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مستفيد خريفة ميرة ليبيا - طرابلس - رقم الهاتف_01: 091733319 - رقم الهاتف_02: 0913103162 - رقم الهاتف_03: 0923103162

Address: Al-Masira Al-Kubra Street / Opposite Al-Jumhouria Bank - Tripoli (Libya)

العنوان: خارج المصيرة الشريفي / مقابل مصرف الجمهورية - طرابلس (ليبيا)

Device name: Monofilament extrusion line (Online advanced)

◆ Design requirements

- The PET monofilament production line can produce monofilament diameter range:0.15-0.9mm
- Materials: PET bottle flakes and PP
- Power requirements: 380V, 50HZ (three-phase AC); 220V, 50HZ (single-phase AC)

◆ Performance and parameters of PET monofilament equipment

NO.	Description	Brief description of parameters	Remark
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1	Precision Single screw extruder	1.Screwø80mm, The ratio of length diameter:30:1,Output 120-150KG/H 2.Heating power 30KW,SIEMENS (China) inverter motor power 45KW. 3. Separate Electric control cabinet	
2	Single precision extrusion die head	1.Precision filter, easy replacement filter, The pressure sensor controls the extrusion pressure and the melt flow by adjusting the motor speed . 2.Usingø200mm spinneret,.The spinneret with a filter screen, suitable for PET flakes production!	Pressure sensing alarm and protection

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3	Cooling tank	1.304 stainless steel material production, lift type water level regulation, water surface fluctuation is very small, manual regulation of water flow.	
4	Slow roll device	1. Roller with hard chrome plated surface, internal hard gear transmission; 2. Built in lubricating oil box, continuous operation for 8 years zero fault; 3. 3KW motor+Turbine deceleration	
5	Hot stretch tank	1. 304 stainless steel material, pneumatic switch cover. 2. Thermal insulation, electric heating power 18KW.	

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6	Water remove device	1. The equipment is made of stainless steel 304, divided into two parts: air blowing and water absorption; The centrifugal fan is used to generate strong wind, which is guided by the box body to form a wind knife to remove the water on the surface of the tow. The sponge towel at the suction end will filter the water again, and the air pump will remove the water on the sponge to achieve the ideal effect of dewatering.	
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7	Fast roll stand	1. Roller with hard chrome plated surface, internal hard gear transmission; 2. With a pressure roller rubber device; built in lubricating oil box, continuous operation for 8 years zero fault 3. 7.5KW turbine decelerator	
8	Single duct on-line shaping drying path	1. For hot air products of the molecules tend to stereotypes, heating power 18kw, blower power 3kw. 2. Single PLC control operation and shutdown, with security and protection.	

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9	Silicone oil adding device	1. Frequency converter speed, add more convenient and Stainless steel roller. 2. Made of stainless steel, Use pneumatic pump cycles.	
10	Stereotype roll stand motor	1. Three Roller with hard chrome plated surface, internal hard gear transmission; 2. With 1 pressure roller rubber device; built in lubricating oil box, continuous operation for 8 years zero fault 3. 2.2kw hard surface gear motor	

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11	Stabilization	It could let the filament more smoothly when rewinding , And effectively prevent the traction slip, no fluctuation.	
12	Semi automatic winding machine (swinging)	1.The rolling device is simple, easy to operate. 2.Counting alarm function. 3.Shaker reduction of labor intensity 4. With two pcs square frame samples,Length is 137 cm.	
13	Control cabinet	1.Centralized control of PLC system of main machine case and some units (including the terminal and cable, cable into the cable by the customer).	

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14	Precision spinneret	Applicable to the production of 0.20-0.25mm (Or according to customer require)	
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◆ Options device

No.	Device description	Brief description of parameters
1	Horizontal drying machine	1. Dry amount of raw materials: 400KG/H 2. Motor power: 5.5kw 3. Electric heating power: 36KW
2	Frame type oven	The square frame is used for sharpening tow, can achieve the best effect of spring back.
3	Semi-automatic packaging machine	Semi-automatic packing machine with double work station fixture.
4	Automatic cutting machine	Automatic feeding, automatic cutting, safe, efficient and accurate.

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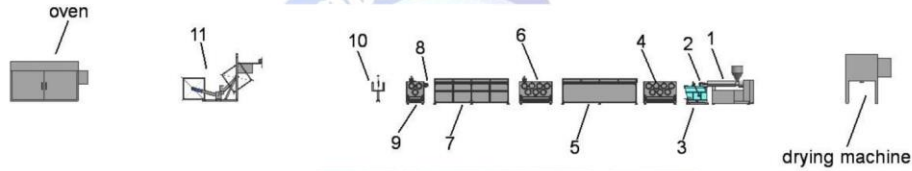
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Production line layout



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◆ Price(for reference only)

Item	Description	Qty./Unit	Amount(USD)
Main Equipment	Monofilament extrusion line	1 set	183,750.00
Option device	Horizontal drying machine	1 set	21,400.00
	Frame type oven	1 set	16,480.00
	Semi-automatic packaging machine	1 set	9,140.00
	Automatic cutting machine	1 set	16,170.00
TOTAL			246,940.00

◆ Delivery time: 120 working days.

◆ Installation and commissioning:

➤ After the equipment is finished producing, we recommend that customers send two employees(one of the electricians)to our

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company for systematic training and field operations.

➤ If the customer needs to go to his factory for commissioning, the following conditions must be met:

- The customer's factory has the conditions for installation and commissioning (water, electricity, compressed air);
- All the travelling cost and accommodation cost are responsible for the customer;
- Customer need to pay 200USD/day for each technical staff, working time is 8 hours/per day;
- Commissioning time is not more than 5 days.

2. Brush base making equipment(injection molding machine);

Device name: Injection Moulding Machine

Price(for reference only): 62,500.00USD*3 set=187,500.00USD(We recommend using 3 injection molding machines to match other equipments).

Please find detailed information below:

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1 Superb energy-saving
Grade 1 in national energy efficiency scale

2 Superior stability and reliability
• Patented circular platen reduces platen deformation and evenly distributes stress
• World-class servo-driven hydraulic system

3 High-performance and versatile screw designs
Result of more than 20 years of accumulated Japanese expertise

4 Silent operation
Average noise level 76.5dB(A) for JK250-MK6e

5 High speed, shorter cycle time
One of the fastest clamping, injection and ejection movements among competition

6 High precision

7 CPC-6.0 - The new standard in intelligent computer controller

China energy saving injection molding machine identification
最高 high 中等 middle 最低 low



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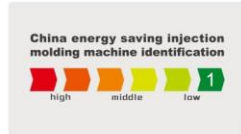
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1 Superb energy-saving

Highly-optimised hydraulics design leverages advanced servo-control system and leading-edge pump technology, resulting in reduced energy consumption



Servomotor and advanced gear pump

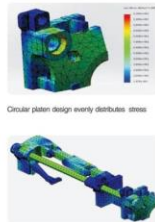


Grade 1 in national energy efficiency certification



Optimised machine base structure - strong and stable

2 Superior stability and reliability



Circular plate design evenly distributes stress



High-precision gear-based mold adjustment mechanism ensures stability and part quality



Named-brand servo-drive system



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3 High-performance and versatile screw designs

Japanese screw technology



Variations based on process requirements

Standard ribbed screw



UPVC screw - chrome-plated, corrosion-resistance, high surface finish (optional)



PC screw - chrome-plated, 42CrMo alloy steel (optional)

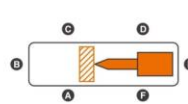


Mixing screws for high mixing demands



4 Silent operation

Advanced servo-control system contributes to extremely low operating noise



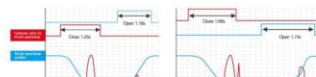
Noise level of JM200-MKGe (Euromap)						
Test position	1	2	3	4	5	Average level
A	79	78.2	78.4	78.6	79	78.84
B	75.8	77.4	77.6	77.4	76.2	76.88
C	76.5	77.1	77.8	76.9	77.4	77.14
D	76.7	74.9	75	74.9	74.9	75.68
E	76.4	76.4	76.3	76	76.2	76.26
F	75.3	75.3	75	74.9	74.6	75.05
Ambient	53					
						Average level 76.56(A)

5 Higher speed, shorter cycle time

Anatomy of a single dry cycle compared

Model	Clamping	Opening	Total Time	Stroke
JM200 MKGe	1.25	1.38	2.43s	330mm
Competition 28T	1.69	1.74	3.43s	330mm

Test mold specifications
Weight: 300kg
Dimensions: 450mmx400mmx300mm (LxWxH)





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6 Automatic mould-height/clamping force adjustment

Fully-automatic mould-height adjustment process is fool-proof and simple to use. You no longer need to measure the thickness of the mould, or manually adjust clamping force. With the new algorithm you simply put on a new mould, enter the desired clamping force, then press "OK". The machine does the rest, speedily and accurately, without mistakes. Complexity is greatly reduced and operating personnel training is mostly eliminated.



Automatic adjustment to the required clamping force



7 All new intelligent computer controller: CPC-6.0

Characteristics

- ① Designed and developed in Japan
- ② Complies with JIS and IEC testing standards
- ③ Named-brand high-definition 7" TFT color LCD screen
- ④ Wide power range: AC110V-AC280V, 50/60Hz
- ⑤ LED backlight with high brightness and long life
- ⑥ Advanced SMT technology with highest stability and reliability
- ⑦ Multiple languages
- ⑧ Intelligent fault diagnostics
- ⑨ Online operational instructions
- ⑩ Full suite of networking features as per Industrie 4.0



Industrie 4.0 meta-environment

Standard Features

- ① Storage for 150 sets of mould data
- ② Multi-stage authorization allows fine-grained access control
- ③ 8 sets of high-accuracy PID barrel temperature control (30°C-500°C)
- ④ Cold start prevention, automatic pre-heat, blocked nozzle alarm, overflow detection
- ⑤ Temperature range detection and broken thermocouple detection
- ⑥ 6-stage injection, 6-stage holding
- ⑦ 20 channels of sequential injection control (valve gates) by position and time
- ⑧ 6-stage plasticizing, 6-stage back pressure
- ⑨ Up to 6 core pulls and 6 air blows
- ⑩ Alarms history storage for maintenance and troubleshooting
- ⑪ Production quantity and batch control settings; automatically stops production when quantity reached
- ⑫ Automatic toggle lubrication with alarms
- ⑬ Cycle time monitor
- ⑭ Injection speed/pressure curves, compare with standard, and injection end position statistics
- ⑮ Status monitor screens show all inputs, outputs, timers and counters, convenient for maintenance and troubleshooting
- ⑯ Retrieval and storage of mould data internally or on external SD card (optional)



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3. Brush Tufting Machine

◆ Broom brush making machine(LS70-200B)



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1. Technical Data:

Features:

The available platform types are slope/vertical bristle angle. The tufting method: flat filament or Martin method, it equipped with 3 drilling heads and 2 tufting heads, can produce various brushes with 2 or 3 colors. It can store 1000 different brush programs and it is easy to make a new program.

The system is equipped with Mastercam software to realize remote assistance operation, remote control, and remote obstacle removal. It is easy to operate and has stable performance. It can be operated by directly importing the brush (broom) into the computer after three-dimensional simulation.

Configuration:

LS70-200B Five axis, three-drilling and two-planting machine



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Tufting head journey 70

LG(Korea) Servo Motor, Servo Drive

Beckhoff(Germany)control system

15 inch large screen monitor

Joint bearing imported from Germany

Bearing imported from Germany

Timing belt imported from Germany

FESTO(Germany) pneumatic components

Specifications

No.	Description	Specification	No.	Description	Specification
1	Number of axis	5	7	Filament length range(mm)	50-240
2	Production speed(holes/min)	900	8	Filament diameter range(mm)	2.5-8.0

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3	Tufting head	2	9	Power of engine(KW)	7.5
4	Drilling heads	3	10	Rated voltage/frequency(V.Hz)	380V,50Hz
5	Maximum length of brush plate(mm)	600	11	Weight(KG)	3600
6	Processing mode	Continuous	12	Dimensions(L*W*H)(mm)	3540*2000*2040

Parts list

No.	Description	Qty.	Unit	No.	Description	Qty.	Unit
1	Needles for filament	10	pcs	6	Cam bearing	2	pcs
2	Concave and convex surface of filament mouth	1	pair	7	Clamp	1	set
3	Knife for picking up filament	1	pc	8	Tool box	1	pc
4	Cam bearing for filament mouth	2	pcs	9	Drilling head	2	pcs
5	Sensor	2	pcs				

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مستفيد خريفة ميرة ليبيا - طرابلس - رقم الهاتف: 01_091733319 - رقم الهاتف: 02_0913103162 - رقم الهاتف: 03_0923103162

Address: Al-Masira Al-Kubra Street / Opposite Al-Jumhouria Bank - Tripoli (Libya)

العنوان: خارج المصيرة الشرقي / مقابل مصرف الجمهورية - طرابلس (ليبيا)

2. Price(for reference only)

No.	Goods description	Type	Parts	Unit Price(USD)	Quantity(set)	Amount(USD)
1	Broom brush making machine	LS70-200B	Mechanical system	46,875.00	1	46,875.00
			Working station	7,250.00	1	7,250.00
			Electrical system	44,375.00	1	44,375.00
			Software system	20,750.00	1	20,750.00
TOTAL						119,250.00
TOTAL TO SAY U.S.DOLLARS ONE HUNDRED NINETEEN THOUSAND TWO HUNDRED AND FIFTY ONLY.						

شركة ميرة للإستيراد والتصدير
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1. Technical Data:

Features:

Professional design, its advantages are: fast speed, high safety, good stability, easy to change products. The equipment can process one thousand brushes per hour in a continuous processing method, and the processed product has a smooth filament and a good effect.

Specifications

Type	KX350
Process head	7
Process model	Continuous
Maximum output per hour(pcs)	1000

سرحه ميره للإستيراد والتصدير
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Maximum brush board process length(mm)	350
Shortest filament process length(mm)	45
Longest filament process length(mm)	200
Energy consumption(kw)	3
Installed capacity(kw)	7
Air Consumption(nl/min)	30
Air pressure(bar)	6.5
Weight(KG)	800
Dimension(L*W*H, mm)	2000*900*1600

2. Price(for reference only): **24,000.00USD**

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In summary, there are a total of 4 machinery and equipment, and the quotations are summarized as follows:

No.	Goods Description	Qty./Unit	Amount(USD)	Remark
1	Brush filament making equipment	1/set	246,940.00	Including option device
2	Brush base making equipment(injection molding machine)	3/sets	187,500.00	
3	Brush tufting machine	1/set	119,250.00	
4	Brush smoothing and finishing machine	1/set	24,000.00	
Total			577,690.00	

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