



滁州市泰来进出口贸易有限公司

CHUZHOU TAILAI IMPORT&EXPORT TRADING Co.,Ltd

地 址 : 安 徽 省 滁 州 市 南 谯 区 龙 蟠 南 苑

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1350 (PE) 涂布机技术配置

Specification of Coating machine 1350 (PE) SPF

概述:

本型号为专业生产 PE , PVC 保护膜 The coating machine is for making PE&PVC surface protective film purpose

1. 主要使用原材料: raw material

2.1 基材: substrate PE 膜 (膜厚 0.02~0.12mm) PE film(0.02-0.12mm)

2.2 胶水: adhesive 水性压敏胶 water based acrylic adhesive

2. 主要工艺: PE 膜放卷→牵引→涂胶→履带输送烘干→冷却储箱→双工位收卷

Production process:

PE film unwinding-traction-coating-oven-cooling&storage-dual station winding

4. 主要技术特点:

1. 本机型是我公司为专业生产 PE 橡胶型保护膜企业特别量身定制的产品。用于 PE 橡胶型保护膜的高效生产。此设备采用我公司自行设计专业定制的风机, 噪音低、风量大、风压稳定。独立开发设计的收卷机构更趋于成熟, 具有自动断膜减少浪费、收卷平整等特点。此设备为生产企业降低成本提高效率达到最经济, 最合理的生产成本及工艺流程。经过多客户使用性能稳定, 性价比极高。

2. 涂布系统:

2.1 网纹涂布, 具有逆向涂布, 设计合理, 涂布均匀, 褶皱、漏涂少, 胶面平滑,



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传动稳定的特点。

2.2 均胶方式多，可满足客户个性化需求

3. 干燥系统：

3.1 采用独到的干燥箱循环系统，配置自主研发的高效箱式低噪音风机，提高干燥箱效率。

3.2 干燥箱进、排风口均配置调节风门，并配置变频器控制风机转速，可根据工艺要求调整风压、风量，满足不同的生产工艺

3.3 风嘴同时可拆卸，清洗极为简便

4. 收卷系统

4.1. 收卷采用气胀轴

4.2 采用—涡轮蜗杆及电机定位，采用美国派克无杆气缸断膜

4.3 采用日本 SMC 恒压力调节阀

5. 电气系统：

5.1 整机采用交流电机驱动，配置高性能变频器与 PLC 可编程控制器及专有的自主研发软件控制，自动同步升降速

5.2 采用多点控制模式，操作及为简便

6. 纠偏系统：

6.1 收卷过程均采用无刷伺服自动纠偏机构，有效提高材料成品率

6.2 使用超声波探头，减少材料波动纠偏效果极佳



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7. 安全措施 :

7.1 整机多点安装急停开关,方便紧急停机

4.General Introduction:

This model is a product specifically customized for our company's professional PE and PVC protective film production. It is designed for high-efficiency manufacturing of PE protective films by water based adhesive. The equipment utilizes a self-designed, professionally customized fan from our company, featuring low noise, high airflow, and stable air pressure. The independently developed and designed winding mechanism is more mature, with features such as automatic film cutting to reduce waste and uniform winding. This equipment helps manufacturers reduce costs and improve efficiency, achieving the most economical and reasonable production costs and process flow. With stable performance and exceptional cost-effectiveness, it has been widely used by multiple clients.

2. Coating System:

2.1 Net pattern coating features reverse coating, rational design, uniform application, minimal wrinkles and missed spots, smooth adhesive surface, and stable transmission

2.2 There are multiple adhesives available, catering to customers' personalized needs

3. Drying System:

3.1 Equipped with a unique drying oven circulation system and a self-developed high-efficiency box-type low-noise fan, it enhances the efficiency of the drying oven.

3.2 The drying oven is equipped with adjustable dampers at both the air intake and exhaust ports, along with a frequency converter to control the fan speed, allowing for adjustments according to process requirements

Adjust air pressure and airflow to meet different production processes

3.3 The wind nozzle is detachable and extremely easy to clean

4.Winding System

4.1 The winding adopts an inflatable shaft

4.2 Using turbine worm and motor positioning, adopting American Parker rodless cylinder with broken film

4.3 Equipped with SMC constant pressure regulating valve from Japan

5. Electrical System:

5.1 The entire machine is driven by an AC motor, equipped with a high-performance frequency converter, a PLC programmable controller, and proprietary independently developed technology

Software control, automatic synchronous speed adjustment

5.2 adopts a multi-point control mode, making operation highly convenient

6. Correction System:



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6.1 The winding process employs a brushless servo automatic alignment mechanism, effectively improving material yield

6.2 Using an ultrasonic probe significantly reduces material fluctuation correction effects

7. Safety Measures:

7.1 Install emergency stop switches at multiple points on the machine for convenient emergency shutdown

规格与性能

- | | |
|-------------|----------------|
| 1. 涂布型式: | 网纹涂布 (反涂布) |
| 2. 有效涂布宽度 | 1350mm |
| 3. 辊面宽度 | 1450mm |
| 4. 机械速度 | 10-120m/min |
| 5. 最大放卷直径 | Φ800mm |
| 6. 最大收卷直径 | Φ400mm |
| 7. 烘箱总长 | 32 米 (4 米/节) |
| 8. 干燥加热方式 | 热风炉加热 |
| 9. 温度控制 | 最高 120℃ |
| 10. 卷取边缘整齐 | 端面整齐误差≤2mm |
| 11. 基材卷芯内经: | 收、放卷为 3” |
| 12. 机械总功率数 | 约 80KW |

主要配备:

- | | |
|-------|-----|
| 1、放卷架 | 1 组 |
|-------|-----|



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2、牵引	1 组
3、网纹涂布	1 组
4. 输送机构	1 组
5、干燥箱	8 节 (4m/节)
6、履带	1 组
7、冷却	1 组
8、储箱牵引	1 组
9、双工位收卷	1 组
10、加热系统	1 组
11、传动系统	1 组
12、电气系统	1 套
13、排风系统	1 组
14、钢架	1 组

Specifications and Performance

Coating method: mesh roller coating (reverse)

2. Effective Coating Width 1350mm

3. Roller surface width: 1450mm

4. Mechanical speed: 10-120 m/min

5. Maximum unwinding diameter: Φ 800mm

6. Maximum winding diameter: Φ 400mm

7. Total length of the oven 32 meters (4m/section)

8. Drying Heating Method Gas Heating(hot air furnace)

9. Temperature Control Maximum 120°C



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10. The coiled edges are neat.

The end face is neat with an error $\leq 2\text{mm}$

11. Core inner diameter of the substrate roll: 3" for both winding and unwinding

12. Total mechanical power approximately 80KW

Mainly equipped with

1. Unwinding stand	1 set
2. Traction	Group 1
3. Net Coating	1 Set
4. Conveyor system	1 set
5. Dry oven	8 sections (4m/section)
6. Track	1 set
7. Cooling	1 PC
8. Tank Tractor	1 Set
9. Dual-winding Reeling	(1 Set)
10. Heating system	1 set
11 Transmission System	1 Set
12. Electrical System	1 set
13. Exhaust system	1 set
14. Steel Frame	1 Set

一、放卷机构

1. 型式	双工位翻卷式放卷(无杆气缸自动断膜)
2. 有效放卷宽度	1350mm
3. 有效放卷直径	$\Phi 800\text{mm}$,
4. 放卷轴	凸键气胀轴 3" , 3 根 , (常州)
5. 放卷张力控制	10Kgf 磁粉制动器 2 套 (海安三菱)

张力检测反馈信号张力传感器获取, 张力控制器自动

控制(凯瑞达)

6 铝辊 $\phi 100 \times 1450$ 铝合金硬质氧化处理, 5 根



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- 7 . 翻卷机构 回转轴 Φ 114X10 无缝管 20mm 钢板拼接组成 ,
摆臂采用 30mm 钢板加工组成 , 压板式定位气帐 轴。
采用 2.2Kw 带刹车减速电机翻卷。 1 台 行程开关定位停止。
- 8 . 机架 采用 18mm 钢板 , 焊接厚度 120mm 组成。
- 9 . 纠偏型式 整体放卷架四轮定位自动纠偏。(超声波探头) 1 套
- 10 . 换料气动接膜机构 橡胶辊、钢辊、气缸控制运动。
橡胶辊 Φ 125X1450 表面包丁晴橡胶硬度 $60^{\circ} \sim 65^{\circ}$ 1 根
钢辊 , Φ 105X1450 , 表面镀硬铬 , 壹根、
- 11 断膜机构 采用平行式气缸前后控制 , 无杆气缸断膜气缸控制 , 1 套

1. Unwinding Mechanism

Type: Double-station unwinding with automatic film cutting (pneumatic cylinder without rod)

2. Effective unwinding width 1350mm

3. Effective unwinding diameter Φ 800mm,

4. Unwinding roll

Tapered key pneumatic expansion shaft 3", 3 pieces,(Changzhou)

5. Unwinding Tension Control

10Kgf Magnetic Powder Brake

2 sets (Hai'an Lanling)

The tension detection feedback signal is obtained by the tension sensor, and the tension controller automatically

Control (Kairuida)

6. Aluminum Roller Aluminum alloy hard anodized treatment, 5 pieces, 100X1450 in size

7. Flipping mechanism

The rotary shaft is composed of a seamless tube Φ 114X10 and 20mm steel plate splicing,

The swing arm is machined from a 30mm steel plate and consists of a pressure plate type positioning air chuck shaft.



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1 unit with a 2.2Kw brake-equipped geared motor for winding

The limit switch stops at the designated position.

8. Frame

Constructed by welding 18mm thick steel plates.

9 Correction Type Automatic alignment and correction of the four rollers on the entire unwinding frame. (Ultrasonic probe) 1 set

10 Material Replacement Pneumatic Film Connection Mechanism

Rubber roller, steel roller, and cylinder-controlled motion.

Rubber roller $\Phi 125 \times 1450$ with surface coating of nitrile rubber, hardness $60^\circ \sim 65^\circ$, 1 piece

Steel roller, $\Phi 105 \times 1450$, surface hard chrome-plated, one piece

11. Film Cutting Mechanism 1 set,

二、牵引机构

1. 牵引有效宽度 1350mm

2. 机架 采用 30mm 钢板及方管拼接组成。

3. 牵引辊 $\phi 180 \times 1450$, 钢辊表面丁晴橡胶, 硬度 $30 \sim 35^\circ$ 1 套, 镀铬处理, 20#钢 Q235A. 1 套

4. 舒展辊 弧形 $\Phi 100 \times 1450$ 表面包三元乙丙橡胶硬度 $60^\circ \sim 65^\circ$
1 根, 灵活性好。

5. 过渡辊 $\Phi 100 \times 1450$, 铝合金硬质氧化处理, 一体辊。3 根

6 调节辊 $\Phi 100 \times 1450$, 铝合金硬质氧化处理, 一体辊。1 根

7 牵引辊传动 采用 1.5Kw 电机, 斜齿轮减速电机, 变频调速。1 套

8. 摆辊机构 SMC 低摩擦无阻力气缸配合直线电位器,

张力检测 反馈信号直线电位器获取, 闭环张力控制。1 套

2. Traction Mechanism

1. Effective traction width: 1350mm



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2. Racking

Constructed from 30mm steel plates and square tubes joined together.

3. Traction Roller: Steel roller surface with nitrile rubber, hardness 30-35°, 1 set, chrome-plated, 20# steel, Q235A, 1 set

4 Stretch roller with an arc shape of $\varnothing 100 \times 1450$ and a surface made of EPDM rubber with a hardness of 60 °~65 ° 1 piece, with good flexibility.

5 Transition roller with a diameter of $\varnothing 100 \times 1450$, treated with hard oxidation of aluminum alloy, integrated roller. 3 pieces

6 Adjust the roller with a diameter of $\varnothing 100 \times 1450$, aluminum alloy hard oxidation treatment, integrated roller. 1 piece

7 The traction roller drive adopts a 1.5Kw motor, a helical gear reduction motor, and variable frequency speed regulation. 1 set

8. Swing roller mechanism SMC low friction no resistance cylinder combined with linear potentiometer, tension detection

Feedback signal linear potentiometer acquisition, closed-loop tension control. 1 set

三、网纹涂布机构

- | | |
|--------------------------------------|--|
| 1. 型式 | 网纹涂布(反涂布) |
| 2. 网纹辊 | $\varnothing 210 \times 1450$ (网纹辊目数由用户提供) 1根 |
| 3. 有效涂布宽度 | 1350mm |
| 4. 机架 | 采用 40mm 钢板及方管拼接组成, 提高运行中的稳定性 |
| 5. 刮刀 | 刮刀采用齿轮减速电机控制摆动, 采用蜗轮蜗杆翻转, 采用铝板结构, 气缸压紧松开。 |
| 6. 反擦辊 $\varnothing 100 \times 1450$ | 采用直线导轨上下, 特氟龙处理, 气缸控制, 2根 |
| 7. 均胶机构 | $\varnothing 45 \times 1450$ 圆棒均胶, 独立电机调速。1套
$\varnothing 45 \times 1450$ 圆棒均胶, 左右移动, 气缸控制。1套 |
| 8. 胶槽 | 2mm 冷板制作, 手动升降, 整体特氟龙处理, 1套 |
| 9. 电机 | 斜齿轮减速电机 2.2KW, 1台 |



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10 过渡辊 $\Phi 100 \times 1450$, 铝合金硬质氧化处理。 4 根

11 舒展辊 弧形 $\Phi 100 \times 1450$ 表面包三元乙丙橡胶
硬度 $60^{\circ} \sim 65^{\circ}$ 2 根, 灵活性好。

12. 运动形式 气压可以调节, 采用电磁阀控制, 停机气缸自动动作, 网纹辊可自转, 反擦辊及脱膜均采用气缸控制。

3.Mesh roller coating mechanism(Gravure coating)

1. type of coating (reverse coating)
2. Mesh roller with a diameter of $\Phi 210 \times 1450$ (mesh size provided by the user) 1 piece
3. Effective coating width 1350mm
4. The rack is composed of 40mm steel plate and square tube splicing to improve stability during operation
5. The scraper adopts a gear reduction motor to control the swing, and uses a worm gear to flip,
Adopting an aluminum plate structure, the cylinder is tightened and loosened.
6. The anti friction roller with a diameter of $\Phi 100 \times 1450$ adopts a linear guide rail for up and down, treated with Teflon, controlled by a cylinder, with 2 pieces
7. Uniform adhesive coating device $\Phi 45 \times 1450$ round bar with uniform glue coating, independent motor speed control. 1 set
The round rod with dimensions of $\Phi 45 \times 1450$ is evenly glued and moves left and right, controlled by a cylinder. 1 set
8. glue tank 2mm cold plate production, manual lifting, overall PTFE treatment, 1 set
- 9 Motor helical gear reduction motor 2.2KW, 1 set
- 10 Transition roller with a diameter of $\Phi 100 \times 1450$, treated with hard oxidation of aluminum alloy. 4 pieces
- 11 Stretch roller with a curved shape of $\Phi 100 \times 1450$. The surface of the bread is made of EPDM rubber with a hardness of $60^{\circ} \sim 65^{\circ}$
2 pieces, with good flexibility.
- 12 The air pressure can be adjusted and controlled by an electromagnetic valve. The shutdown cylinder automatically operates, and the mesh roller can rotate on its own. The anti friction roller and film stripping are both controlled by cylinders.

四、 输送辊机构



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1. 输送有效宽度 1350mm
2. 输送辊 $\phi 135 \times 1450$, 包硅橡胶 (精磨) 邵氏 A 硬度 30~35, 安装在均胶出口前。
3. 输送辊传动 采用斜齿轮减速电机 1.1KW, 变频调速。 1 套

4、Conveyor roller mechanism

1. Effective conveying width 1350mm
2. Conveyor roller $\phi 135 \times 1450$, wrapped in silicone rubber (precision ground) with a Shore A hardness of 30-35, Installed before the adhesive outlet.
3. The transmission of the conveyor roller adopts a helical gear reduction motor of 1.1KW and variable frequency speed regulation. (1 set)

五、烘箱机构

1. 型式 外置侧开门式热循环烘箱, 热循环风机及回风管
排风管在烘箱顶部,
2. 喷嘴 狭缝式, 1.0mm 不锈钢板, 可抽出清洗。
3. 长度 4000mm/节。
4. 热源 热风炉加热。
5. 温度 最高 120°C
6. 保温 充填超细玻璃棉加岩棉板, 厚度 80mm。
7. 循环风机 高效箱式风机, 5.5KW/6 台, 3KW/2 台, 变频调速。
8. 框架 采用 10#槽钢及方管钢板焊接组成
9. 烘箱外壁板材料 1.5mm 冷板。



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|---|---|
| 10. 烘箱内壁侧板材料 | 1.0mm 不锈钢板。 |
| 11 . 烘箱内壁底板材料 | 1.0mm 不锈钢板。 |
| 12 . 烘箱内壁顶板材料 | 1.0mm 不锈钢板。 |
| 13 烘箱风胆材料 | 1.5mm 不锈钢板。 |
| 14 . 循环风管材质 | 0.8mm 镀锌板。 |
| 15 风管密封 | 接头处采用 3mm 石棉绳密封。 |
| 16 导辊 | 不锈钢辊上层 8 根 ,钢辊表面镀铬下层 2 根 ,两端为调心轴承外置式。 |
| 17 风管调节阀 | 排风口回风口各安装手动调节装置 壹套
采用小涡轮蜗杆结构 , 安装在风管外侧方便调节 |
| 18 新风吸风口 | 调节装置一套 , 。 |
| 19 烘箱内部结构 | 内侧全部不锈钢内包结构 , 风胆上下调节。 |
| 20. 烘箱内侧带吸布机构 , 预防材料卷边。电机:2.2KW、3 台 , 变频控制。 | |

5 .Oven mechanism

1. External side open-cycle heat circulation oven heat circulation fan, and circulation air duct located at the top of the oven, the exhaust duct is also on the top of the oven.
2. nozzle slit type, 1.0mm stainless steel plate, can be pulled out for cleaning.
3. Length 4000mm/section.
4. Heat source: Thermal oil.
5. The maximum temperature is 120 °C
6. Insulation filling with ultra-fine glass wool and rock wool board, with a thickness of 100mm.
7. High efficiency box type circulating fan, 5.5KW/9 units, 3KW/1 unit, variable frequency speed regulation.
- 8.Frame Composed of welded 10 # channel steel and square tube steel plates
- 9 The outer wall of the oven is made of 1.5 mm cold plate material.



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- 10 The inner wall side plate material of the oven is 1.0mm stainless steel plate.
 - 11 The bottom plate material of the inner wall of the oven is 1.0mm stainless steel plate.
 - 12The top plate material of the inner wall of the oven is 1.0mm stainless steel plate.
 - 13 Oven air duct material: 1.5mm stainless steel plate.
 - 14 The material of the circulating air duct is 0.8mm galvanized sheet.
 - 15The sealing joint of the air duct is sealed with 3mm asbestos rope.
 - 16There are 8 stainless steel rollers on the upper layer of the guide roller, and 2 chrome plated lower layers on the surface of the steel roller
The end is an externally mounted self-aligning bearing.
 - 17 Install one set of manual adjustment devices for the exhaust and return air outlet of the air duct regulating valve
Adopting a small turbine worm structure, installed on the outside of the air duct for easy adjustment
 - 18 A set of fresh air intake adjustment device
 - 19The internal structure of the oven is entirely covered with stainless steel, and the air duct can be adjusted up and down.
 - 20 The inside of the oven is equipped with a cloth suction mechanism to prevent material curling. Motor: 2.2KW, 3 units, variable frequency control.

六、履带

1. 履带有效宽度 1420mm
2. 履带动力辊 $\phi 210 \times 1500$ 钢辊、表面镀硬铬 1 根
3. 履带被动力辊 $\phi 210 \times 1500$ 钢辊、表面镀硬铬 1 根
4. 履带材料 防静电布, 耐温 120℃
5. 履带传送电机 采用斜齿轮减速电机 3kw, 1 台
6. 涨紧机构 采用直线导杆加直线轴承机构, $\phi 105 \times 1500$ 加厚钢辊气缸涨紧, 1 套
7. 纠偏机构 采用直线导杆加直线轴承机构, $\phi 100 \times 1500$ 加厚
钢辊电子纠偏, (超声波探头) 2 根
8. 履带过渡辊 $\phi 105 \times 1500$ 表面镀硬铬。



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9. 履带结构

履带内循环，涨紧在外，纠偏在外。

6.Conveyor belt unit

1. The effective width of the conveyor belt is 1420mm
2. Track power roller ϕ 210X1500 steel roller, surface coated with hard chrome
1 piece
3. The track is equipped with a power roller of ϕ 210X1500 steel roller and one surface coated with hard chromium
4. Track material anti-static cloth, temperature resistant to 120 °C
5. The track conveyor motor adopts a helical gear reduction motor of 3 kw, 1 set
6. The tensioning mechanism adopts a linear guide rod and linear bearing mechanism, with a thickness of ϕ 105X1500
Steel roller cylinder tensioning, 1 set
7. The correction mechanism adopts a linear guide rod and linear bearing mechanism, with a thickness of ϕ 100X1500(2 pieces)
Steel roller electronic correction, (ultrasonic probe) 1 piece
8. The surface of the track transition roller ϕ 105X1500 is coated with hard chromium.
9. Track structure: The track circulates internally, tightens externally, and corrects externally.

七、冷却机构

1. 型式 墙板式单辊冷却
2. 冷却辊 ϕ 500X1450, 表面镀硬铬、精磨, 20#钢 Q235A 配旋转接头。 1 套
3. 牵引防粘辊 ϕ 141X1450, 表面镀等离子, 20#钢 Q235A。 1 根
4. 冷却辊传动 采用 3Kw 电机, 变频调速, 配涡轮蜗杆减速器 1 套
5. 舒展辊 弧形辊 ϕ 100X1450 表面包三元乙丙橡胶硬度 60° ~65° 弧度 15° / 2 根



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- 6. 过渡辊 $\Phi 100 \times 1450$, 铝合金硬质氧化处理。 2 根
- 7. 机架 采用 30mm 厚墙板结构, 提高运行中的稳定性。
- 8. 摆辊机构 SMC 低摩擦无阻力气缸配合直线电位器, 张力检测
反馈信号直线电位器获取, 张力自动控制 1 套
- 9. 纠偏型式 出烘箱自动纠偏 (超声波探头) $\Phi 100 \times 1500$ 弧形辊 1 套

7. Cooling mechanism

- 1. Type: Wall panel type single roll cooling
- 2. Cooling roller $\phi 500 \times 1450$, surface coated with hard chromium and finely ground, made of 20 # steel Q235A Equipped with rotary adapter. 1 set
- 3. Traction anti sticking roller $\phi 141 \times 1450$, surface embossed with plasma coating, made of 20 # steel Q235A. 1 piece
- 4. The cooling roller drive adopts a 3Kw motor, variable frequency speed regulation, and is equipped with one set of turbine worm reducer
- 5. Stretch roller, curved roller with a diameter of $\phi 100 \times 1450$, surface coated with EPDM rubber with a hardness of $60^{\circ} \sim 65^{\circ}$ radians $10^{\circ} \times 2$ pieces
- 6. Transition roller with a diameter of $\phi 100 \times 1450$, treated with hard oxidation of aluminum alloy. 2 pieces
- 7. The rack adopts a 30mm thick wall panel structure to improve stability during operation.
- 8. Swing roller mechanism SMC low friction no resistance cylinder combined with linear potentiometer, tension detection Feedback signal linear potentiometer acquisition, 1 set of automatic tension control
- 9. Correction type: Automatic correction of oven (ultrasonic probe) with a curved roller of $\phi 100 \times 1500$ 1 set

八、储箱机构

- 1. 形式 墙板式肆辊储架, 储膜长度 10 米
- 2. 防粘辊 $\phi 100 \times 1450$ 铝辊表面镀等离子处理。 5 根
- 3. 浮辊 $\phi 100 \times 1450$ 铝合金氧化处理。 4 根



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- 4. 舒展辊 $\Phi 100 \times 1450$ 弧形式。1 根
 - 5. 机架 采用 30mm 厚墙板结构，提高运行中的稳定性。
 - 6. 储箱浮辊 采用直线轴承气缸控制及自动复位电位器，

导杆采用进口高硬度直线轴配直线轴承，精密调压阀控制气缸上下。1 套

8.Storage container mechanism

- 1. Form wall mounted four roll storage rack, with a film storage length of 10 meters
- 2. Anti sticking roller $\phi 100 \times 1450$ aluminum roller surface coated with plasma treatment. 5 pieces
- 3. Floating roller $\phi 100 \times 1450$ aluminum alloy oxidation treatment. 4 pieces
- 4. Stretch roller in the form of a $\phi 100 \times 1450$ arc. 1 piece
- 5. The rack adopts a 30mm thick wall panel structure to improve stability during operation.
- 6. The storage tank float roller adopts linear bearing cylinder control and automatic reset potentiometer,The guide rod adopts imported high hardness linear shaft with linear bearings,The precision pressure regulating valve controls the up and down of the cylinder. 1 set

九、双工位收卷

- 1. 型式 双工位表面加压中心卷取。(可接触式、间隙式收卷可选)

两种收卷形式，人机界面。

- 2. 有效收卷宽度 1350 mm
- 3. 机架 采用 30mm 厚板加工
- 4. 回转型式 采用大摆臂、蜗轮蜗杆减速器带刹车电机回转
- 5. 收卷 采用变频调速、离合器 (江苏兰菱机电科技有限公司、FL100)

加闭环张力控制器控制收卷



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6. 收卷最大直径 $\phi 400\text{mm}$
7. 收卷轴 3 " 凸键通条式气胀轴, 单侧下卷, 小卷不复卷。 2 根
8. 纠偏型式 整机收卷架自动纠偏 (超声波探头) 1 套
9. 弧形舒展辊 弧形辊 $\phi 100 \times 1450$ 表面包三元乙丙橡胶硬度 $60^{\circ} \sim 65^{\circ}$
弧度 10° 1 根
10. 调节辊 $\phi 100 \times 1450$ 铝辊表面镀等离子, 两端配调心轴承。 1 根
11. 橡胶压辊 $\phi 320 \times 1450$, 聚氨酯胶辊, 胶层厚 $20 \sim 25\text{mm}$, 硬度邵氏 A40~45 1 根,
气缸控制, 电磁阀控制气缸。平行前进后退。滑动采用高精度直线导轨。
小车前进后退采用滚珠丝杆, 齿轮减速电机 1 套
- 12 收卷牵引辊 $\phi 150 \times 1450$, 表面镀等离子。 1 根
- 13 张力传感器 张力检测反馈信号张力传感器获取, 张力控制器自动控制。 1 套
- 14 离合器 10kgf 磁粉离合器 1 套
- 15 传动电机 采用斜齿轮减速电机 1.5KW 牵引 1 台
采用斜齿轮减速电机 2.2KW 收卷 1 台
采用斜齿轮减速电机 1.5KW 橡胶辊 1 台
- 16 橡胶压辊运动气缸气压精密可调, 采用精密恒压力调节阀, 自动断膜。
17. 收卷橡胶辊运动采用精密减速电机, 滑动采用高精度直线导轨, 采用日本 SMC 恒压力调节阀,
- 18 采用无杆气缸, 自动断膜, 自动换卷。



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9. Double station winding

1. Type: Double station surface pressure center coiling. Two winding forms (touchable and gap winding optional), human-machine interface.

2. Effective winding width 1350 mm

3. The rack is processed with 30mm thick plate

4. The rotation type adopts swing arm, worm gear reducer with brake motor rotation

5. The winding is controlled by variable frequency speed regulation, clutch (Jiangsu Lanling Electromechanical Technology Co., Ltd., FL100) and closed-loop tension controller

6. Maximum diameter of winding ϕ 400mm

7 Winding roll shaft :3 "convex key strip type inflation shaft, rolled down on one side, no rewinding for small rolls. 2 pieces

8. Correction type: 1 set of automatic correction (ultrasonic probe) for the whole machine winding rack

9. Curved stretching roller, curved roller with a diameter of ϕ 100X1450, surface coated with EPDM rubber with a hardness of 60 °~65 ° and a curvature of 10 °, 1 piece

10. Adjusting roller: The surface of the ϕ 100X1450 aluminum roller is coated with plasma, and both ends are equipped with self-aligning bearings. 1 piece

11. Rubber pressure roller ϕ 320X1450, Polyurethane rubber roller, adhesive layer thickness of 20-25mm, hardness of A40-45 Shore A, 1 piece,Cylinder control, solenoid valve controls the cylinder. Parallel forward and backward.The sliding adopts high-precision linear guide rails. The car adopts ball screw for forward and backward movement, and 1 set of gear reduction motor

12. The winding traction roller has a diameter of ϕ 150X1450 and is coated with plasma coating on the surface. 1 piece

13. Tension sensor tension detection feedback signal tension sensor acquisition, tension controller automatic control. 1 set

14. One set of 10kgf magnetic powder clutch for clutch

15 The transmission motor adopts a helical gear reduction motor with a power of 1.5KW to pull one unit

Using a helical gear reduction motor with a capacity of 2.2KW for winding 1 unit

1 set of 1.5KW rubber roller using helical gear reduction motor

16 The air pressure of the rubber roller movement cylinder is precisely adjustable, and a precision constant pressure regulating valve is used to automatically break the film.

17. The winding rubber roller adopts a precision reduction motor for movement, a high-precision linear guide for sliding, a precision constant pressure regulating valve(SMC),

18. a rodless cylinder, automatic film breakage, and automatic roll replacement.



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十、加热系统

1. 热源; 天然气(广东热风炉直燃式 40 万大卡, 风机 11KW 变频控制)
2. 加热型式; 热风炉外置热循环式, 热风炉放在机架下面。
3. 加热控制 采用温控表微调电动执行器控制温度, 温度 $\pm 2^{\circ}$ 。

10.Heating system

1. Heat source; Gas, Guangdong Hot Air Furnace Direct Combustion Type (400,000 kcal, 11KW Fan with Variable Frequency Control)
2. Heating type; The hot air furnace is of the external heat circulation type, with the furnace placed beneath the machine frame
3. Heating control: Adopting a temperature control meter to fine tune the electric actuator to control the temperature, with a temperature of $\pm 2^{\circ} \text{C}$

十一、传动系统

1. 型式 三相交流异步电动机变频调速汇川
2. 运行方式 共有 9 个单元
 - 1) 牵引机构
 - 1) 网纹涂头
 - 2) 上下均胶机构
- 3) 输送辊机构
- 4) 履带
- 5) 冷却机构
- 6) 收卷牵引
- 7) 收卷橡胶辊



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8)收卷轴

3. 控制方式 自动控制 9 个单元进行同步运行

11.Transmission system

1. Type Three phase AC Asynchronous Motor Variable Frequency Speed Control
Huichuan

2. There are a total of 9 units in the operation mode

1) Traction mechanism

2) Mesh coating head

3) uniform adhesive coating amount device

4) transmission roller device

5)conveyor belt device

6) Cooling mechanism

7) winding& traction

8)winding rubber roller

9) roll winding shaft

3. Control mode: automatically controls 9 units for synchronous operation

十二、电气控制系统

电气控制系统(节能总控电气设计，全变频传动控制)

1. 型式：主电柜集中控制(立式)，1 台，放卷、网纹、收卷控制面板，电气柜柜门带有 密封条，密闭良好，装有轴流风机对流散热，照明灯及散热风扇通过门开关 互锁控制，安全节能，

2. 温控表：8 只常州，热电阻测温。

3. 长度计米器：接近开关计米(欧姆龙)

4. 接触器、(施耐德)继电器、(ABB)

5. 变频器汇川

6. 带座轴承湖北黄石，其他哈尔滨及 NSK

7. 警铃:2 只



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8. 涂布头、收卷均能进行自动启动、停止和速度调节，并带急停按钮。
9. 循环风机及排风风机采用变频器控制人机界面(汇川)
10. 整机电器采用施耐德系统，PLC 总控制。

12.Electrical control system

Electrical control system (energy-saving overall control electrical design, fully variable frequency drive control)

1. Type: Centralized control of main electrical cabinet (vertical), 1 unit, unwinding, mesh and winding control panel, electrical cabinet door with sealing strip, well sealed, equipped with axial flow fan for convective heat dissipation, lighting and cooling fan controlled by door switch interlock, safe and energy-saving,

2. Temperature control meter: 8 pieces Changzhou, thermal resistance temperature measurement.

3. Length meter: proximity switch meter (Omron)

4. Contactors, Schneider relays (ABB)

5. Inverter Huichuan

6. Bearing with seat in Huangshi, Hubei, other cities in Harbin and NSK

7. Alarm bells: 2 pieces

8. The coating head, and rewinding can all be automatically started, stopped, and speed adjusted, and come with an emergency stop button.

9. The circulating fan and exhaust fan adopt frequency converter control human-machine interface (Huichuan)

10. The entire electrical system adopts Schneider system and PLC overall control.

名 称 name	规格及品牌 brand/specification
PLC	施耐德 Schneider
人机界面 HMI	台湾(维纶)WEILUN(TAIWAN)
电机 Motor	西门子 SIEMENS



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减速机 reducer	速博雷尔 SUPROR
张力传感器张力仪 tensioner sensor	重庆东登 Dongdeng(China Chongqing)
参与张力控制变频器 frequency converter	汇川 Huichuan
电子纠偏 Electric rectify	无锡精控 Wuxi JINGKONG(China Wuxi)
低压元器件 low voltage component	施耐德及 ABBSchneider&ABB
轴承 bearing	哈尔滨及 NSK HAIERBIN& NSK
主要气动元件 Pneumatic components	台湾新恭及 SMC XINGONG&SMC TAIWAN
风机 fan	上海 SHANGHAI
风机变频 Fan converter	汇川 Huichuan
斜齿轮减速器 Helical gear reducer	常州慧尔德 Changzhou Huierde
无杆气缸 Rodless cylinder	美国派克 PARKER(USA)

1. 排风风机: 采用 3 台 1.5KW 离心式风机抽风 (变频控制)
2. 风管材质: 0.8mm 镀锌板
2. 风管密封: 接头处采用 3mm 石棉绳密封



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13.Exhaust system

1. Exhaust fan: three sets of 1.5KW centrifugal fans are used for exhaust (frequency conversion control)
2. Material of exhaust duct: 0.8mm galvanized sheet
3. Duct sealing: 3mm asbestos rope is used to seal the joint

十四、钢架

1. 型式 拱型机架
2. 材料 采用 200X100X5 方管、200X200X5 方管 20#槽钢及 10mm 钢板拼装组成。
3. 踏步板 3mm 花纹板及 80X50 方管焊接组成。
4. 整机颜色白色、扶手黄色加黑色。

附 A : 需方厂房要求和承担事项

1. 电源 三相, 50HZ, 380V。(线径 \geq 95 平方米)
2. 冷水源 冷却辊处进、出冷却水管 1”。
3. 气源 空压机或空压站, 每小时供气 0.9 立方米。
4. 厂房 室内净高 6M 以上。
5. 涂布机本体至排风机间的引风管的材料及施工, 涂布机本体至电工间的主线路、以及排风机的安装。
6. 加热管路的保温材料及施工。
7. 涂布机本体与加热源的接管材料及施工。
8. 整机接地, 接地电阻小于 4 欧姆, 且不能与避雷系统接地线共地。

14.Steel frame

1. Arched frame type



滁州市泰来进出口贸易有限公司

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2. The material used is 200X100X5 square tube, 200X200X5 square tube, 20 # channel steel, and 10mm steel

Composed of assembled boards.

3. The step board is composed of 3mm patterned board and 80X50 square tube welded together.

4. The overall color of the machine is white, with yellow and black handrails.

Attachment A: Requirements and Responsibilities of
the Buyer's Factory Building

1. Three phase power supply, 50HZ, 380V. (Wire diameter \geq 95 square meters)

2. The inlet and outlet cooling water pipes at the cooling roller of the cold water source are 1 ".

3. Air source compressor or compression station, supplying 0.9 cubic meters of gas per hour.

4. The indoor net height of the factory building should be at least 6 meters.

5. The material and construction of the induced draft duct between the coating machine body and the exhaust fan, the main circuit between the coating machine body and the electrician room, and the installation of the exhaust fan.

6. Insulation materials and construction for heating pipelines.

7. The material and construction of the connection between the coating machine body and the heating source.

8. The whole machine should be grounded with a grounding resistance of less than 4 ohms and cannot be grounded together with the grounding wire of the lightning protection system.