



Double-wire and Double Dryer and Double Felt A4 Printing Paper Making Production Line

□.Brief introduction:

1.this is a complete production line,include pulp making machine, paper making machine, paper processing machine. capacity is1 ton per day, it can make printing paper, writing paper,;

2.The printing paper making production line process:


Raw material → Pulp making line → Paper making line → /Boiler section jumbo roll paper → printing paper converting machine → product (A4 printing paper)

□.Technical parameters:

1. Raw material: recycled book paper and writing paper;
2. Output paper: printing paper;
3. Capacity : 1 ton per day;
4. Trim paper width: 1092mm (max width can be 1150mm) ;
5. Output paper weight:70-80g/m² ;
6. Design speed: 80-90m/min ;
7. Width of wire :1450mm ;
8. Bearing center-center:1800mm ;
9. Drive way: Alternating current ,frequency conversion, speed control, section drive;

Item	Name	Qty (set)
1	1.5m ³ hydrapulper	1
2	High frequency vibration screen	1
3	Φ250mm single disc refiner	1
4	Centrifugal screen	1
5	Potcher (bleacher)	2
6	Propeller (pulp mixer)	3
7	Pulp pump (4 inch)	3
8	Sand cleaner system	1 set (6pcs)
9	Inclined screen (thickener)	2
10	High pulp (level) tank	1
11	4inch used water pump	
12	4inch fresh water pump	
13	Muti- level water pump	
14	1092mm cylinder mould making machine	
15	A4 paper cutting machine	
16	A4 paper packing machine	
17	Boiler section	



No	Item	Picture
1	1.5m ³ consistency hydrapulper	
Technical specification	Qty	1 set;
	Function	this machine is used to crush pulp board, various recycled paper.
	Power	11kw
	Material of tank:	stainless steel, thickness is 6mm;
	pulp consistency:	5%-8%
	capacity:	5 t/d
	Diameter of exit:	Φ159mm
	dimensions of main body	Φ1.1m×1.2m
	total weight	1T
	Diameter of sieve plate	Φ1000mm
	Thickness of sieve plate	8-10mm
	Material of mesh	stainless steel
	diameter of sieve pore	Φ6mm
	diameter of rotor	Φ800-850mm
	Material	cast steel
Working speed	300r/min	

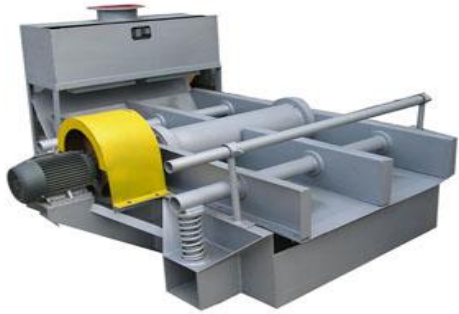
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2	High frequency vibration screen		
	Technical specification	Qty	1set
		Power	2.2kw
		Function	used to screen out all the inclusions in the pulp.
		Size (L*W*H)	2.2 *1.5 *1m
		Material of main body	Steel
		Size of sieve plate	2000 *1000mm
		Thickness of sieve	3mm
		Material of mesh	stainless steel;
		size of taper hole:	upper is 3mm, bottom is 4mm
3	Φ250mm single disc refiner		
	Technical specification	Qty	2set
		Power	11kw
		Function	it used to grind the coarse pulp to good pulp for paper making.
		inlet consistency	3%-5%
		Capacity	3-5t/d
		dimensions	1.2×0.5×0.5m

		diameter of refiner disc	Φ250mm
		Weight	300kg
4	Centrifugal screen		
Technical specification	Qty	1set	
	Power	7.5kw	
	Function	this machine is profession equipment for remove the light impurity in pulp.	
	Inlet consistency	0.8%~3.0%	
	Capacity	10-15t/d	
	Dimension (L*W*H)	1.5 *0.6 *0.8m	
	Weight	200kg	
	Material of sieve plate	stainless steel	
	Thickness of sieve plate	1mm	
	Diameter of screen hole	φ2.6mm	
	Material of rotor	carbon steel	
	Working speed of rotor	600r/min	
5- potcher (Bleacher)			
Technical specification	Qty	2sets;	
	Power	3kw including electric motor	
	Function	this equipment used to bleach the pulp and make it reach the whiteness of the paper should be.	



	Material	glass fiber reinforced plastics
	Size	Φ 1.5* 1.8

6	pulp mixer (Propeller)		
	Technical specification	Qty	3sets
		Power	5.5 kw, Include electric motor;
		Function	it used to recycle and mix pulp in the pulp chest. Which can make the fiber in suspended status, ensure element of pulp equally distribute in pulp.
		Size	Dia 650mm *1000mm
		Material Totor	nodular cast iron
		Speed of rotor	420m/min

7	pulp pump (4 inch)			
		Technical specification	Qty	5sets
			Power	3kw× 2sets ,5.5kw×2 sets ,11kw×1 set, Include electric motor;
			Function	it is used to transmit pulp with consistency below 6% and recycle, transport, hoist, press medium during recycle soda.
			Size	1.2* 400*500mm
			Material of main body	Cast iron
			Diameter of impeller	200--250mm
			Material of impeller	nodular cast iron
8	Sand cleaner system			
		Technical specification	qty	4 pcs
			Function	it used to removed heavy impurity and part of light impurity in the pulp.
			Material of main body:	cast iron
			Material of exit	Ceramics
			Diameter of impurity exit	8--12mm

9	Inclined screen (thickener)			
		Technical specification	Function	it used to filter out part of water and all big size impurity in pulp so that to increase the consistency of pulp.
			Size	Based on the actual size made at factory
			material	Wood, cement, steel etc.
10	High pulp tank (level)			
		Technical specification	Qty	1set
			Function	it is used to increase the pressure of pulp and water, so that it can save the pump power
			Material	Stainless steel, wood or cement etc
		Size	Baed on the actual size at factory	
11	4 inch used water pump			
		Technical specification	Qty	1sets
			Power	5.5kw including electric motor



12	4 inch fresh water pump		
	Technical specification	Qty	1sets
		Power	5.5kw including electric motor
13	Muti-level water pump		
	Technical specification	Qty	1sets
		Power	5.5kw including electric motor

IV. Main structure and characteristic of paper making machine:

1. Cylinder part:

Φ1250mm×1350mm×1800mm cylinder mould 2sets; Φ350mm×1350mm×1800mm couch roll 1set, coated 20mm rubber Share hardness is 92°C±2; ; Φ350mm×1350mm×1800mm couch roll 2 set Share hardness is 38°C±2 pneumatic loading device

2. press part: ;

Φ350mm×1350mm×1800mm squeeze roll 2sets; Φ350mm×1350mm×1800mm stone roll 1 set ; Φ350mm×1350mm×1800mm rubber press roll 1 set;

3. Dryer part:

Φ1500mm×1350mm×1800mm cast iron dryer cylinder 2 sets; Φ400mm×1350mm×1800mm cast iron touch roll 1 set; pneumatic pressure device, rubber hardness HSD 93°C± 2. Equipped

with double layer of exhaust hood.

4. Paper processing part:

Φ600mm×1350mm×1800mm winding machine 1 set; single knife paper sheet cutting machine, A4 paper cutting machine.

5. Calender:


Two-roll calender: Diameter of upper roll is 300mm , diameter of bottom roll is 350mm ;


6. Driving & control part:

AC frequency conversion speed, section drive.

Item	Name	Power	Qty
1	Press section	11kw	1
2	1 ist dryer section	5.5kw	1
3	2 nd dryer section	7.5kw	1
4	1092mm calendar	5.5kw	1
5	1092mm winding machine	3kw	1
6	33-vacuum pump	7.5kw	1
7	Axial –flow ventilation	1.5kw	1
8	Air compressor	2.2kw	1
	Total	43.7kw	8



7. Electric motor and picture of main part :

No		Picture								
14	cylinder making									
	Technical specification	<table border="1"> <tr> <td>qty</td> <td>1 set</td> </tr> <tr> <td>Power</td> <td>11kw</td> </tr> <tr> <td>function</td> <td>it used to making paper.</td> </tr> <tr> <td>Structure</td> <td>Compact structure, it composed by cylinder mould part, press part, dryer cylinder part etc.</td> </tr> </table>	qty	1 set	Power	11kw	function	it used to making paper.	Structure	Compact structure, it composed by cylinder mould part, press part, dryer cylinder part etc.
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1	Cylinder mould			
		Technical specification	qty	2sets
			function	mainly used for paper pulp dewatering.
			Material of mesh	stainless steel
			Dimension	Φ1250×1350×1800mm
			Material of tyre	cast iron
			Material of shaft	45# steel
2	Dryer cylinder			
		Technical specification	Qty	2sets
			Function	it is used to dry the wet paper by vapor (heating medium).
			Diameter of dryer cylinder	Φ1500mm
			Material	cast steel
			Dimension	Φ1500mm×1350mm×1800mm
			Material of bearing pedestal	cast iron
3	Rubber roll			
		Technical specification	qty	5pcs, include reverse roll 1 set; couch roll 2



			sets; squeeze roll 2 sets.
		function	it is used to press out the water in the paper pulp before dryer
		size	Φ400×1350×1800mm
		Material of shaft	45# steel
		Material of body	Steel pipe
		size	Φ400×1350×1800mm
		Surface material of reverse roll	coated 20mm rubber and shore hardness 92°C±2
		Surface material of couch roll	Coated rubber and shore hardness 38°C±2
		Surface material of squeeze roll	coated rubber and shore hardness 92°C±2
4	press roll		
	Technical specification	qty	2pcs, include touch roll 1 set, stone roll one set
		Function	it is used to press out the water in the paper pulp before dryer and it puts under the rubber roll
		Material of body	Steel
		size	Φ350×1350×1800mm
		Material of shaft	45# steel
		Surface material	coated shore hardness 94°C±2 rubber
5	axial-flow ventilation		
	Technical specification	qty	1set

		power	1.5kw, include electric motor
		function	it used to dissipating heat that suck by vacuum pump in the dryer can section like a fan
		material	Iron
		Diameter of fan blade	Φ380mm
6	vacuum pump		
	Technical specification	Qty	1set
		Power	7.5kw
		Function	it sucks the excess of vapor by vacuum suction to dissipation heat in the dryer can section
		Max speed (m3/min)	6
		Rated speed(m3/min)	4.2
		Rated vacuum degree	33.3Kpa
		Rated revolution speed	400r/min
		Diameter of opening	125mm
		Weight	440kg
		Accessory triangular belt	B-type 2800

7	Electricity control cabinet			
	Technical specification	qty	1 set	
		Function	this system is composed of given speed microcomputer and the digital electromagnetic variable speed motor, which has epochal differences with the old models. It has features as follows: advanced technology, simple structure, easy operation, sync and accuracy. High resolution makes the motor's exact contact easily.	
8	Vacuum suction box			
		Technical specification	qty	2sets
			Function	it used to suck part of water in the pulp in the cylinder mould section
			Size (l*w)	1800*300mm
			Material of body	Stainless steel
			Surface of plate	Caramics

V.Paper processing section:

No	Item	Detail description	Picture
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1	Two-roll calender		
	Technical specification	qty	1 set
		Power	5.5kw
		Function	this machine plays a key role in enhancing the smooth, glossiness and compactness of paper which in order to make the paper thickness uniform, and to improve the paper outline quality by follow-up calendering and finishing the paper.
		Diameter of roll	Upper roll is $\Phi 300\text{mm}$, bottom roll is $\Phi 350\text{mm}$
		Material of roll	Cast steel
		Max rotate speed	200m/min
2	winding machine		
	Technical specification	qty	1 set
		Power	3 kw
		Function	this machine is the first range after paper making machine, the scroll is moved by the weight of itself and the friction of sweat cylinder, so the paper from the machine can spool uniform




		Dimension of sweat cylinder	Φ400×1350×1800mm
		material	Steel plate
		Working speed	Adjustable (synchronize with speed of paper making machine)
3	Final jumbo roll of printing paper		
4	Single-knife cutter (paper sheet cutter)		
	Technical specification	Qty	1 set
		Power	3kw
		Function	it can cut the roll paper into sheet paper or paperboard.
		Working speed	Adjustable (synchronize with speed of paper making machine)

15	A4 paper cutting machine		
	Technical specification	Qty	1set
		Power	2.2kw
		Function	it used to cut the sheet paper into A4 size.
		Working length	1300mm
		Working width	1300mm
		Working height	700mm
		Height of operation flat	930mm
		Working speed	42m/min
		dimension	2700*2900*1600mm
1	Working flow chart		

16	A4 paper packaging machine		
Technical specification		qty	1 set
	Function		This machine can pack China A4 copy sheets (210x297mm), America A4 printing paper(216x280mm)、(216x330mm).
	Productive capacity		10-15(Pcs/min)
	Functions whereby roll overwrap paper can be automatically cross cut and fed		10-15(Sheets/min)
	Specification of packed object(based on 500 pieces)		210x297x50mm
	Power supply		380V Three-phase four-wire
	Motor power		1.5kw
	Gluing power		.17 kw
	Compressed air		0.6mpa

	Paper size(Lenght×Width)	550-560mm×386mm
	Overall dimension	4600×2550×1400mm
	Weight	1350Kg
	Suitable range	Package material for gluing paper of color printing or hexahedral wrapping

17.Boiler section :

Name	0.5 ton boiler	
Main technical parameter	fuel	Electricity
	Rated evaporation	0.5t/h
	Rated temperature of steam	171°C
	thermal efficiency	98%
	Rated pressure of vapor	0.7Mpa
	Input power	360kw
	Temperature of feeding water	20
	weight	2300kg
	dimension	2636×1400×1806mm