



Office: 207 Shrinidhi Complex, Nicol Haridarshan Road, New Naroda, Ahmedabad-382330

Temporary Project Invoice for
PP NONWOVEN FABRIC EXTRUSION LINE 3.2

&

Other supported manufacturing machinery

INSTRUCTION SPECIFICATIONS Terms & conditions

www.globalventure.hpage.com

fabric@googlevibgyor.com

9033817316 (IND)

---Global Venture Impex---

List of Machinery and Inspected Costing cum important note

All Machinery with FOB Prices (Calculation with 52 Rs / 1\$ USD)

| | |
|---|--------------------|
| 01. PP Non Woven Fabric Extrusion Line 3.2 | 4,40,000 \$ |
| 02. Non Woven Fabric Bag Making Machine | 25,000 \$ |
| 03. Non Woven Fabric Roll Printing Machine | 33,000 \$ |
| 04. Non Woven Fabric Bag Printing Machine | 15,000 \$ |
| 05. Non Woven Fabric Roll Laminating Machine | 37,000 \$ |
| 06. Non Woven Fabric Roll Slitting Machine | 10,000 \$ |
| 07. Non Woven Manual Ultrasonic Sealing Machine | 2,059 \$ |
| 08. Automatic Loop Handler Machine | 3,285 \$ |
| 09. Manual Di-Cut Machine | <u>1,806 \$</u> |
| Total FOB | 5,67,150 \$ |

Our Two Combine Manufacturer Company

- 01. Wenzhou Guanda Xin Chemical Fibre Machinery Factory
- 02. Yanfeng Group Co, Ltd.

| | |
|---|---------------------------|
| Total Cost of this Project expected With all other services and facility | <u>8,73,411 \$</u> |
| Bay Back Deduction 10% of plant cost (Will Back in 6 Month to 1 Year) | 56,715 \$ |

Total Net 8,16,696 \$ in 4,24,68,192 INR

Important Note: Cost expected and included with

- FOB
- Import Duty.
- Transportation.
- Installation.
- No any engineers Extra charges.
- 15 to 45 Days Training.
- 1 Year Guaranty on all machinery.
- 5 Years Warranty on all Machinery.
- Allowed Reverse Penalty System (If Plant Closed more than 3 hour and Cause is our services you will paid up hourly 1000 INR If we can't reach you)

- Heavy Duty Sensor and Controller Mad bay reputed Country mad company like Japan, USA, Korea, Taiwan.
- Payment will be 10% as Down Payment and 85% paid up before Shipment from China, 5% after installation. (This will act by Global Venture to manufacture Unit in Foreign)

Facility Generation

- Project Counseling From Be YOGA ORGANIZATION for GLOBAL ACHIEVEMENT LLC (USA)
- Facility of Project approval
- Facility of 100 % Finance.

- Facility of achieving 24% Subsidy
- Facility Project BUILDINT AND construction Interior administration Build up by Snkrve Arch Pvt. Ltd.

Machining Ultimatum

Machine capacity : 10 to 11 ton / Day
 Start Plant : 560 KW
 Running power: 380KW One ton fabric need 700kw approximate
(415V 3PHASE 50HZ 220V 1PHASE 50HZ FOR INDIA)
 Working labor : 5-6 persons

I. GENERAL INTRODUCTION

The first PP spun bonded non woven fabric extrusion line had been manufactured for years and the technology has been improving rapidly. The demand of the use of this line is huge, because of its unique function and lower price.

II. FLOW CHART OF PRODUCTION LINE

PP chips-----feeding & mixing-----melting & extruding-----pre-filtering-----spinning-----air cooling-----airflow stretching-----net forming-----hot rolling into fabric-----winding-----slitting----- final product.

This line consists of feeding mixer, extruder, filter, spinning body, spinning measure pump, cooling system, air flow stretching system, net forming system, suction system, auxiliary conveyor belt, hot rolling mill, winder and slitter etc.

The main raw material for spun bonded non woven fabric line is Polypropylene chips. Please check the technical parameters below:

MFR: 20-40g/10min

Melting point: 165°C

Ash PPM: <220

Consumption: 0.01

Tensile strength: vertical, 16gm 1.0; 40gm, 27.0

Horizontal, 16gm 14.0; 40gm 37.0

Elongation: 30-70

Tearing strength: vertical, 16gm 5.0; 40gm 20.0

Horizontal, 16gm 7.0; 40gm 24.0

III. EXTRUSION CAPACITY

Say, the weight per s.q.m of fabric is 40g; the extrusion output can reach 2800T per year.

Take the 1600mm wide fabric for example; the weight ranges from 10g/s.q.m to 250g/s.q.m.

Setting of temperature of screw:

Zone I: 190-210°C

Zone II: 220-230°C

Zone III: 220-230°C

Zone IV: 220-240°C

Zone V: 220-240°C

Zone VI: 220-240°C

Rotational speed of screw: 10-75r.p.m

Dia. Of screw: Φ135

L/D ratio: 1:30

Temp. of spinning body: 220-250°C

Melting temp.: 220-230°C

Measure pump: 250cc/r, one set
Rotational speed of measure pump: 10-40r.p.m

Wind velocity of net suction: 15m/s

Gross wind: 1800m³/hr

Air flow distribution: even horizontal distribution;

Gradually decrease from the nozzle outlet to the exit of net forming unit

IV. MAIN TECHNICAL SPECIFICATIONS

1) Hot milling unit:

Effective width of hot rolling: 1600mm

Max. mechanical speed: 150m/min

2) Roller:

Upper roller: embossing roller

Lower roller: flat roller

Dia. Of roller: 450mm

Temp.: 170°C

Spun bonded area: 19%

Pressure of roller: 50-100Yanfengin

3) Winding unit:

Max. winding dia.: 1200mm

Max. mechanical speed: 150m/min

Max. fabric width: 1600mm

Max. slitting speed: 200m/min

Effective width: 1600mm

Max. rewinding width: 800mm

4) Calciner:

Max. temp.: 500°C

Process temp.: 450°C

Calcinations time: 6 hours

V. MAIN EQUIPMENT

1) Feeding system

It feeds with negative pressure and adopts the kinetic energy of air pump. The level of storage bin can control automatically.

2) Extruder

It is driven by DC motor with automatic temperature and pressure control.

3) Mixing of color master batch

The precise and even measure ensures the stable color of final product.

4) Melt filter

The filter with 3.5m² and 80u precision is adopted so as to reduce the stopping time and ensure the quality of product.

5) Spinning body

Singe die is used for spinning section.

6) Heating system

The screw is heated by power, while the circulation heating of heat conduction oil is adopted for

the filter and spinning body.

7) Spinning cooling system

When the PP fiber is formed, double-surface air cooling is adopted so that rapid cooling can be achieved, which ensures proper strength and better quality.

8) Stretching device

It is mainly to be used to get the fiber stretched and refined under the rapid air flow.

9) Net forming device

it uses negative pressure to collect the fiber and feeds forward gradually. In this way, the net curtain can be got. It is composed of DC variable speed device, rack, transmission curtain and assorted air suction device.

10) Curtain conveying

It conveys the fiber curtain into hot rolling mill.

11) Hot rolling mill

It is used to reinforce the fiber curtain. The deformation and partial melting will happen through high pressure and heating. Some assemblages will change into bonding points, which gets the fiber curtain into non woven fabric with certain physical properties and appearance.

The effective width of hot rolling can reach 1600mm and the max. linear speed can reach 150m/min.

The upper roller adopts laser embossing roller and the lower one is plain roller.

42CrMo is used as the raw material.

The surrounding drilling way is used for the overall forging.

Dia. Of hole is $\Phi 35\text{mm}$.

There're 15 holes around.

Drilling straightness: $\leq 0.5\text{mm}$

(including docking tolerance)

Hardness of plain roller: HRC60

Hardness of embossing roller: HRC58

Heat treatment: normalization for forging, quenching after lathing, intermediate quenching, tempering to required hardness.

Roller pattern: can be designed as required.

Speed accuracy of mill: $\leq 0.10\text{m/min}$ when it exceeds 20m/min ;

$\leq 0.15\text{m/min}$ when it

is less than 20m/min ;

Spun bonded area: 19.01%

Final product: $\pm 1^\circ\text{C}$

12) Winder

It is used to rewind the non woven fabric into rolls. It consists of rack, frictional roller, automatic roll changing unit, winding axis, AC motor and control system.

13) Slitting unit

It can slit the big roll into small rolls according to the requirements from customers, which satisfies the customers with various lengths, widths and weight.

14) Component washing

The calciner adopts ultrasonic to wash and then check the spitting holes with microscope.

VI. AUTO. CONTROL

1) Spinning section

a) Temp. control of screw

Temp. control zone: 6

Temp. control: $280^\circ\text{C} \pm 1^\circ\text{C}$

b) Pressure control system

pressure transformer: Dynisco, USA.

adjuster: RKC F900, Japan

speed regulation box: SSD591, Eurotherm

DC motor: Simo

c) Measure pump regulation system

AC inverter: Fuji, Japan

Motor: 5.5kw*2

2) Managing section

The DC speed-regulation unit of net curtain former, curtain conveyor, hot rolling mill and winder adopts the following way to work.

Configurator: PLC control (LG, South Korea)

Speed regulation box: SSD590, Eurotherm

Motor: Simo

Speed measuring motor: Simo

3) Public project section

a) Air pressure control system(stretching)

speed regulator: RKC F900, Japan

inverter: Fuji, Japan

motor: AC induction motor

b) Air pressure control system(suction)

inverter: Fuji, Japan

motor: AC induction motor

VII. REFERENCE AND SPECIFICATIONS FOR AIR CONDITIONER DESIGN

1) Outdoor specifications

Wind direction in winter: N

Wind direction in summer: S

Dry bulb temp. in winter: 38°C

Dry bulb temp. in summer: 39.3°C

2) Technical parameters for each section

a) Negative velocity for spinning cooling: 0.3-0.5m/s

Air flow area: 3400×800mm

Temp. of air flow: approx. 200°C

Max. pressure of air flow: 200Pa

b) Stretching air flow

Max. air flow volume: 10000m³/hr

Temp. of air: 20°C±2°C

Pressure: 10-15Kpa

3) Air suction

Gross suction volume: 10000m³/hr

Max. negative pressure: 500Pa

Temp. surrounding the net surface: 20-30°C

VIII. PRINCIPLE OF DESIGN

The required air conditioner system must be extremely strong, thus, the normal air conditioner cannot satisfy this demand.

The system needs to be composed through proper treatment and improvement according to the technology of this extrusion line with the experience obtained during the production

practice.

IX. POWER SUPPLY & AUTO. CONTROL

High & low pressure power supply: designed by the customer

Illumination & small power systems: designed by the customer

Infrastructure: designed by the customer

Power & auto. control for non woven fabric: designed by the manufacturer

400KVA is required for installation.

| NO. | Equipment | Power for installation(kw) | Coefficient |
|-----|--|----------------------------|-------------|
| 1. | Feeding blower | 5.5 | 0.6 |
| 2. | Color master batch measure | 0.75 | 0.8 |
| 3. | Extruder | 90 | 0.4 |
| 4. | Measure pump | 5.5 | 0.5 |
| 5. | Heat conduction oil circulation system | 4 | 0.6 |
| 6. | Net former & preheating roller | 12 | 0.5 |
| 7. | Hot rolling mill | 30 | 0.6 |
| 8. | Oil circulator | 4 | 0.6 |
| 9. | Winder | 5.5 | 0.6 |
| 10. | Slitter | 4 | 0.3 |
| 11. | Fiber cooling stretching system | 37 | 0.55 |
| 12. | Suction blower | 37 | 0.6 |
| 13. | Cooling system | 32.6 | 0.6 |
| 14. | Cooling tower | 9 | 0.6 |
| 15. | Calciner | 18 | 0.4 |
| 16. | Ultrasonic device | 2 | 0.4 |
| 17. | Electric hoist | 1 | 0.2 |
| 18. | Illumination | 5 | 0.5 |
| 19. | Heating furnace | 102 | 0.4 |
| 20. | Recycling extruder | 10 | 0.4 |

YF-S3200

| NO. | Name of Part | Specifications | Origin | Remarks |
|-----|--------------------------|---|-----------|--------------------------------------|
| 1. | Extruder | Model: 170 | Shanghai | DC motor |
| 2. | Main motor | Optional: AC motor: 110kw DC motor: 140kw | 1set | AC motor: Siemens; DC motor: Simo |
| 3. | Motor for pump | 5.5kw | 2sets | YANFENG |
| 4. | Smoke exhaust ventilator | 11kw | 1set | YANFENG |
| 5. | Vertical filter | 5.5 | Zhejiang | 2 sets of filter cores |
| 6. | Measure pump | 200cc | Jiangsu | 2 sets |
| 7. | Pump body | Model: 320 | Self-made | 2 sets |

| | | | | |
|-----|---|-------------|-----------|---|
| 8. | Motor for pump | 5.5kw | Optional | Cycloidal pinwheel |
| 9. | Spinning jet | Model: 320 | Jiangsu | Slit |
| 10. | Components for spinning jet | Model: 320 | Self-made | YANFENG |
| 11. | Cooling air box | Model: 320 | Self-made | YANFENG |
| 12. | Air conditioner | Model: 320 | 1set | Carrier, USA |
| 13. | Smoke exhaust ventilator | 7.5kw | Optional | YANFENG |
| 14. | Components for smoke exhaust ventilator | Model: 320 | Self-made | YANFENG |
| 15. | Upper stretching | Model: 320 | Self-made | With upgraded configuration |
| 16. | Lower stretching | Model: 320 | Self-made | With stainless components |
| 17. | Fibre net former | Model: 320 | Self-made | Including 2 sets of spinning nets |
| 18. | Hot rolling mill | Model: 320 | Jiangsu | Guangyu |
| 19. | Winder | Model: 320 | Self-made | Automatic |
| 20. | Slitter | Model: 320 | Self-made | Frequency-conversion high-speed |
| 21. | Air suction blower | Model: 320 | Guangdong | YANFENG |
| 22. | Side blower | Model: 320 | Guangdong | YANFENG |
| 23. | Distribution box | Model: 320 | Shanghai | With touch screen, fully auto PLC control |
| 24. | Air conditioner | Model: 320 | Guangdong | Imported main body |
| 25. | Screw for color masterbatch | φ50 | Shanghai | Frequency-conversion speed-regulation |
| 26. | Heating system | 20w | Jiangsu | Vacuum calciner |
| 27. | Ultrasonic washing furnace | YANFENG | Jiangsu | |
| 28. | Material-suction feeder | YANFENG | Jiangsu | Automatic, with alarming control |
| 29. | Oil pipeline | YANFENG | Self-made | YANFENG |
| 30. | Stainless slurry pipe | Welded part | YANFENG | YANFENG |
| 31. | Spinneret | Model: 320 | Changzhou | Changzhou |
| 32. | Other spares | Model: 320 | YANFENG | YANFENG |
| 33. | Inverter | Model: 320 | 1set | Emerson/Delta |
| 34. | PLC | Model: 320 | 1set | LG |
| 35. | Relay | Model: 320 | n/m | CHNT |
| 36. | Breaker | Model: 320 | n/m | CHNT |
| 37. | Speed regulator | Model: 320 | n/m | RKC |
| 38. | Thermostat | Model: 320 | n/m | RKC |

Non Woven Fabric Roll Printing Machine & Fabric Bag Making Machinery

Product Description (All Parts Origin from Taiwan)

HYT series high speed non-woven fabrics flexographic printing machine

Features:

1. Major configuration

1. Low speed and full load startup; Stable running by tension control when increasing and decreasing speed, noise is decreased
 2. High dots presentation rate under high speed; Clear and

vivid stratification of screen printing; Strong stereo effect and accurate registering.
 3. Aluminum roller adopts the Japan semi-sealing small bearing; Flinty oxidation, static and dynamic balancing treatments are conducted; Low resistance and small flop.

4. The special made modulus angular gears adopted; Accurate printing size and full printing specifications (5mm is a spec)
 5. With the air exhaust, blowing and heating settings; The heating system adopts the central thermostatic

control system and group management, also with the cold air forming devices.
 6. Printing rolls should keep moving while machine halted

7. Material holder use air shaft
 8. Autotension control
 9. Unwind with auto deviation correction system (EPC)
 10. EDGE position control

11. Reversible printing 6 color press for 6+0, 1+5, 2+4, 3+3.
 12.1 sets of printing cylinder, sizes: 15 inches.

| | | | | | | | | |
|-------------------------------|---|---------|----------------------------|---------|---------|---------------------------|---------|---------|
| Printing width Item | 600mm | 800mm | 1000mm | 1200mm | 1400mm | 1600mm | 1800mm | 2000mm |
| Printing material | Single adhesive paper, Double adhesive paper, Copper plate paper, Kraft paper: 50-180g/ Single filter membrane paper, Double filter membrane paper: 80-300g/ | | | | | | | |
| Printing color | 4 special color | | | | | | | |
| Material feeding width | 700mm | 900mm | 1100mm | 1300mm | 1500mm | 1700mm | 1900mm | 2100mm |
| Printing length | 7.5 " -40 " /190mm-1016mm | | 7.5 " -50 " / 190mm-1270mm | | | 7.5 " -60 " /190mm-1524mm | | |
| Printing plate lifting system | Pneumatic/Hydraulic press control | | | | | | | |
| Mechanical speed | 180m/min | | | | | | | |
| Printing speed | 10-15m/min | | | | | | | |
| Anilox cylinder | 80DK-170DK(Germany)/180LPI-800LPI | | | | | | | |
| Register precision | Longitude: ± 0.1mm Transverse: ± 0.1mm | | | | | | | |
| Rewinder/Unwinder DIA | ø 1000mm /ø 1200mm /ø 1500mm | | | | | | | |
| Master motor | 5.5W | | 7.5KW | | 11W | | 15KW | |
| Rewinder motor | 5.5KW | | | | 7.5KW | | | |
| Unwinder motor | 5.5KW | | | | 7.5KW | | | |
| Electrical header | 26KW | | 32KW | | 38KW | | 45KW | |
| Blower of header | 0.75KW | | 1.1 KW W | | 1.5 K W | | 2.2 K W | |
| Blower of nature wind | 0.75 KW | | 1.1 KW | | 1.5 KW | | 2.2 KW | |
| Inking motor | 370W | | | | 750W | | | |
| Master frequency converter | 5.5KW | | 7.5KW | | 11KW | | 15 KW | |
| Master power | 45KW | | 54KW | | 68KW | | 82KW | |
| Weight | 8100Kg | 98760Kg | 9300 Kg | 9750 Kg | 10120Kg | 10500Kg | 11000Kg | 11700Kg |

REMARKS:

If the buyer wants to change the following parts with appointed brands, he has to bear extra charges around US\$10,000.

- Inverter: Siemens
- PLC: Siemens
- Main motor: Siemens
- Relay: Schneider
- Breaker: Schneider

Picture of the machines:



| Important parts | Brand : |
|---|----------------|
| MACHINE USE INDUSTRIAL CONTROL LEVEL PLC | Taiwan weilun |
| TOUCH SCREEN USE | Taiwan weilun |
| TRANSMISSION ARE DRIVED AND CONTROLLED BY | Taiwan |
| MAIN MOTOR | America yatai |
| SERVO MOTOR FOR FEEDING THE MATERIAL BY | Taiwan |
| UNWINDER EQUIPED WITH TWO PHOTOCCELL FOR TRACKING, SENSOR | Germany sick |
| TEMPERATURE CONTROL | OMRAN |
| SWITCH | SCHNNEIDER |
| AIR COMPONENT USE | TAIWAN AIRTACK |
| BEARING USE | JAPANESE NSK |
| Ultrasonic | Taiwan Jinrong |
| Printing Head and Offsets | Taiwan |



All other machinery like

Non Woven Fabric Making, Bag Making or Printing or Laminating Machine

You can check with attached pdf of company brochures so if possible please check it all or visit our site www.globalventure.hpage.com

Terms and Condition:

01. All the rules and regulation are change without prior notification in the benefit of company and its entity existence matter event for earning point of execution.
02. Payment will be mad in advance 35% and at the time of shipment from foreign country 60% in the matter of cash payment.
03. Payment will be made 5% or actual quotation Which was issue for financial mater like loan from the bank or any privet finance, this payment is not calculate for final booking payment here goods delivery after full payment from your financer to the Global venture Impex.
04. Delivery time is minimum 81 days from booking payment date that is already mansion in web site and company e-brochures.
05. Related matter of installation, service, and guaranty will be based on the company ultimate terms and condition and may change within the marker, social, government, natural etc. problems or rulings.

Thanks in anticipation, for asking your kind need full applications and do our best for your kind help and execution, we feel glad to join with you and if you ready with our terms please follow us we can make the change in the world likely hood.

We can give Best offer If you book your project with under 30 days of this document released on the base of cash payment (No Finance Support) for mare detail please contact Mr. Prashant Patel 9033817316.

Thanks again,

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