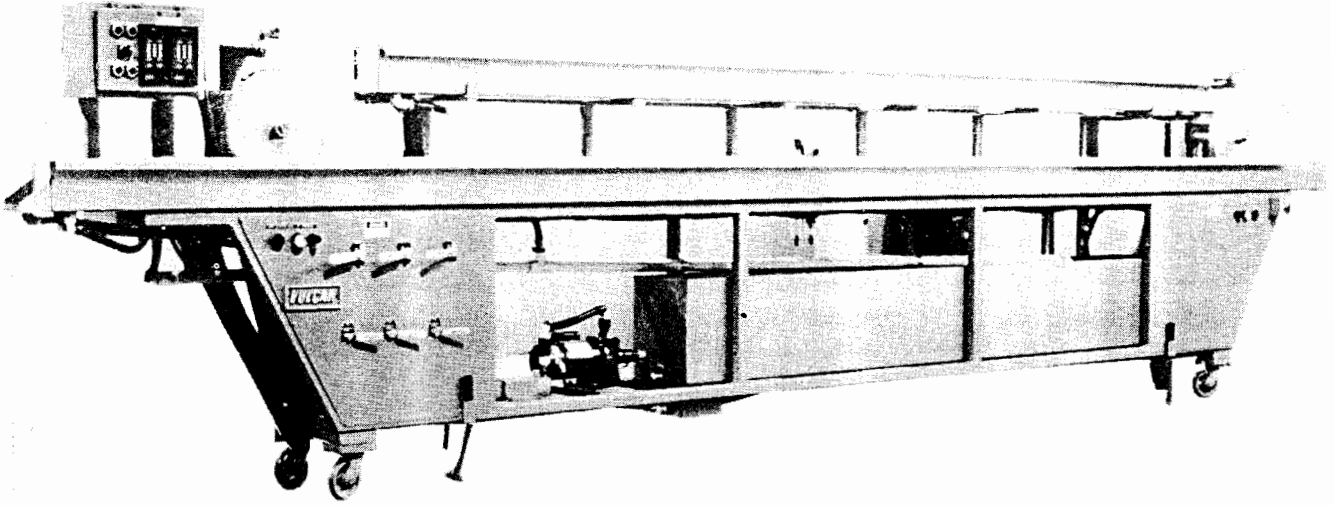


TRIPLE PASS SIZING/COOLING SYSTEM



APPLICATIONS:

The Triple Pass Sizing/Cooling System is designed with the sizing unit (puller) inserted upstream from its normal position in the extrusion line such that sufficient elastic recovery time is available after the pulling operation to prevent collapsing or damaging to the extrudate cross-section during subsequent coiling operations. Increasing the elastic recovery time after sizing, and before cutting is also important in most cut-to-length operations.

EQUIPMENT DESCRIPTION:

The Triple Pass Unit has a digitally controlled DC-SCR driven, low durometer, rubber covered pulley located at the end of the first pass that sizes the material out of the die. Another identical pulley is located at the end of the second pass which can be furnished with or without a DC-SCR drive. The triple pass unit is also offered with or without a take-off unit mounted at the end of the third tank to control the take-off speed of whatever unit that is used. The controls on the last two drives are designed to reduce tension in the product and allow for dimensional recovery from the strains produced in drawing the product out of the die and through the line.

MODELS AVAILABLE:

Model CS60S – Triple Pass Tank with Sizing Pulley

Model CS60SI – Triple Pass Tank with Sizing Pulley and Powered Intermediate Pulley

Model CS60ST – Triple Pass Tank with Sizing Pulley and Powered Take-off Unit

Model CS60STI – Triple Pass Tank with Sizing Pulley, Powered Intermediate Pulley and Take-off Unit.

TANK AND FRAME CONSTRUCTION:

- Tank Lengths – First Pass 21 ft., Second Pass 15 ft., Third Pass 21 ft. (Includes 2 ft. Air Wipe Section)
- Tank Cross Sectional Dimensions – 6 inches x 6 inches
- Tank Material – 12 Gauge 304 Stainless Steel
- Center Line Height Adjustment – 40 to 44 Inches
- Four UHMW Hold Down Rollers Provided for Each Tank Section
- Frame – Tubing, Plate, and Structural Sections with Four Grooved Rigid Casters & Floor Locks
- Water Height Control – Separate Adjustable Overflows in Each Tank Piped to Drain Manifold
- Drip Trays Located at Each End of Tanks; Air Wipe Compartment Drain, and Tank Drains are all Piped to Common Drain Manifold
- Supply Water Manifold with Valved Lines to Each Tank

DRIVE TRAIN:

- Sizing Puller Drive is 1 HP Digitally Controlled DC-SCR Drive with 15 Inch Diameter Natural Rubber Pull Roll Contoured to Customer's Requirements
- On CS60SI and CS60STI Models, Intermediate Drive is 1 HP Digitally Controlled DC-SCR Drive with 15 Inch Diameter Natural Rubber
- On CS60ST and CS60STI Models, the Take-off Unit is 1 HP DC-SCR Drive with a Natural Rubber 60 Duro., Shore A Nip
- Wet Dancer is Located in Third Pass Tank and Controls the Speed of the Take-off Unit

CONTROLS AND ELECTRICAL:

- Sizing Puller – Start, Stop, and E-Stop
- Driven Intermediate Puller – Start, Stop, and E-Stop
- Take-off Puller – Start, Stop, E-Stop, Nip Open, Nip Closed
- All Drives Controlled by Digital Front End with Set Point and Actual Line Speed Displays. Speed Regulation $\pm .05\%$
- Electrical Service Required – 230 Volt, 1 Phase, 60 Hertz

OPTIONS:

- Closed Loop Recirculation System – Complete with 30 GPM Pump, Plate Type Heat Exchanger for 30,000 BTU/Hr. Heat Removal Capacity. Unit Completely Plumbed Requiring Only Customer Connection of Chilled Water Source to Inlet & Exit of Heat Exchanger.
- Electrical Service Other Than 230/1/60

Note: This specification represents the design parameters of a typical Vulcan Triple Pass Sizing/Cooling System. Customer required deviations to these specifications are available upon request.



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