



上海永明机械制造有限公司



***Quotation of the PU Sandwich Panel
Product Line(YMPU-PRL-1)***

2007

The period of validity is before 2007-12-30 of this quotation.

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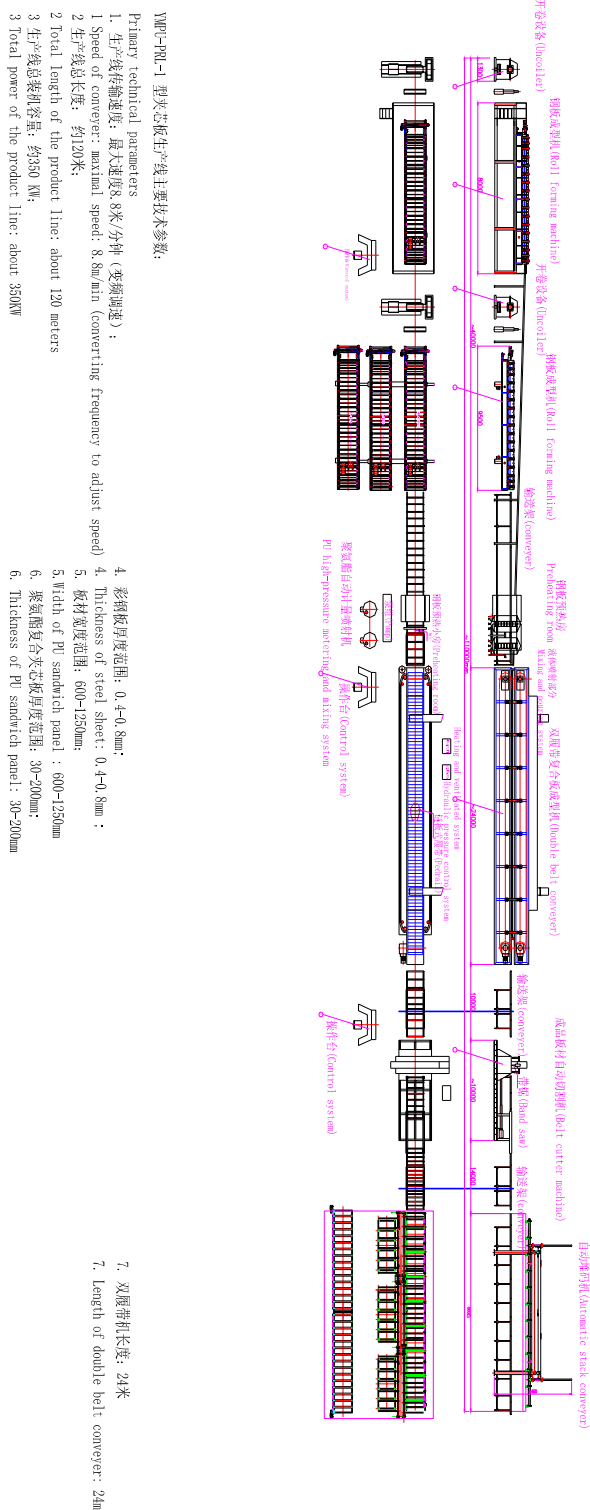
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1. YMPU-PRL-1 聚氨酯夹芯板生产线设备排布图 The sketch of YMPU-PRL -1PU sandwich panel product line

聚氨酯夹芯板生产线排布简图/The sketch of PU sandwich panel product line



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2.The list of the product line consists of components and the technical data of the product line:

生产线组成列表如下:

NO.	Composing of product line:生产线组成:	Amount 数量
1	Two sets of Uncoiler 自动开卷机	2
2	Steel panel transverse cutting machine、steel panel surface PVC film covering device 钢板横切断装置,钢板 PVC 膜覆膜装置	2
3	Roll forming machine(4 sets) and platform(up and down) 压型机及平台	
4	Conveyer rack 输送架	1
5	Pre-heating room 预热房	1
6	PU two component Liquid mixing and injecting section for foaming 聚氨酯二组分混合浇注装置	1
7	Foaming and the maturing double belt machine include Hydraulic pressure control system and 4 sets side nylon seal blocks to make wall panel and roof panel 双履带机包括液压装置,侧面尼龙挡块-可用于制造屋面板,墙面板	1
8	Heating and heat insulation system 加热通风及保温系统	1
9	Panel automatically cutting system 自动切割机	1
10	conveyer and automatic stacking machine:输送及自动堆码机	1
11	Electric control system 电气控制系统	1

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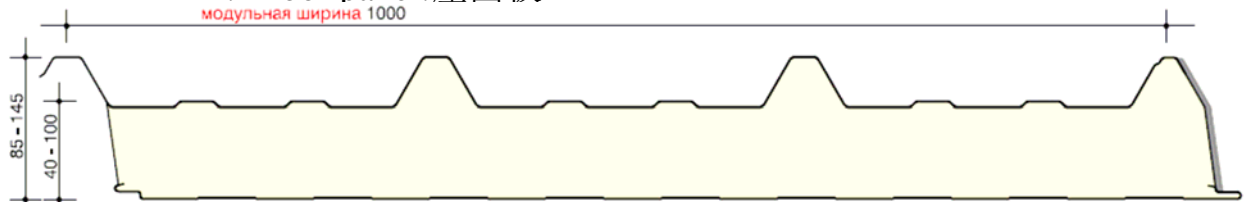
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3. This product line could make two kinds of sandwich panel:

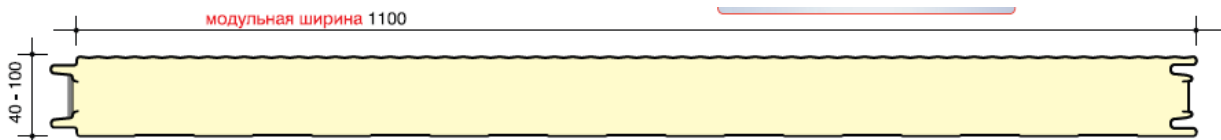
该生产线可生产二种夹芯板.

1. Roof panel: 屋面板

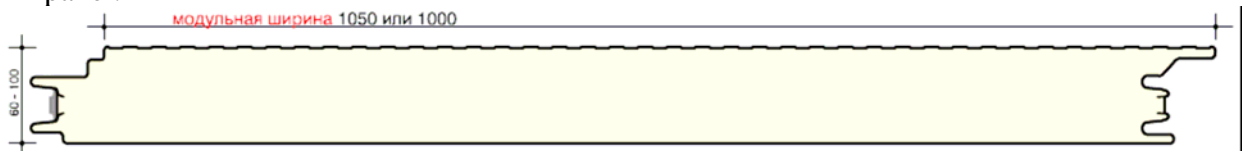


Note: The thickness of the sandwich panel is 40mm-100mm. But in this product line, the seller only supply the side nylon seal block to make the 40mm thickness sandwich panel.

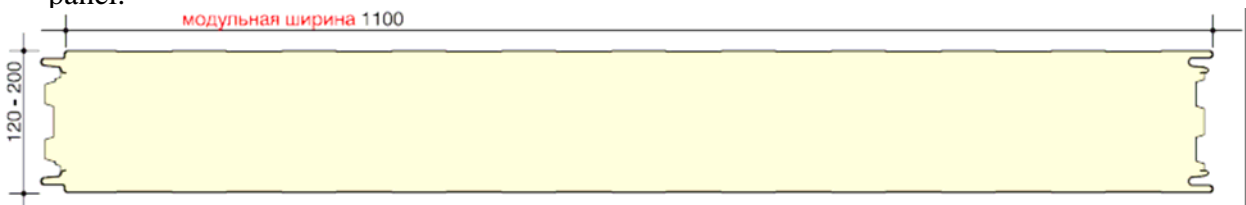
2. Wall panel: 墙面板



Note: The thickness of the sandwich panel is 40mm-100mm. But in this product line, the seller only supply the side nylon seal block to make the 40mm thickness sandwich panel.



Note: The thickness of the sandwich panel is 60mm-100mm. But in this product line, the seller only supply the side nylon seal block to make the 60mm thickness sandwich panel.



Note: The thickness of the sandwich panel is 120mm-200mm. But in this product line, the seller only supply the side nylon seal block to make the 120mm thickness sandwich panel.

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4. Primary technology parameters of YMPU-PRL-1 sandwich panel product line:

YMPU-PRL-1 型聚氨酯夹芯板连续生产线技术参数:

- ◇ Speed of product line: maximal speed: 8.6m/min(frequency conversion to adjust speed)
- ◇ 生产线传输速度: 最大速度 8.6 米/分钟 (变频调速)
- ◇ The dimension the product line: about 120 m*18m*3.5m
- ◇ 生产线尺寸: 约 120 米*18 米*3.5 米
- ◇ Total power of the product line: about 350 KW
- ◇ 生产线总装机容量: 约 350 KW

The photo of the product line laying out:生产线排布照片:



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5. Main machines and technical data:

主要设备组成及技术参数

- **Two sets of uncoiler:** It is Automatic and hydraulic, can be used to uncoil steel coil which is maximal 1300mm's wide, no more than 7 ton's weighty and steel coiler's inner diameter is about 500mm.

二套自动开卷机:自动上卷,液压涨紧,能满足宽度 1300mm、重量不大于 7 吨、卷芯直径约 500mm 的钢卷使用



Two sets of steel sheet transverse cutting machine: it is hydraulic, could cut steel sheet according to certain length and move by the sheet running.两套钢板横切断装置, 在开卷装置后面, 采用液压驱动切断钢板的方式, 可实现计长和定长切断,可随钢板同步运动:

- **Two sets of PVC film covering device:** could cover the PVC film on the steel sheet. 二套钢板 PVC 膜覆膜装置:



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- Four sets of roll forming machine, one is on the up platform and three are on the down platform. They make one kind of roof panel and three kind of wall panel.

4 台压型机,一台在上平台,三台在下平台,可压制一种屋面板和三种墙板:



- Two sets of conveyer rack: up conveyer is about 25m, down conveyer is about 15m. They lead the steel sheet from the roll forming machine to preheating room. 二套输送架:上输送架约 25 米,下输送架 15 米.用于引导成型钢板进入预热房.

- One preheating room: It is built by heat-insulation material, and it could heat up the steel sheet to 25-38°C by heater.

预热房:采用保温材料建造,其中用红外加热管加热,使通过的钢板表面温度达到 25-38°C.

- One set of PU two component Liquid mixing and injecting section for foaming : it adopt GERMANIC high pressure pump. It have the temperature control system and material-level monitoring system. The tank of the material is about 500L. Two tanks. This section is showed in the photo:

一套聚氨酯二组分混合浇注装置:该装置采用德国高压计量泵,采用温度控制系统和原料自动补料系统.原料罐有 2 组 500 升的罐.二组分原料混合后,通过混合头往复运动,浇淋在钢板上.

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High pressure P.U. foam dispensing machine complete with: VOLTAGE: THREE PHASE , 380V, 50HZ

高压 PU 发泡设备组成如下:电压:380V,3 相,50HZ

- **2 set of GERMANY REXROTH HYDROMATIK A2VK pumps mounted with separate motors**
- **2 套采用分离马达的德国力士乐公司出产的 A2VK 泵**
- **1 set of Touch Screen Operator Panel with synoptic graphics and alarm messages and 1 set of Mitsubishi PLC**
- **一套用于显示图表和报警信息的触摸屏和三菱公司的 PLC.**
- **2 set of flow transducers**
- **2 套流量传感器**
- **2 set of 500 liter pressurized carbon steel Jacketed tank for ISO & Polyol**
- **2 只 500 升的带有套层的压力储罐,用于储存 ISO 和 POLYOL**
- **1 set of Electric POLYOL stirrer**
- **一套用于搅拌 POLYOL 的电动搅拌器**
- **1 set of Electric ISO stirrer**
- **一套用于搅拌 ISO 的电动搅拌器**
- **1 set of Temperature control system for each tank**
- **用于控制储罐中温度的温度控制系统.**
- **1 set of 2 component Mixing head**
- **2 组分混合头**

- **Foaming and the maturing double belt machine include Hydraulic pressure control system and 4 sets side nylon seal blocks to make three kind of wall panel and one kind of roof panel.**

双履带机包括液压装置,侧面尼龙挡块 4 套-可用于制造 1 种屋面板,3 种墙面板

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- The length of the DOUBLE BELT machine is about 24m, which consists of upper frame and lower frame, each frame has three sections.
- 双履带设备长约 24 米,由上下机架组成,每个机架分为 3 段
- The width is about 1.6m,the height of the down belt is about 1.2m.
- 机架宽度 1.6 米,下机架链板面高度 1.2 米
- The width of pedrail board is 1320mm, the range of adjusting distance between upper and lower frame pedrail board: min 30mm, max 200mm.
- 链板宽度为 1320mm,上下履带调节距离为 30mm-200mm
- Horizontal distance between the two sides nylon seal blocks can be adjusted so can meet requirements of different width's sandwich panel. the width is from 600mm to 1300mm.
- 两侧挡块之间的水平距离可以调整,以适应不同板宽的夹芯板生产,它们由减速电机驱动可分别向机架中心方向移动 350mm;这样除尼龙挡块宽度外,最宽 1300mm,最窄 600mm。不同厚度不同板型其所配的尼龙挡块都不一样
- Four sets of nylon seal blocks for making the different thickness sandwich panel- one kind of roof panel and three kind of wall panel.
- 尼龙挡块配置: 4 套, 其中满足制作特定板厚的墙板 3 套, 特定板厚的屋面板 1 套。



- One set of heating and heat insulation system: the DOUBLE BELT machine is closed by heat insulation material. The heating system heat and fan hot air to keep the temperature 25-35°C in the DOUBLE BELT machine. The temperature could adjust according to the production process.

为配合保证聚氨酯发泡所需的固化温度,向上下机架内通暖风.聚氨酯发泡所需

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的固化温度受固化时间（生产线传输速度）、固化压力、发泡厚度等方面因素的影响，一般预热温度 25-35℃，需要预热的温度范围最后由湿部确定.整个上下机架都拟采用保温材料封闭，保温材料为块状，表面喷聚氨酯自干漆；

- **Panel automatically cutting system:**

成品板材自动切割部分

- **Cutting machine can move 2500mm longitudinally along product line;**
- 切割机沿生产线方向纵向行程约 2500mm
- **Band saw of the cutting machine can move transversely 1900mm, Cutting machine moves longitudinally and transversely along the slide way.**
- 切割机上带锯条横向行程约 1900mm，切割机在直线导轨上沿纵向和横向方向移动
- **Cutting machine adopts one-side blade band saw manner, cutting and revolving after cutting. The cutting saw can revolve, so cutting in two directions is realizable.**
- 切割机采用单面刃带锯，旋转切割，需要有带锯涨紧装置，因双向切割，刀头能旋转
- **There is panel tight-pressing system (pneumatic) in the cutting machine;**
- 切割机设置板材压紧装置（气动）
- **There is location limiter to limit longitudinal and transverse motion of cutting machine.**
- 切割机纵向、横向移动装有限位装置



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- **Conveyer and automatic stack machine: The length of this section is about 20m, automatic stack machine is droved by pneumatic driving.**
- **自动输送和堆码装置:这部分长约 20 米,自动堆码机由气动驱动.**

- **Electric control system:电气控制系统:**
- **The control system adopt the touch screen , PLC , module control and transducer. The control system adopt MITSUBISHI(JAPAN) product.**
- **控制系统采用触摸屏,PLC,模块,传感器等组成控制网络,控制系统采用日本三菱公司的产品.**
- **There are three control platforms and five electric trunk by which operating and controlling the electric motors and all motions (including hydraulic and pneumatic) in the product line.**
- **整个生产线采用 3 个控制台,5 个电控箱来操纵和控制本生产线所配电机的运转及各动作 (包括液压和气动) 的实现;**
- **Intercalated appropriate amount of portable switch on the product line, so manual operation get convenient.**
- **整个生产线适当设置手提开关插座, 以便于手动操作**
- **Alarm and emergency stop system should be installed in the product line in case accident happens.**
- **整个生产线应设置连锁机构, 报警及急停装置, 以保证生产线安全运行**
- **There is one industrial touch screen computer which link the 4 monitors to monitor the production process.**
- **生产线中配置一台工业级计算机及 4 台监控摄像机,可以监控整个生产过程.**

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6. The price of YMPU-PRL is USD 1,250,000 (FOB SHANGHAI PORT)

The transport

The product line need about 15 40' container to transport.

7.0 Installing, adjusting and training:

7.1 The seller would advise to install and debug the sandwich Panel Product Line. During the course of installing and debugging, the Buyer should supply the crane and arrange the craneman, welding-workers and other workers to cooperate. The seller would appoint 3 engineers to guide to install and debug. The buyer supply interpreter.

7.2 The buyer supply the material for debugging

8.0 Payment terms:

8.1 40% for the earnest

60% the retentive payment shall be payoff before handing over of the goods

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8.2 The seller will finish manufacturing the Sandwich Panel Product Line within 180-240 days after receiving the earnest.

Warranty: 12 months limited warranty

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Linkman



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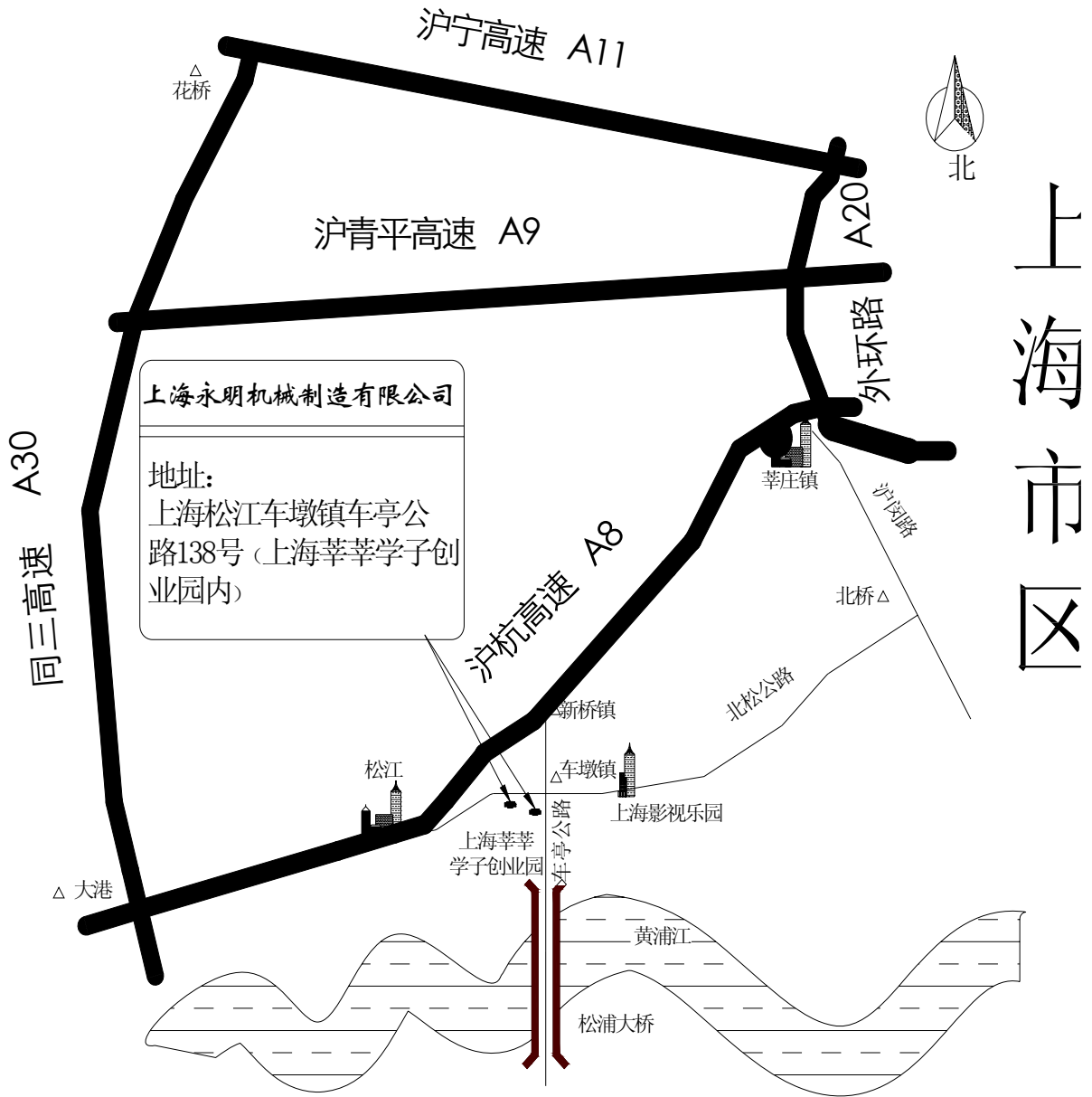
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