

DWJ SERIES
Single corrugated board production line



Basic Introduction

- (1)、Consist of mill roll stand, single facer,rotary cutter,etc
- (2)、Hydraulic shaftless mill roll stands and electric shaftless mill roll stands.
- (3)、Finger or fingerless suction single facer
- (4)、Plc type,mechanical type,computer controller type cut-off
- (5)、Steam heating,electrici heating,gas heating or oil heating
- (6)、Flute type:A,C,B,E,F,G(other type)
- (7)、Minimum slitting with:100mm
- (8)、Maximum cutting length:300-1200mm(E flute,F flute G flute);400-1600mm;
600-2400mm(others flute)
- (9)、Maxumum production speed:100m/min-120m/min.
- (10)、Available with:1200-2200mm

Equipment components

No. .	Unit	Quantity
1	Hydraulic Milic Mill Roll Stand, includes: (Expanding chuck)	2sets
	(1)Tracks/trolleys	4strips
	(2)Paper Roll Changer	2pieces
2	SDK Fast- change type Single Facer(2 flutes in one, 5 minutes change flute) (PLC frequency transducer control, color touch screen, auto adjustment of glue thickness)	1set
	Includes: Fan and Silencer	
3	Preheater ((PLC control wrap angle)	2sets
4	Single Layer Span Bridge	1 set
	paper guide device	1 set
5	PLC Rotary Shear Cut-Off and Convey Stacker	1 set
6	Glue making & Recycle System	1 set

FEATURES:

1、 Hydraulic MILL ROLL STAND (hydraulic pressure, with Expanding Chuck)

Characteristics

- (1)、 In the course of production, support and supply the scroll paper out.
- (2)、 The arms of the roll stand can go up and down, which is controlled by $\Phi 125\text{mm}$ hydraulic pressure oil cylinders. and clamp, transverse movement controlled by $\Phi 63\text{mm}$ hydraulic pressure oil cylinders.
- (3)、 Might load and unload scroll without stop production.
- (4)、 6 sets of hydraulic cylinders control.
- (5)、 Pneumatic control the tension and force the ABS brake tension force controlling system
- (6)、 Fixed type and expanding type finial are available (3 inch and 4 inch clamping part in mutual)

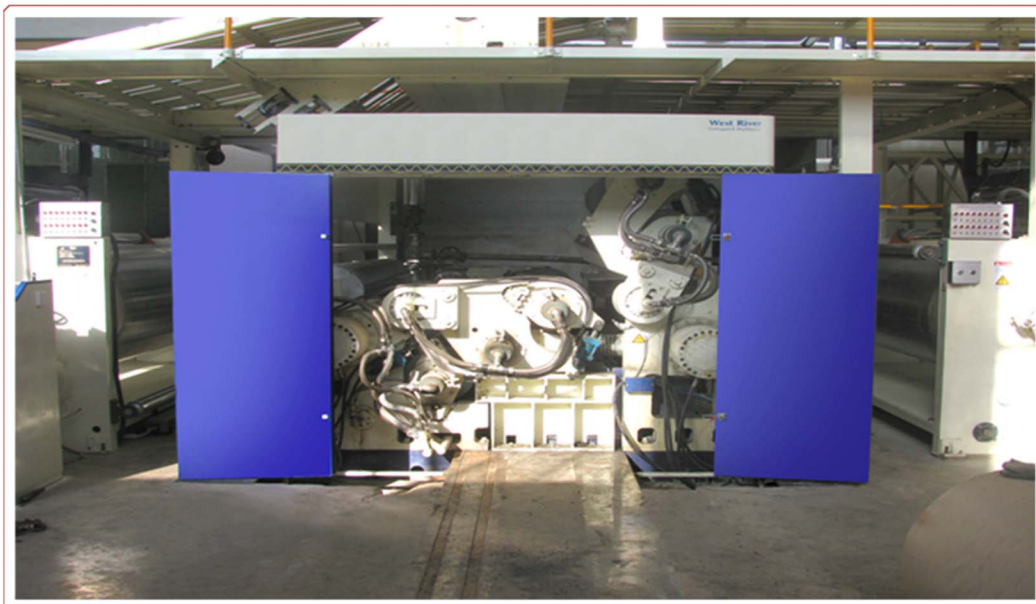


Technical parameters

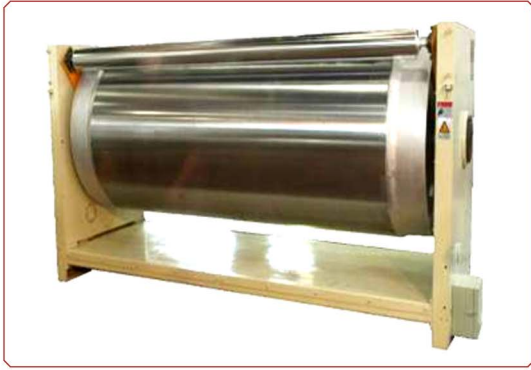
- (1)、 Max. diameter of scroll: $\Phi 1500\text{mm}$.
- (2)、 Max. width of scroll: 1400-2800mm
- (3)、 Power: 4kw.

2. SDK Fast-change type SINGLE FACER (2 flutes in one, 5 minutes change flute)

- (1)、 The whole machine control by the computer and equip with two pairs of corrugated roller, so can achieve multiple flute type fast change together but no need to move out and change separately, this method can enhance the production efficiency, mitigate the worker's labor intensity, the whole process just need 5 minutes.
- (2)、 The whole machine use hydraulic control technic, ensure the flute can highspeed setting and glue perfectly.
- (3)、 The corrugated roller use gear clutch achieve independence transmission, no need to equip with locking mechanism.
- (4)、 Use direct-drive three points transmission, suit for mid-high speed corrugated cardboard production line, can meet 300m/min high speed production.
- (5)、 The roller is made from special alloy steel, the size as following: 320mm, 360mm, 430mm. We use heat treatment technical to do the precision grinding. The surface is done by hard chromium or tungsten carbide plating.
- (6)、 Equip with infrared broken sensor in order to achieve paper breaking automatic protection; when the paper is broken, the press roller will exit and the glue plate also exit.
- (7)、 Sizing control include electric control and automatic control, when you set automatic, according to the running speed's changing, the sizing amount can be adjusted by the encoder and plc and also make sure the single ply's quality is stable too.
- (8)、 Use same high rigidity pedestal, transmission and pressing integrative; independent drive box can achieve the communication between the plc and transducer, another hand this design can save energy when the corrugated machine is accelerate or decelerate and have communication port for the management system.



FEATURES:



3.PREHEATER

- (1)、Heat raw paper or corrugated paper cardboard, control moisture of raw material.
 - (2)、Automatic or electric control types are available for customers' choice.
 - (3)、Fixed or rotational cylinders are available of choice.
 - (4)、Advanced round closure design, keeps the heat of paper even.
 - (5)、Heat cylinders diameter: Φ 600mm, Φ 900mm, Φ 1100mm
 - (6)、Effective breadth: 1400mm, 1600mm, 1800mm, 2000mm, 2200mm, 2500mm, 2800mm
 - (7)、Adjusting range of preheating roll: 0° - 320°
- (8)、Might be equipped with sprayer to adjust moisture content of the corrugated medium paper. Multiple pre-heater is available.

4. Single LAYER SPAN BRIDGE



- (1)、Germany structure of conveyor.
- (2)、With 2ply paper guide up device (overhead crane).
- (3)、With strong fences and ladders.
- (4)、At the bottom of the bridge, equipped with relevant illumination, be convenient to operate.
- (5)、The surface of all paper guide rollers is plated with hard chromium.

5. PLC Rotary Shear Cut-Off and Convey Stacker

1. Description:

SC series single face corrugated cardboard Shearer Cut-off is a new advanced equipment for producing B,E, F...FLUTE single face corrugated cardboard equipped in production line, also can cut base paper (such as white cardboard, kraft paper) into sheets (pieces),

Computer might deposit many order forms specification, and realize change order forms without stop machine. Machine is controlled by PLC automatically. Main Drive is controlled AC Frequency Transducer (inverter), save electric power.

Drive mechanism is equipped with arc shape teeth synchronization belt, long using life, less noise. Cutting Precision of this machine is nice, stable system, low maintenance cost.

It's consisted of slitting section, transverse cutting section, convey and stacking section.

2. Main technical parameters:

- 2-1. Range of Cutting Length: 300~1300mm
- 2-2. Valid Breadth: 1400mm, 1600mm, 1800mm, 2000mm
- 2-3. Max. mechanical speed: 100-120M/min,
- 2-4. Cutting Precision: ± 1.5 mm (at stable speed)



FEATURES:



6. Glue making & Recycle System

There are two barrels formed with Single facer to a recycled loop:

- (1) Glue making vertical Barrel(higher): Glue making material is carried up through ladder by manual, equipped with a stirring motor, might make glue and temporary store,
- (2) After glue stirring and making well, flowing to the glue trough of Single Facer(for feeding glue).
- (3) Another little barrel(lower) is put beside single facer, might received glue flew out from Single Facer, realize a cycled loop automatically.
- (4) Glue making material (reference): Starch(tapioca, or corn), Caustic Soda, mixture, Water.



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