

THREE-LAYERS COEXTRUSION CAST LINE COLINES

For polypropylene film production

TECHNICAL DATA:

	A	B	C
Film composition and layers distribution	20%	40%	40%
Extruders capacity - extruder 100 - extruder 130 - extruder 130			
Film working width	2500 mm (working width, without trims)		
Thickness range	20 ÷ 150 µm		
Line production capacity	35 µ - 400 Kg		
Finished rolls diameter	300 ÷ 800 mm		
Strawboard cores	Internal diameter	External diameter	
	(76 mm)	105 ÷ 108 mm	
	(152 mm)	175 ÷ 180 mm	

LINE COMPOSITION

1. n° 1 Extruder **100**
Extruder screw diameter: 100 mm
2. n° 1 Extruder **130**
Extruder screw diameter: 130 mm
3. n° 1 Extruder **130**
Extruder screw diameter: 130 mm
4. n° 3 Hydraulic filter changing system **100 130 130**
5. n° 3 Connection units between extruder and flat die
6. n° 1 Extruders platform
7. n° 1 Pre-laminator feed block
n° layers: 3
Layers disposition: A B C
Layers distribution (%): 20 40 40
8. n° 1 Flat die with thermal bolts
9. n° 1 Automatic thickness regulator Electronic System
10. n° 1 Aspirant blade
11. n° 1 Pushing blade
12. Mero treatment unit
13. n° 2 Edge-fixing electrostatic bars
14. n° 1 Cooling system
15. n° 1 Diagonal oscillator
16. n° 1 Suction trims system composed by:

n° 2 Trims suction device
Air ejection device
n° 2 Grinders
Electric-fan for trims suction
Soundproofing cabin
Electric-fan for milled material transport
Unloading cyclone for milled material
n° 2 Hoppers for material loading
n° 1 Normal hoppers for material loading
Trims number: 4

17. n° 1 Cooling water pumps system

The pumps system feeds 3 circuits:

- Primary circuit (water flow for the main roll)
- Secondary circuit (water flow for the auxiliary roll)
- Auxiliary circuit (water flow for cooling exchanger, switchboards and extruder guides)

18. n° 13 General service cabinets

19. n° 1 Line command console

20. n° 1 Thickness control command console

21. n° 1 Extruders pumps command console

22. n° 3 Pneumatic loader Ø 76 mm

23. n° 3 Pneumatic loader Ø 152 mm

AUTOMATIC WINDER

The automatic winder has been designed for cutting straight on the extrusion line, producing rolls of max. 800 mm diam.

The automatic winder is composed by:

TAKE OFF UNIT with longitudinal cut and adjustable belts dividing system:

- Free rollers
- Take off unit input
- Trims cut and suction
- Longitudinal cut

AUTOMATIC WINDER

- Free rollers
- Take-off unit
- Wind-up switchboard

TECHNICAL DATA

Max. film width after trims cut	2500 mm
Max. film width before trims cut	2970 mm
External min/Max finished rolls diameter	350÷800 mm
Internal strawboard cores diameter	76 / 152 mm
Winding type	contact/mix/gap