

Technical configuration

◆ Honeycomb/Hollow Core Metal/A2

Composite Panel Production Line

● Design specification:

- Production material: Aluminum coil;
- Product width: W1000-1570mm;
- Product thickness: Honeycomb $\delta = 3 \sim 30\text{mm}$;
Hollow core metal/A2 composite panel $\delta = 3 \sim 6\text{mm}$
- Compound speed: 1.5~5m/min;
- Surface aluminum thickness: 0.2-1.2mm;
- Core aluminum thickness: 0.2-1.2mm
- Bottom aluminum thickness: 0.2-1.2mm;
- Honeycomb core thickness: 3-29mm;
- Conditions of use: The power is 380V/3 phase /50HZ;

● List of component:

- 1.Honeycomb stretch pinch machine 1 set
- 2.Honeycomb thicknessing drive 1 set
- 3.Honeycomb, A2 core panel conveyor oven 1 set
- 4.Core aluminum laminating machine 1 unit
- 5.Aluminum 3D embossing machine 2 set
- 6.Core material rolling machine 2 set
- 7.Compound machine heating oven 1 set
- 8.Surface aluminum rolling machine(including platform) 2 set
- 9.Bottom aluminum rolling machine 2 set
- 10.Compound unit 6 unit
- 11.Air cooling box 1 set
- 12.Protective film laminating machine 1 set
- 13.Longitudinal trimming machine 1 set
- 14.Longitudinal cutting machine 1 set
- 15.Four-roll leveling machine 1 set
- 16.Tractor 1 set
- 17.Cutting panel system 1 unit
- 18.Transverse cutting machine 1 unit
- 19Automatic vacuum machine 1 unit
- 20.Oil heating group (including electromagnetic heating) 9 unit
- 21.Electric control system 1 unit

Equipment composition and main configuration:

- 1. Honeycomb stretch pinch machine 1 set
- 1.1 Honeycomb core width range L=1240-1570mm
- 1.2 Honeycomb chip cylinder press wheel automatically compacts
- 1.3 Honeycomb stretch cots $\Phi 270 \times 1800$ mm
- 1.4 Honeycomb clip roller $\Phi 270 \times 1800$ mm, with power plant
- 2. Honeycomb thickening drive 1 set
- 3. Honeycomb core conveyor oven 1 set
- 3.1 Oven length L6000mm
- 3.2 Transmission net with power
- 3.3 Use electric heating
- 4. Core aluminum laminating machine 1 unit
- 4.1 The polymer film is put in the top tight way of air swelling shaft, which is convenient to change the coil, and can adapt to various requirements of the coil core
- 4.2 Polymer film edge trimming mechanism $\times 4$ unit (Upper and lower double station), ensure that production is in line with requirements
- 4.3 50N.M. Magnetic powder brake $\times 4$ unit, tension automatic control, to ensure uniform film tension, flat and level
- 5. Aluminum 3D embossing machine 2 set
- 5.1 Concave-convex embossing roll $\Phi 270 \times 1680$
- 5.2 4 kw ac motor drive power, ABB inverter
- 5.3 wire rod is discussed
- 6. Core material rolling machine 2 set
- 6.1 Hydraulic support type, rolling bearing biggest 5 tons
- 6.2 Rolling core flange $\Phi 405 \Phi 505$
- 6.3 Magnetic powder brake of roll 40KG
- 6.4 Rolling machine width range L=1240-1570mm
- 7. Compound machine heating oven 1 set
- 7.1 For the first group of this kind of composite honeycomb panel or A2 to reheat compound, fine composite help behind
- 7.2 Oven length L1500
- 7.3 Heating mode for electric heating
- 8. Surface aluminum rolling machine(including platform) 2 set
- 8.1 Hydraulic support type, rolling bearing biggest 5 tons
- 8.2 Rolling core flange $\Phi 405 \Phi 505$
- 8.3 Magnetic powder brake of roll 40KG

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- 8.4 Rolling machine width range L=1240-1570mm
 - 9. Bottom aluminum rolling machine 2 set
 - 9.1 Hydraulic support type, rolling bearing biggest 5 tons
 - 9.2 Rolling core flange $\Phi 405$ $\Phi 505$
 - 9.3 Magnetic powder brake of roll 40KG
 - 9.4 Rolling machine width range L=1240-1570mm
 - 10. Compound unit 6 unit
 - 10.1 Composite steel roller $\Phi 450 \times 1800 \text{mm}$ X 1 unit
 - 10.2 Composite steel, rubber roller $\Phi 450 \times 1800 \text{mm}$ X 5 unit
 - 10.3 Group composite cylinder pressure $\Phi 200 \times 100$
 - 10.4 Rotary joints: the 1.5 "rotary joint
 - 10.5 The first group with double location polymer film membrane units
 - 11. Air cooling box 1 set
 - 11.1 Two water-cooled air conditioners on top and bottom respectively
 - 11.2 Air cooling box length L=6000mm
 - 12. Protective film laminating machine 1 set
 - 12.1 Protective film feeding with higher shaft tight way, in volume and convenient, can adapt to all kinds of roll core requirements
 - 12.2 Polymer film edge trimming mechanism $\times 4$ unit (Upper and lower double station), ensure that production is in line with requirements
 - 12.3 50N. M. Magnetic powder brake $\times 4$ unit, tension automatic control, to ensure uniform film tension, flat and level
 - 13. Longitudinal trimming machine 1 set
 - 13.1 Uses the steel plate welded frame
 - 13.2 Longitudinal and transverse precision fine-tuning
 - 13.3 Wear-resistant special circular knife and maintenance-free automatic roll cutting without dust, optimize the work environment, quality of edge
 - 14. Longitudinal cutting machine 1 set
 - 14.1 Cutter motor power 1.5KW
 - 14.2 Cutting range W=1000-1620
 - 15. Four-roll leveling machine 1 set
 - 15.1 Leveling roll $\Phi 131 \times 1800 \text{mm}$ $\times 4$ rolls
 - 15.2 Adopt screw reducer to adjust and adjust
 - 16. Rubber roller Tractor 1 set
 - 16.1 Traction type: active friction type.
 - 16.2 Rubber roller: $\Phi 270 \times 1800 \text{mm}$ X 4 rolls

- 16.3 Clamping way: pneumatic clamping
- 16.4 Drive motor, AC motor 7.5 kw.
- 16.5 Reducer, cycloid reducer, gear transmission
- 16.6 Traction speed: 0~5m/min
- 16.7 Control unit: the ABB inverter control
- 17. **Cutting panel system** 1 unit
- 17.1 Cutting ability: ACP composite panel T6.0mmx1600mm
- 17.2 Plates welded frame
- 17.3 Domestic well-known brand, quality assurance
- 17.4 With the function of brake motor: 5.5kw
- 17.5 Roller components $\phi 75\text{mm} \times 1,600\text{mm}$
- 17.6 PLC control+servo+precision ball screw drive, make sure the cutting length within $\pm 1\text{mm}$
- 17.7 Electrical operation box
- 17.8 With the function of peel strength sampling shear
- 18. **Transverse cutting machine** 1 unit
- 18.1 Cutting power 1.5KW
- 18.2 Cutting width L=1600
- 18.3 Cutter movement cylinder $\Phi 100 \times 800$
- 19. **Automatic vacuum machine** 1 unit
- 19.1 Automatic translation type suction plate platform (without frame)
- 19.2 PLC control+vacuum cup type
- 19.3 Effective width 1570mm
- 19.4 Effective suction plate length 3M
- 20. **Oil heating group (including electromagnetic heating)** 9 unit
- 20.1 Heat-conducting medium: heat conduction medium for 320 # high temperature heat conduction oil
- 20.2 Temperature control precision: $\leq \pm 1^\circ\text{C}$
- 20.3 Heating unit: heating tube heating mode
- 21. **Electric control system** 1 unit
- 21.1 Forms: couplet body type
- 21.2 Material: is made of medium carbon steel). All controller installed in the control panel
- 21.3 Control panel: the import of domestic and international famous brands and quality products and parts. It is composed of power indicator, host on/off switch, emergency stop button, fine adjustment button, voltmeter and power switch
- 21.4 Electric appliance : AC press contact is South Korea brand LG

- **Quality assurance and post sales service:**
 - **Quality assurance:**
 - 1.1 The equipment shall be guaranteed for one year from the date of signing the acceptance certificate by both parties, and the contractor shall be responsible for free maintenance or replacement of the equipment in case of failure caused by non-ordering party within the warranty period.
 - 1.2 Within one year of the warranty period, if the equipment is damaged or lost due to reasons attributable to the ordering Party, the contractor shall have the obligation to assist the ordering Party in dealing with the aftermath and resend the goods, and the necessary expenses shall be borne by the ordering Party.
 - **Post sales service:**
 - 2.1 When the contractor delivers the equipment to the ordering party, it shall randomly provide a list of wearing parts.
 - 2.2 The guarantee random file is complete, the contractor to provide a given party and a whole set of equipment electrical specifications, packing list.
 - 2.3 The ordering party in equipment in use process such as quality problems occur, the ordering party notice the contractor (by fax) after 12 hours to respond, if is really necessary maintenance personnel, reach the site within 8 hours for processing (domestic).