
OFFER **no. 0404610** **08/12/2014**

PROJECT: **TWO PRESSES 125/38 1V WITH ONE DAYLIGHT AND ONE METERING MACHINE RSC
40/40 WITH ONE MIXING HEAD AND CONTAINER STATION (Layout LY.0.00515.R06)**

QUOTATION

TWO PRESSES FOR POLYURETHANE PANELS TYPE 125/38 1V

ONE DAYLIGHT

Platen dimensions	12500x3300	mm
Pressing platen stroke	450	mm
Max clamping force	260	tons
Max specific pressure	0,7	kg/cm ²
Opening clearance	200	mm
Loading side	3300	mm
Hydraulic pumps	100/2.4 x 4	l/min
Pump motor power	2 x 4	Hp
N. of clamping cylinders	28	mm
Cylinders diameter	90	mm



DESCRIPTION

The fabricated press structure is composed by **Fe 430B** steel profiles.
By CNC machine, all the assembling surfaces are machined to ensure the maximum assembling accuracy.
The structure is designed to withstand the deflections of the platen's width when charged at the maximum clamping force.
Double rack and pinion system on the length and on the width to grant the perfect movement of the platens.

PLATENS

Upper fix and lower movable platens structure made by welded beams; their surfaces are planed.
Lower platen with surface tool machined and covered by a thick iron sheet planed; motorised chains covered with rubber are located onto the platens to facilitate the loading/unloading phases.

Three sets of mechanical stoppers to control the position of maximum three panels loaded into the press.

Pneumatic centering system on the long sides for correct positioning of the panels before automatic foaming process.

Platens are not equipped to receive any heating medium.

HYDRAULICS

Oil control unit composed by **nr. 2** motor-pumps (high-low pressure).
The group includes a motor, high capacity pump/low pressure for fast approaching, low capacity pump/high pressure to slow the pressure delivery, automatic circuit breaker valve for pump exchange, safety max, pressure valve, stop pressure valve.

The groups are mounted above an oil tank needed for their working.

The oil control cylinders are the simple effect type, with diving shaft, thickness chromate, hardness of chrome 70 HCR Depth 100 Micron rectified and lubricated.

The shaft is mounted on self-lubricating bushings made of anti-friction alloy.

All the oil control components, cylinders, seals, pumps, piping, connections, etc. are designed to bear a max pressure of 350 bar, and are tested safely tested up to 700 bar.

FOUR AUTOMATIC MIXING HEAD MANIPULATORS

Sliding along the 12.500mm side by wheels on rails.
Motorized by pinion/rack system driven by an Hp 0,5 moto-reducer with fixed speed.
Chemical and hydraulic hoses from the metering machine to the mixing heads are included

LOADING SYSTEM

One motorised roller conveyors is installed on the loading side 3300 mm.
It facilitates the introduction of the panel in the press.

Dimension: **13.000 x 4.000 mm**
Distance between rollers 200 mm

Structure in welded steel profiles, adjustable in height in order to compensate any possible difference on the floor level.

Single body steel rollers welded ball bearing seats
Holding structure fully protected by stainless steel sheets.
Motorised with electrical motor..

ELECTRICAL CONTROL

The control panel is contained within a freestanding desk type console panel with all necessary instruments, including timer with different position, manometer, start-stop buttons: selecting switches for semi or fully automatic press function, one emergency switch, main indicator switch lamp.
Possibility to control full line from this control cabinet.

The wires from the press to the control cabinet are contained in a special raceway to protect them.
All the electrical and electro-mechanical items are referred to the electrical drawing provided with the instruction book on the press.
It is realized according to the last current legislative rules.

CONTROL BOARD

It controls and drives all the pressing phases, loading and unloading.
The controls and drives are obtained by an INTERNATIONAL REPUTED HARDWARE and a SOFTWARE developed by Krauss Maffei Italiana.

The PLC is composed of a CPU main unit, with a 128 KByte memory, EEPROM memory pad, STATUS and LED indications, expansion possibility of inputs and outputs, analogue inputs, analogue outputs, fast impulse counter.

The HARDWARE contains a SOFTWARE that runs the following functions:

- SELF TESTING when starting
- SELF TESTING in parallel development of the user program
- Errors control
- Short circuit control
- Transmission data between main unit and expansions

NOTE: safety fences, safety barriers and lights

ONE METERING MACHINE RIM-Star Compact 40/40 WITH ONE MIXING HEAD



Note: For your information only! Picture may included options not quoted.

Item / ZE	Quant	Material/Designation
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Mixing and metering machine
for the production of polyurethane mouldings

The machine has been built to the modular construction
concept and will be supplied with documentation as
follows

- Operating / maintenance manual
- Replacement parts list
- CE-conformity or CE-manufacturer`s declaration

The machine includes the following components:

Item / ZE	Quant	Material/Designation
RAW MATERIAL TANKS		
61.41610	2	Raw material tank RWB 250 without agitator, insulated - working- and safety valves unit - prepared for level probes and heating cartridge max. pressure/ effect. cap.: 4 bar/ 250 l double jacket: max. 3 bar, max. 80°C material: ST 37 temperature probe: PT 100
61.41654	2	Standard agitator RWB 250 with stuffing bush seal
61.4512	2	Fill level monitoring on the raw material tank four oscillating level probes (24 V DC) - Min. material level = switching off - Low level = refilling on - High level = refilling off - Max. level = emergency stop
61.46110	2	Automatic filling each component, consisting of: - down pipe - check valve - two-way directional valve with pneumatic actuating drive - potential-free contact for filling pump, without filling pump
61.47200	2	Heating cartridge 3 kW for raw material tank types 60 l/ 100 l/ 250 l/ 500l
61.4740	1	Air drying cartridge Silicagel type (1 piece)
SUCTION LINES		
61.1731	2	Suction line 40 l/min with edge filter (manually cleanable) - gap size: 0,2 mm polyol/ isocyanate - discharge cock

PUMPS

- 61.11410 1 Base frame RIM - Star Compact**
for mixing head hydraulic, 2 pump supports,
2 raw material tanks and control desk
Dimensions (LxW) ca.: 3600 x 2200 mm
- 61.12210 1 High pressure metering pump 40 l/min**
Axial piston pump: open circuit
Displacement: 28 cm³ / 1450 rpm
Handwheel adjustment: left
Mode of operation: suction mode
Viscosity: 20 - 3000 mPas
Adequate for polyurethane components
- 61.12211 1 High pressure metering pump 40 l/min**
Axial piston pump: open circuit
Displacement: 28 cm³ / 1450 rpm
Handwheel adjustment: right
Mode of operation: suction mode
Viscosity: 20 - 3000 mPas
Adequate for polyurethane components
- 61.15210 1 Support for HP pump 40 l/min**
Support for high pressure metering pump
pump and motor carrier with elastic coupling
- pressure transducer with display
- 61.15230 1 Support for HP pump 40 l/min**
Support for high pressure metering pump
pump and motor carrier with magnetic coupling
- pressure transducer with display
- SK: For Isocyanate**
- 61.1631 2 Drive of metering pump 40 l/min**
3-phase motor: 13,0 / 8,0 kW
rotational speed: 1440 / 710 RPM
voltage: 3 x 400 - 440 V, 50 Hz
3 x 460 - 480 V, 60 Hz
thermistor sensor
design: B5
protection category: IP 55

HIGH PRESSURE LINE - SYSTEM

- 61.7314** **2** **Volumetric flow meter**
gear counter: VC 3.0
viscosity range (mPas): 20 - 3000
measuring range (l/min): 116 - 12
- 61.74210** **2** **Component switch over unit**
for 2 components consisting of:
- 2 seating valves (DN 25)
- 4 ball valves
- 61.7822** **2** **Manual testing with two valves (28L)**
operated by a collective actuating shaft,
one check valve is placed in the discharge line
- 61.79308** **2** **Mounting pedestal**
for one mixing head switch over unit, piped up
high of pipework : on floor

MIXING HEADS

- 61.83372** **4** **Transfer mixing head MK 12/18 ULP-2KVV-G-80-I**
output rate, MR=1/1: 110 - 1300 g/s
suitable for rigid foam
discharge tube length: 80 mm
discharge tube diameter: 30 mm

E - CONTROL CABINET / E-CONTROL CONSOLE

- 61.0206** **1** **Control desk RP 4 - 40**
for pump size 4 - 40 l, with Siemens S7-300 control
and integrated operating panel OP 177 B for:
- 2 day tanks
- 2 mixing heads
- automatic filling
- cooling water regulation and the display of:
- 2 volumetric streams, 1 mixing ratio
 (available in combination with additional
 volumetric flow meters)
- 2 pressures (A and B)
- 2 temperatures (day tanks)
- dosing times (foaming programs)

E-CONTROL CABINET/ E-CONTROL CONSOLE - A

- 61.5518** **1** **Interface external installation**
with profibus (KM-Standard)
- KM Italy Standard DP-DP Coupler**
- 61.5535** **1** **Control heating for day tanks**
(2 pieces)

HYDRAULICS

- 61.6112** **1** **Mixing head hydraulic**
on base frame
- tank capacity: 100l
- feed pump: 22 l/ min., max. 200 bar
- high pressure and integrated return line filter
- min. oil level probe
- pressure accumulator 2,8 l
- 61.6217** **2** **Mixing head control block**
for MK 12/ 18 ULP - 2KVV - 80 mixing head includes:
- control valves
- pressure accumulator
- pressure display
- shut off cocks

ACCESSORY COMPONENTS

- 61.9960** **1** **Painting KraussMaffei standard**
Machine : RAL 9002 gray white
control desk : RAL 9002 gray white
control desk door : Pantone 7461 sky blue
Tank, Polyol : RAL 9006 white aluminum
Tank, Isocyanate : RAL 9006 white aluminum

61.99912 1

Documentation foreign language

Standard documentation in any foreign language consisting of:

1-fold: operation instruction, operation manual.

As far as available in a foreign language, otherwise in english.

1-fold: spare part list, electric circuit plan, hydraulic plan, flow sheet, documentation of the components of the facility components

copies of day tank pressure certificat (TÜV-certificate),

copies of the CE conformity or manufacturers declaration

1-fold: documentation on compact disk as described.

Acrobat Reader necessary for viewing.

1-fold: Electronic Spare Parts catalog as far as available in a foreign language, otherwise in english.

- Easy parts identification with linked/hotspotted position numbers

- integrated pictures supporting easy parts identification

- Layout and flow diagram linked and hotspotted with assembly groups and part lists

- part lists with clear structure and corresponding drawings

- easy to use search and printing functionality

- on CD-ROM, for multi-user installation

CONTAINER STATION FOR POLYOL AND ISOCYANATE

61.0230	2	Control desk container station for polyol or isocyanate, with Logo control
61.97224	1	Container station polyol functional complete unit consisting of: - base frame with drip pan - lift with electrical agitator - suction hose with tank truck coupling - gear pump with magnetic coupling
61.97227	1	Container station isocyanate functional complete unit consisting of: - base frame with drip pan - suction hose with Camloc coupling - gear pump with magnetic coupling
61.9965	2	Painting for miscellaneous assembly groups KraussMaffei standard colour Machine : RAL 9002 gray white control desk : RAL 9002 gray white control desk door : Pantone 7461 sky blue Tank, Polyol : RAL 9006 white aluminum Tank, Isocyanat : RAL 9006 white aluminum

Payment terms: 50% Down payment
50% against shipping documents

Should you intend to finance the machine (plant) by a leasing company through a takeover contract (order entry by the leasing company), we kindly ask you to send us the corresponding documents in time for checking and acceptance.

Terms: FOB Belgium excl. vat. transport quoted
seperately
Packing: TBD

Delivery time: approx. 4 months to be confirmed upon receipt of your official order, letter of credit and clarification of all commercial and technical details.

Please note: The attached general conditions which correspond to those of Mopac Systems International S.A. are to be applied to for the delivery of our machines, apparatus and plants for inland and foreign country deliveries.

We reserve the right for modifications and design alterations arising from advancing technical development.

We are bound by this offer for a period of 2 months.

Installation and commissioning: Included

Electric: Operating voltage 400 Volt 60 Hz
Control voltage 230 Volt AC 60 Hz
Valve voltage 24 Volt DC

Screening of machine against possibly existing interferences (e.g. electromagnetic capatibility) and safeguarding of the site against areas exposed to fire-risk are the customer's entire liability.

Warranty: Machine: As is by inspection

Any warranty is excluded in particular in the following instances:

Unsuitable

or unprofessional use, incorrect installation or commissioning by you or a third party, natural wear-and-tear, faulty or careless handling, maintenance not in conformity with specifications, unsuitable service products, defective Construction work, unsuitable base, chemical, electrochemical or electrical influences to the extent that these are not our responsibility.

Limitation of Liability:

We shall be liable for damage which has not arisen to the delivery item itself irrespective of the legal basis and subject to exclusion of further claims, only in the case of: intent or gross carelessness on the part of our Chief Executive Officers or higher management, or negligent injury to life, limb, health, or defects which we deviously failed to mention or the absence of which we have guaranteed.

We are liable moreover in conformity with the German Product Liability Act and maintain a product liability insurance with worldwide coverage.

We shall be liable by virtue of a guarantee only in such cases where the guarantee has been given as such in written form, and has been signed by one of our Chief Executive Officers. Moreover, our liability, for whatever legal reason, including liability for incorrect conduct on the part of our employees and subcontractors, is limited to the replacement of the direct damage which we can reasonably have foreseen, but to a maximum of 5 % of the net order value.

On no account are we liable for consequential damages such as lost profit, for increased or abortively or additionally retained production costs etc.

Claim for damages:

The seller undertakes no liability for loss of profit, loss of production, loss of use and/or other direct, indirect or consequential damages of any kind.