



PS FOAM FOOD CONTAINER PRODUCTION LINE

Main parts brand and manufacturers

Sheet machine	
PLC	Mitsubishi Japan
Touch Screen	Taiwan Weilun
Primary motors 2	BEIDE Siemens
Main speed reducer	Shandong
Frequency converter	Taiwan Delta
Temperature controller module	Taiwan Delta
High pressure measuring pump, 2 pump heads	Huali Hangzhou
Solid state relay	Delixi
Contactors	Schneider
Breaker	CHNT
Low voltage electrical appliances	Schneider
Forming machine	
PLC	Mitsubishi Japan
Touch Screen	Taiwan Weilun
Hydraulic Pressure system	Yuken and Huade and Le-HydrauliX
Pneumatic device	Taiwan AirTAC
Motor	Siemens Beide
Intermediate relay	DINKLE Japan
Temperature controller system	Taiwan Delta temperature modular unit
Servo motor	Taiwan Delta



Frequency converter	Taiwan Delta
Vacuum pump	zhuoxin
Low voltage electrical appliances	Schneider
Static Eliminator 3sets	CCJM China
Recycle machine	
Primary motor	Beide Siemens
Main speed reducer	Shandong
Frequency converter	Taiwan Delta
Temperature controller meter	Omron
Low voltage electrical appliances	Schneider

I PS 发泡片材挤出机组



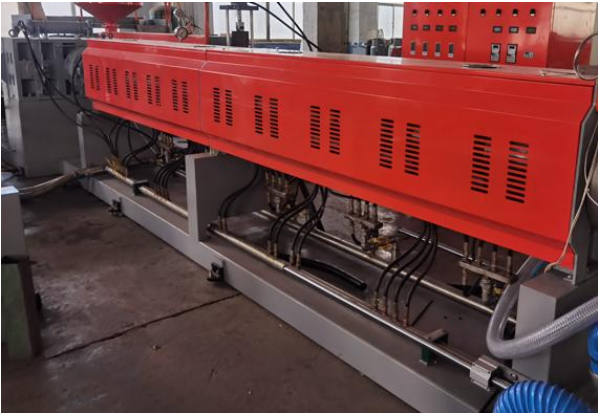


PS foam sheet extrusion line110/130 型 PS 发泡片材生产线包括以下主要部分





110/130 PS foam sheet extrusion line includes the following components

序号	名称	数量(套)	图片
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No	Name	Quantity	Picture
1	Mixer and feeder	1 set	
2	The first stage extruder	1 set	
3	Blowing agent injecting system	1 set	
4	Non-stop replace screen changer system	1 set	



5	The second stage extruder	1 set	
6	Extruder head and mold	1 set	
7	Shaping cooling and cutting system	1 set	

8	Pulling system	1 set	
9	Electrostatic elimination system	2 set	 
10	Winding system	1 set	

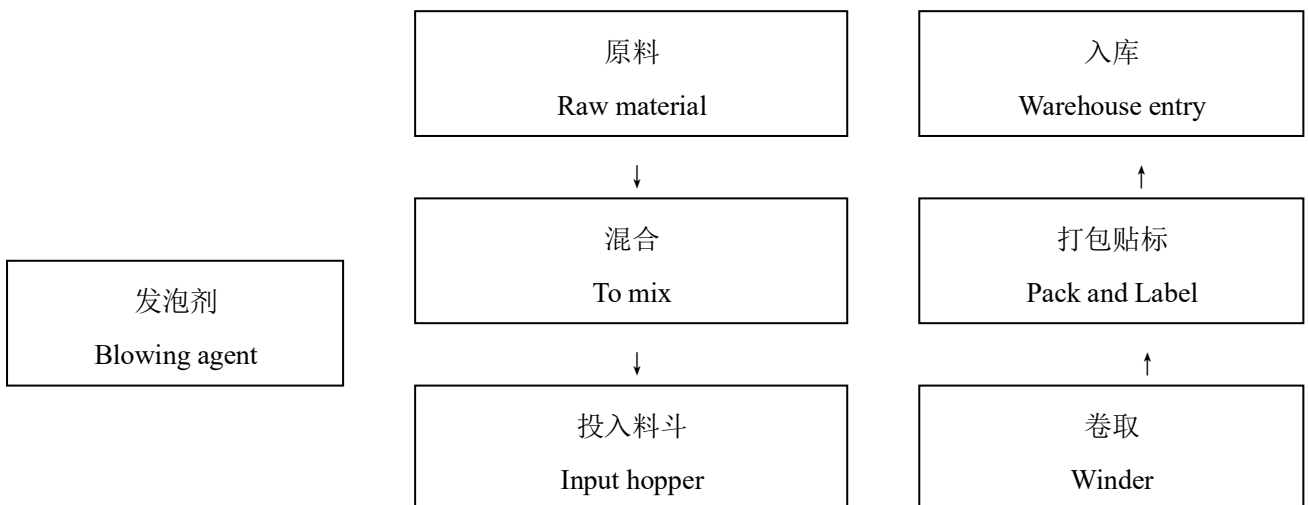


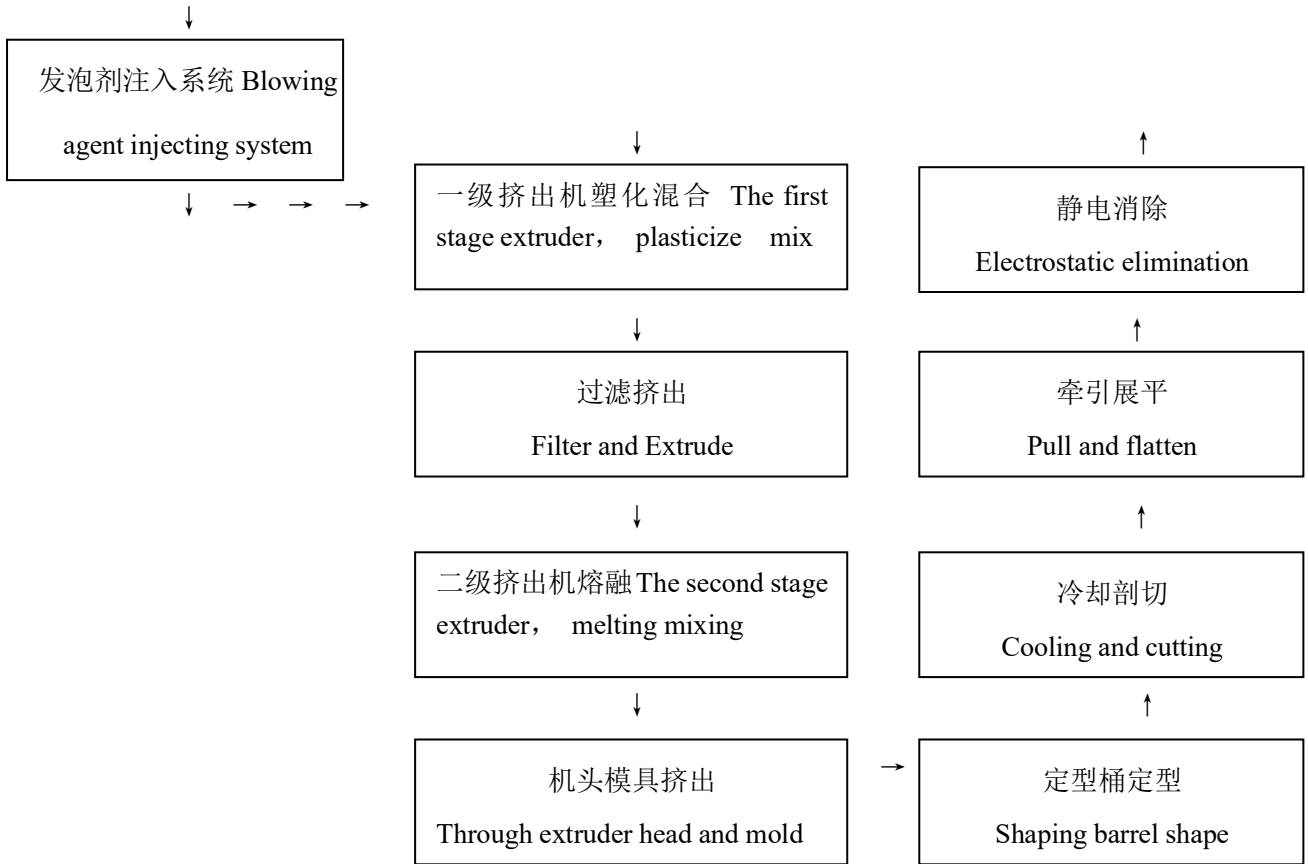
11	Control system	1 set	
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II 主要技术参数 Main parameters

项目 Item	单位 Unit	参数 Parameter	备注 Remark
型号 Model		FS-FPP110-130	
适用材料 Applicable materials		GPPS granule	
成型片材厚度 Thickness of sheet	mm	1-5	
片材宽度 Width of sheet	mm	1080	
发泡倍率 Foaming rate		12-20	
制品容重 Bulk weight of product	Kg/m ³	50-83	
制品导热系数 Thermal conductivity of product	W/m.k	0.021-0.038	
产量 Output	kg/h	200-250	
整机额定功率 Rated power	Kw	260	
外形尺寸 External dimension	mm	25000×7000×3000	
整机重量 Complete weight	Ton	约 13 About13	

III 生产工艺流程图 Production flow chart





IV 各部分详细介绍 Details of foam sheet extrusion line

A. 自动上料系统 Automatic feeding system

1. 上料形式 Feeding style

螺旋上料 Spiral feeding

2. 主要参数 Main parameters

混料机料箱容积 The capacity of mixer (kg)	600
混料机电机功率 Motor Power of mixer (kw)	3kw-6
上料机电机功率 Motor power of feeder (kw)	1.5

B. 一级挤出机 The first stage extruder

1. 螺杆, 机筒材质 Screw and barrel materials

38CrMoAlA 氮化处理 38CrMoAlA nitrogen treatment

2. 主电机形式 Main motor style

交流电机配变频器 AC-motors with frequency converters

3. 减速机 Speed reducer



挤出机专用减速机，硬齿面，高扭矩，低噪音

Extruder dedicated reducer, hard tooth surface, high torque, and low noise

4. 加热器 Heater

铸铝加热器，固态继电器无触点输出，智能温控仪控温

Aluminum casted heaters, solid-state relay contact-less output, intelligent temperature controller.

5. 技术参数 Technical parameters

驱动电机功率 Driving motor power (kw)	55
螺杆直径 Diameter of screw bolt (mm)	Φ110
螺杆长径比 L/D ratio of screw bolt	32: 1
螺杆最高转速 Max speed of screw (rpm)	60
加热圈数 Number of heaters	10
加热功率 Heating power (kw)	30

C. 发泡剂注入系统 Blowing agent injecting system

1. 泵种类 Type of pump

柱塞式高精度高压计量泵，配单向阀控制，注入量由柱塞行程控制

Plunger type high precision and high pressure measuring pump, to match one-way valve to control, the injection volume is controlled by plunger lift

2. 主要技术参数 Main technical parameters

发泡剂种类 Type of blowing agent	丁烷和液化石油汽 butane or LPG
计量泵流量 Metering pump flux	63 (L / H)
注入最高压力 The Max pressure injection	30 (Mpa)
压力表 Pressure gauge	0-40 (Mpa)
电机功率 Motor power	2.2 (kw)

D. 不停机换网系统 Non-stop replace screen changer system

优点。换网面积大，过去的换网面积是长 10cm 宽 10cm，面积 100cm²

现在使用的直径 6cm，高 16cm 圆柱，过滤面积是 301cm² 换网积增加了三倍。同理，过滤网在机器上使用的时间就长了时间，假如过去每天换一次网，现在就是三天换一次网。

本换网器耐压强度高，该换网器有两个换网芯，一个在工作区，工作压力可以达到 30MPA,另一个在备用区，在备用区内可以更换滤网，更换滤网时，有个泄压装置，能把该区域内的压力卸掉，进行换网，安全方便，而液压换网器，压力不能泄，压力增大时，增加了拖板的压力，容易使拖板变形，



漏料。严重时，换网还换不动。

所以此换网器属于大面积、高压、不漏料换网器。

Advantage:

1. The screen-changing area is large.

In the past, the screen-changing area was 10cm long and 10cm wide, and the area was 100cm². Now the diameter of 6cm, the height of 16cm cylinder is used, the filter area is 301cm², and the screen area is increased by three times. In the same way, the filter has been used for a long time on the machine. If the filter was changed once a day in the past, it is now every three days.

2. The screen changer has high compressive strength.

The screen changer has two screen changing cores, one is in the working area, the working pressure can reach 30MPa, and the other is in the spare area, where the filter can be replaced. , There is a pressure relief device, which can relieve the pressure in the area and change the screen, which is safe and convenient. If choose hydraulic screen changer, the hydraulic screen changer can not release the pressure. When the pressure increases, it increases the pressure of the carriage, which is easy to make the carriage Deformation, leakage. In severe cases, the network cannot be changed.

Hence, this screen changer is a large area, high pressure, no leakage screen changer.

E. 二级挤出机 The second stage extruder

1. 螺杆，机筒材质 Screw and barrel material

38CrMoAlA 氮化处理

38CrMoAlA nitrogen treatment

2. 主电机形式 Main motor style

交流电机配变频调速

AC-motor with frequency converters

3. 减速机 Speed reducer

挤出机专用减速机，硬齿面，高扭矩，低噪音

Extruder dedicated reducer, hard tooth surface, high torque, and low noise

4. 加热器 Heater

铸铝加热器，固态继电器无触点输出，智能温控仪控温,加热器内串冷却水。

Aluminum casted heater, solid-state relay contact-less output, intelligent temperature controller, Cooling



water device in heater .

5. 冷却降温方式 Cooling and temperature-reduction style

水循环冷却，带自动旁路系统

Circulating water cooling , automatic bypass system.

6. 技术参数 Technical parameters

驱动电机功率 Driving motor power (kw)	75
螺杆直径 Diameter of screw (mm)	Φ130
螺杆长径比 L/D ratio of screw	38: 1
螺杆最高转速 Max speed of screw (rpm)	50
加热圈数 Number of heaters	13
加热功率 Heating power (kw)	50

F. 挤出机头和模具 Extruder head and mold

1. 结构 Structure

圆形挤出模头，模口可调，机头带有压力表

Round of the extruder head, mold can adjust, head with a pressure gauge

2. 材质 Material

优质模具钢，经热处理，流道表面粗糙度：Ra0.025μm:

High quality tool steel, heat-treated, flow channel surface roughness: Ra0.025μm

3. 主要技术参数 Main technical data

模口直径 Diameter of mold	根据订货合同 According to the order contract
温度控制区数 Quantity of temperature control zones	2/1
温度控制精度 Accuracy of temperature control	±1 (°C)
加热功率 Heating power	4 (kw)

G. 冷却、定型及切割系统 Shaping cooling and cutting system

1. 定型方式：定型桶定型

Shaping style: shaping barrel

2. 冷却方式：定型桶水冷加外部风环风冷

Cooling style: shaping barrel cooling with water and external wind-ring



3. 结构: 定型桶, 切割刀及机架组成

Structure: shaping barrel, cutting knife and rack components

4. 主要参数 Main technical parameters

定型桶尺寸 Shaping barrel size (mm)	根据订货合同 According to the order contract
风机功率 Blower power (kw)	三相 Three phase 2.2

H. 牵引系统 Pulling system

1. 牵引方式: 三辊 S 型牵引, 气动压紧。

Pulling style: three-rollers S shape puller, compress with air drive

2. 驱动电机形式: 交流电机, 变频调速, 减速机变速。

Driving motor form: AC-motor, frequency conversion velocity modulation, speed reducer changes speed

3. 主要参数 Main parameters

牵引辊数量 Pulling roller quantity (piece)	3
牵引辊规格 Pulling roller size (mm)	Φ400×1300
电机功率 Motor power (kw)	2.2

I. 静电消除系统 Electrostatic elimination system

采用杆式离子棒消静电系统, 工作电压 7 千伏以上, 能产生高效、强力的离子风, 有效消除静电危险。

Use the type of ion rod electrostatic elimination system, working volt is 7KV above, can produce high effective and powerful ion wind, eliminate electrostatic danger effectively.

J. 卷取系统 Winding system

3. 形式 Form

双臂气涨轴式 Double-arm air shaft type

2. 主要技术参数 Main technical parameters

卷取重量 Coiling weight (kg)	最大 40 Maximum40
卷取直径 Coiling diameter (mm)	最大 1000 Max 1000
长度控制 Length control	计米器控制, 长度可调 Meter counter control, adjust length
传动电机 Driving motor	力矩电机 10n.m×2 台 Torque motor 10n.m×2 sets

K. 电气控制系统 Electric control system



挤出机加热控制柜一套 Heating control cabinet of the first stage extruder: one set

卷取控制柜一套 Winding control cabinet: one set

V 片材机工具备件清单

Tools and spare parts list for foam sheet machine

序号 NO.	名称 Name	数量 Quantity
1.	内六角扳手一套, 外加 12, 14, 17, 19 Hex wrench1 set add 12, 14, 17,19	各一把 each 1pc
2.	叉扳手 Forked wrench	1 套 1 set
3.	固态继电器 Solid state relay	4 个 4 pcs
4.	温控表 Temperature controller	2 块 2 pcs
5.	电流表, Ampere meter,	3 块 3 pcs
6.	液压用密封垫 Hydraulic gasket	2 个 4pcs
7.	热电偶 Thermocouple	3 支 3 pcs
8.	压力表(大小各一块)Pressure gauge (big and small each one)	2 块 2 pcs
9.	加热圈 Heater	若干 Some
10.	计量泵专用工具 Special tool for meter pump	一套 1 set
11.	联接螺纹卡扣 Joint Thread hook	2 个 2 pcs
12.	不锈钢过滤网 Stainless steel mesh	1 平方米 1 m ²
13.	主机单向阀 One-way valve for main machine	1 套 1 set
14.	单向阀内的弹簧 One-way valve springs	5 个 5pcs
15.	模头加热棒 Heating rod for die head	2 根 2 pcs
16.	水路电磁阀 Waterway Electromagnetic valve	2 个 2 pc
17.	模头螺丝 Die head screw	6 个 6pcs
18.	换网器加热板 heating plate for screen changer	1 个 1 pc
19.	交流接触器 AC contactor	5 个 5 pcs
20.	钻头 Drill	2 个 2 pcs
21.	卡簧 Circlip	5 个 5 pcs
22.	脚踏开关 foot switch	1 个 1 pcs
23.	光电开关 photoelectric switch	1 个 1 pc



Crusher System

FS-YTA1000/1400 全自动真空成型冲裁机械手堆垛在线破碎一体机



I 主要技术参数 Main tech data

Model 型号	FS-YTA1100-1400
Effective forming area 有效成型面积	1100×1400mm
Forming speed 成型速度	16-20cycles/min
Total power 总装机功率	200KW
Weight 整机重量	26.5MT
Installation dimension 安装尺寸	25×5×3m

<p>Stacking method 堆垛方式</p>	<p>Double robot arms stacking, reduce products damage probability and increase efficiency. 双机械手堆垛，减少产品损耗，增加效率。</p>
<p>Controll method 控制方式</p>	<p>PLC and Color touch screen PLC, 彩色触摸屏</p>
<p>On-line crusher 在线破碎</p>	<p>Collect crush scraps on-line, workshop is much cleaner and save manpower. 在线破碎并收集碎料，工厂环境更整洁，节省人工。</p>

II Significant advantages 显著优势

	<p>1. Steel Rail 钢轨代替铝轨 Chain rail is steel material , more wear-resistant durable than aluminum alloy guide rail and chiller is necessary for rail cooling, cooling tower is fine. 采用钢质导轨，比铝合金导轨更耐磨耐用，并且不需要水机组冷却，冷却塔足够。</p> <p>2. Delta Servo Motor Drive Chains 台达伺服电机控制链条驱动 Whole chains transmission, controlled by Delta servo control system,7.5kw 整机链条传送，台达伺服电机控制。</p>
	<p>Cutting Pressure 120T 冲裁压力 120T Hydraulic cylinder bore is 220mm, while other factory is 160mm or less. The pressure on unit area decreases, cylinder, hydraulic circuit and solenoid valve lifetime increase. 油缸缸径 220mm，接触面积增大 1 倍，单位面积上压强减少，从而使油缸的寿命得到延长，油路、电磁阀</p>



等受到的冲击力也减少，寿命延长。

Thicker and denser grid for cutting board.冲裁板板材更厚，栅格更多，结实耐用

Cutting board is much more stronger than other factory. Only strong board can offered high pressure and high speed cutting.

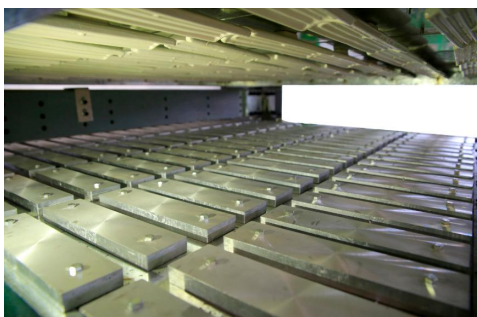
冲裁大板比其他工厂栅格更粗，更密集。只有高强度的大板才能经受住高压和高速的冲裁。



Temperature Control Module 温控模块

Heating portion use temperature control module + PLC+ touch screen control method, which has memory function, all heating temperature can one-click retrieval when change mold, don't need adjust setting anymore.

加热部分采用温控模块+PLC+触摸屏控制温度，带记忆功能，生产不同产品时，可一键调取相对应产品的温度，而不需要一一设定。



1.Aluminum Heaters For Third-section Lower Heating 三段加热，第三段加热区采用铝加热片

Aluminum heaters are more durable and easier to clean.

铝加热片更耐用，也更容易清理。

2.Heating section use thermal closed insulation design 加温温区隔热保温设计

Heating box full use of heat insulation material, seal



heat, heat preservation effect is much better and saving power.

加热箱四周全部用保温材料包装，保温效果好，省电



New functional improvements for robotic arm molding machines:

When making different products, such as food boxes, bowls, and plates, the height of the products varies, and the height of the forming, punching, and stacking parts also varies. Every time the mold is changed, the lowering height needs to be adjusted. Next, we will make improvements to all molding machines:

1. For the forming part, make digital rulers for the up and down strokes.
2. For the punching and mechanical arm parts, digital electronic rulers are used for the left and right strokes, with an accuracy of less than 0.1mm.
3. PLC has a memory function, which can store the descending height of each product's formula. The standard can store 30 sets of formulas, and special requirements can be raised in advance.
4. In this way, the PLC memory function can store both temperature data and distance data, saving employees time for mold replacement and debugging, and improving costs and efficiency.



In addition, our PLC has always reserved data cable sockets, which can be remotely connected as long as it is connected to the network. With the customer's permission, we can connect to the network to restore factory settings or update upgrade programs for the customer.



Both forming part and cutting part guide post equip with oil lubrication pump, can increase guide post and bush lifetime.



Install air gun between the forming and cutting part, easy for customer to clean working tables.

III Technical configuration 技术配置

1. Unwinding portion 放料部分

Advantage: double stations of feeding sheet rolls, don't need to stop machine when feeding in new roll sheet, save production time.

1. Unwinding length: photoelectric switch control
2. Unwinding mode: 0.75kw turbine decelerating motors
3. Feeding method: pneumatic feeding
4. Double feeding shaft alternately



2. Heating portion 加热部分

Advantage: Temperature control: Adopts automatic control of PLC and temperature control module, temperature control module to adjust the voltage on both ends of the heater, the heater has been in a state of constant temperature heating.



Detail Specification:

1. Heating zones: three-zone heating, heating area: 1100×4400 (mm)
2. Heating box total length is 4.4m, relatively extend heating time, avoiding over high temperature melt the sheet, at the same time making better secondary foaming effect.
3. Heating mode: heating tube, aluminum plate and ceramic tile radiation
4. Heating power: 160kw
5. Heating box can be moved right and left, convenient maintenance

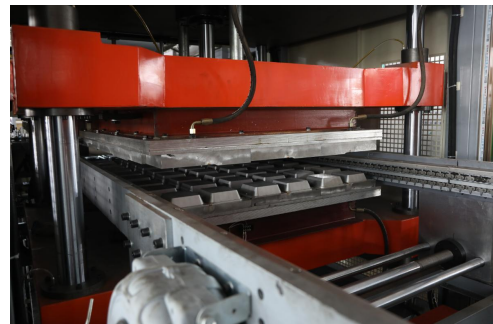
3 Molding portion 成型部分

Advantage:

1. Max forming area: 1100×1400 (mm), is 1.4 times larger than traditional machine, it can be arranged more boxes.
2. Forming speed: 16-20 mould/min

Detail Specification:

1. Forming depth: Max 80mm
2. Forming pressure: Max 20t, adjustable



3. Machine control method: hydraulic control of the upper and lower mold alone.
4. Hydraulic pump station, with double vane pump motor power: 7.5 kw×2
5. Vacuum pump: adopting Zhuoxin water ring vacuum pump
6. Vacuum tank: 118L×2
7. Working table stroke: photoelectric switch automatic control.
8. The hydraulic oil tank is equipped with bidirectional filtration, which extends the service life of oil products and oil circuits.



4 Cutting portion 冲裁部分

Advantage:

1. Cutting Pressure 140T

Hydraulic cylinder bore is 220mm, while other factory is 160mm or less. The pressure on unit area decreases, cylinder, hydraulic circuit and solenoid valve lifetime increase.

2. Thicker and deser grid for cutting board.

Cutting board is muh more stronger than other factory. Only strong board can offered high pressure and high speed cutting.

Detail Specifiction:

1. Punching mode: hydraulic automatic control
2. Punching machine, double vane pump with oil, motor power: 11Kw
3. Working table stroke: photoelectric switch automatic control
4. Cutting area can move: driven by the motor, it is beneficial for changing the moulds and can save the time of changing moulds.
5. Punching plate: high quality stainless steel
6. Punching area: 1100×1400(mm)
7. Electrostatic eliminators are set on cutting area, it can eliminate the static produced during the forming process. May sure the safety of producing.
8. The hydraulic oil tank is equipped with bidirectional filtration, which extends the service life of oil products and oil circuits.



5 Double Robot Arms Stacking collection system 双机械手堆垛收集系统

Advantage:

1. Mechanical arm stack products on both sides, which save the traditional model's conveyor belt output time, increase the production speed.
2. Suck the food containers up. Even the containers don't suck out successfully, won't affect next move.
3. Production increased, labor is not increased, reduce production cost, making more profit.

Detail Specification:

1. Control method: controlled by PLC
2. Stacking method: The servo motor control the mechanical arms reciprocating motion, the mechanical arms catch the plate by vacuum sucker, it use conveyer belt to collect the plate from both sides, it can stack 25 pcs plate for single row, it is convenient to put in the carton box or bag.
3. Transmission mode: Bilateral conveyer belt transmission
4. Control mode: The servo motor control.
5. The stacking part fix two sets static eliminators, it can remove static, and avoid fire



6 Edge material crush and collect

Advantage: Leftover material input crusher directly, by suction fan inhaled granulation workshop through the pipe after crushing, keep the forming workshop clean and tidy, save manpower to carry the leftover material.

Detail Specification:

1. Traction transmission: motor power: 0.75kw
2. Crusher: motor power: 7.5kw
3. Suction fan power: 1.5kw



7 Electric Cabinet 电柜

Heating cabinet 加热电柜



PLC control Cabinet PLC 控制柜



C 主要外购件 Main purchased parts

名称 Name	产地或品牌 Origin or brand
真空泵 Vacuum pump	山东 Shandong
PLC	日本三菱 Mitsubishi
触摸屏 Touch screen	台湾威纶 Weinview
中间继电器 intermediate relay	正泰 CHNT
温控模块 Temperature controller module	台湾台达 Delta
伺服电机 Servo motor	台湾台达 Delta
陶瓷辐射瓦 Ceramic radiation	江苏 Jiangsu
低压电气 Low voltage electrical appliances	正泰 CHNT
液压阀 Hydraulic valves	日本油研、华德，乐卓 Yuken and Huade and Le-HydrauliX
钢制导轨 steel Rail	富士 Fushi

Free Spare Parts List

序号 NO.	名称 Name	件数 Pc
1.	工具箱 Tool box	1 pc



2.	内六角扳手 12, 14, 17, 19 Hex wrench 12, 14, 17,19	each 1pc
3.	呆扳手 Forked wrench	1 pc
4.	活扳手 Flexible wrench	1 set
5.	钢丝钳 Wire-cutter	1 pc
6.	十字螺刀 (大小各一把) “十” screwdriver (big and small each one)	2 pcs
7.	管钳 Box spanner	1 pc
8.	锤 Hammer	1 pc
9.	棘轮扳手 ratchet wrench	1 pc
10.	空气三联件 Air triple	1set
11.	数显电流表 Digital ammeter	4 pcs
12.	按钮 (红绿各两个) Press button(red and green each two pcs)	4pcs
13.	水管活接垫 Water line connecting gasket	each 5pcs
14.	热电偶 Thermocouple	3 pcs
15.	成型机固态继电器 Solid-state relay for forming machine	4 pcs
16.	接近开关 Proximity switch	2pcs
17.	光电开关 Photoelectric switch	1 pcs
18.	铸铝加热片 Heater for forming machine	5pcs
19.	陶瓷加热片 Ceramic heaters	20 pcs
20.	加热管 Heating pips	Each for 1pc
21.	链条 Chain	1m
22.	∅ 10mm\∅ 8mm 气管接头 ∅ 10mm\∅ 8mm gas line tie-in	Some
23.	∅ 10mm\∅ 8mm 三通 ∅ 10mm\∅ 8mm tee join	Some
24.	∅ 10mm\∅ 8mm 气管 ∅ 10mm\∅ 8mm gas line	Some
25.	电磁阀 electromagnetic valve	1pc
26.	固定模具螺丝 Screws for fix molds	20 个 20pcs
27.	吸盘 Sucker	50 个
28.	吸盘长短杆 Stick for install suckers	Each for 15pcs
29.	切割模具刀片 cutting mould blade	2pcs for each mold
30.	EVA 切割模垫 EVA cutting mould pad	4plates

31	吹气电磁阀 Air blowing magnetic valve	1pc
32	卡夫特胶 Kraft glue	2pcs
33	油窗 (液位计)	1pc
34	压力表 Pressure gauge Oil window (level gauge)	2pcs, 4mpa and 6ma
35	中间继电器 Intermediate relay	2pcs

FS-ZL125/320 Double Screws Fully Automatic Crushing Recycling And Air Collecting Machine



流程: Flow Chart:

选料—投料—破碎—一级挤出机—熔化—第二挤出机—液压换网过滤—挤出牵引—冷却水槽冷却—切粒—装包

Material —Put into—Crush—Inhalation storage silos—Melt—Extrude—Water tank cooling—Pulling—Pelletizing—Packaging

1 主要技术参数 Main parameters

型号 Model	FS-ZL320/125
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破碎机功率 Crusher power	7.5KW
一级螺杆直径 First stage screw diameter	Φ320mm
电机搅料喂料功率 Motor feeding power	3kw
一级螺杆电机功率 First stage screw motor power	18KW
二级螺杆直径 Second stage screw diameter	Φ125mm
二级电机功率 Second stage screw motor power	7.5KW
电动换网电机 Electric screen changer motor power	3KW
换网器加热功率 Hydraulic screen changer heating power	2.6kw
切粒机功率 Pelletizer power	0.75kw
加热功率 Heating power	35kw
总功率 Total power	78kw
加热区数 Number of heating zones	6
产量 Throughput	150-180kg/h
适用材料 Applicable materials	PS 发泡废料 PSfoam scrap

2 主要部件 Main parts

主机 Main machine	2 台 set
切粒机 Pelletizer	1 台 set
水箱 Water tank	1 个 pc
控制柜 Control cabinet	1 个 pc
电动换网器 Hydraulic replace filter mesh device	1 套 set

Free Spare Parts List

名称 Name	数量 Quantity
温控表 Temperature controller	1 个 1 piece



龙口市富士包装机械有限公司

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热电偶 Thermocouple	2 个	2pcs
加热圈 Heating ring	2 个	2pcs
过滤网 Filter Screen	2 平方米	2m ²

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