

Extrusion line type RKN 90L

Technical specification

Single screw extruder

Screw diameter	90 mm
Screw L/D	16/1
Screw speed, max.	60 rpm
Screw & barrell hardness	65-68 HRC
Head pressure, max.	350 bar
Extrusion height	1100 mm
Motor power	55 kW
TCU power, each	3 kW

Shock oven

Heating power	36 kW
Working temperature	300 °C
Heater temperature, max.	350 °C
Air fan motor power	120 W
Heating time, approx.	25 min 300 °C
Tunnel entrance dimension	210 x 130 mm
Tunnel size	180 x 80 mm
Conveying speed	0,5 – 28 m/min
Conveyor motor power	1,5 kW

Microwave oven

Microwave heating power	12 kW (8 x 1,5 kW)
Magnetron type	Witol 2M463K
Frequency oscillation	2450±15 MHz
Peak anode voltage max.	4,65 kV
Average output power	150 - 1500 W
Heating power, max.	36 kW
Working temperature	350 °C
Heater temperature, max.	450 °C
Heat distribution	max. 10 °C difference between any two parts of the oven ±2 °C in the same part of the oven
Fan motor power	2,2 kW
Fan capacity	21 m ³ /min
Cooling water consumption	3 l/min
Tunnel size	250 x 90 mm
Product height, max.	75 mm
Conveyor belt width	170 mm
Conveying speed	0,5 – 28 m/min
Conveyor motor power	1,5 kW

Hot air curing oven

Heating power	36 kW
Working temperature	250 °C
Heat distribution	max. 10 °C difference between any two parts of the oven ±2 °C in the same part of the oven
Heating time	30 min
Fan motor power	1,1 kW
Fan capacity	21 m ³ /min
Tunnel size	220 x 130 mm
Product height, max.	70 mm
Conveyor belt width	170 mm
Conveying speed	0,5 – 28 m/min
Conveyor motor power	1,5 kW

Cooling tank

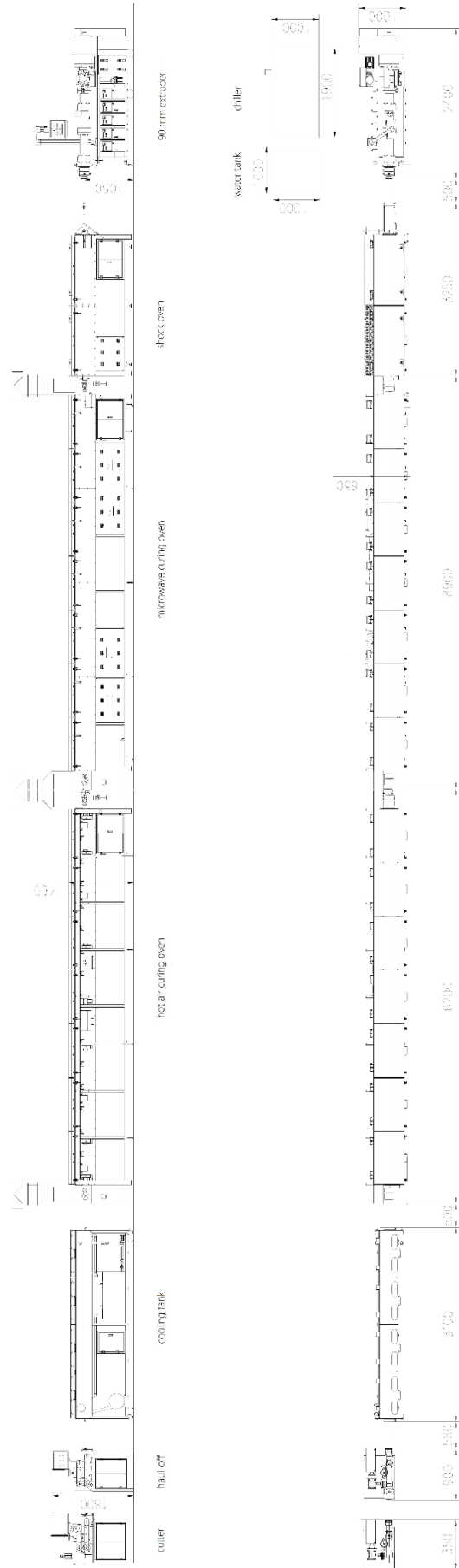
Pump motor power	0,4 kW
Pump volume	40 l/min
Nozzle diameter	80 mm
Air turbine capacity	2,5 m ³ /min
Useful length	3 m
Chiller motor power	6,5 kW

Haul-off

Belt length	600 mm
Belt width	150 mm
Belt opening, max.	80 mm
Motor power	1,5 kW
Haul-off speed	2 – 30 m/min
Hauling force	2000 N

Universal cutter

Cutting width	150 mm
Cutting height	30 mm
Cutting capacity, max.	230 cut/min
Cutting force	2200 N
Cutting length adjustment	0,1 mm - 99999,9 mm
Cutting precision	0,1 mm
Forwarding speed	2,1-60 m/min
Compressed air supply	4 – 6 bar
Compressed air consumption	approx. 2 l/cut



Project Name	
Project No.	
Date	12.08.2010
Scale	
Sheet No.	
Sheet Total	
RKN	

RKNS00 extrusion line layout