 5600mm</p> <p><b>Water pump:</b> Power: 5.5 KW</p> <p><b>Direction adjustment:</b> Up and down, left and right manually adjusted</p> <p><b>Up and Down,</b> Range: ±50mm</p> <p><b>Left and Right</b> movement: ±50mm</p> <p><b>Seal:</b> silica gel anti-friction panel and Q235 galvanized panel</p> <p><b>Inner pipe support:</b> Nylon wheels</p> <p><b>Water temperature and level control:</b> Controlled electronically and with stainless steel ball floats</p> <p><b>Spray nozzles:</b> ABS</p>	
6	<b>Haul off (6 claws)</b>		Six claw
		<p>Motor: 1.1 × 6 KW</p> <p>Claw length: 2200mm</p> <p>Claw width: 80mm</p> <p>Maximum haul off speed: 1.2m/min</p> <p>Maximum traction force: 45000N</p> <p>Pneumatic clamping: with anti-friction rubber blocks</p> <p><b>Electrical components:</b> Inverter: Hitachi or ABB Low voltage electrical parts: LG or Schneider Length detecting: by encoder</p>	
7	<b>Planetary Cutter</b>		Scrap collecting with independent control system
		Cutting method: planetary cutter	



		Diameter of the saw: 230mm Cutting motor: 5.5KW Rotating motor: 2.2KW Cutting saw: steel alloy. Duralumin clamping for accurate and repeatable cutting Dust collection motor power 1.5KW With chamfering function <b>Electrical components:</b> Low voltage electric parts: Schneider or LG PLC control: Siemens	
8	<b>Tip Table</b>		Discharge: Pneumatic
		<b>Length: 5,000mm</b>	

**2.2 Spare parts list (free of charge)**

No.	Name	Qty.	Application
1	Thermocouples	3 pcs	Extruder
2	Rubber blocks	15 pcs	Haul-off
3	Sealing gasket	10 m	Vacuum tank and spray cooling tank
4	Sprayers	15 pcs	
5	Small contactors	2 pcs	Electrical cabinet
6	Buttons and switches	2 pcs	
7	Relays	2 pcs	

**2.3 Spare part list (not included in quotation)**

No.	Spare part	Qty.	Application
1	Screws and barrel	1set	Extruder
2	Complete set of barrel heaters	1set	Barrel

**2.4 Auxiliary equipment (optional equipments)**

No.	Spare part	Qty.	Application
1	High Intensity Mixer	1set	Blending material compound
2	Printer	1set	Printing characters

### **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,