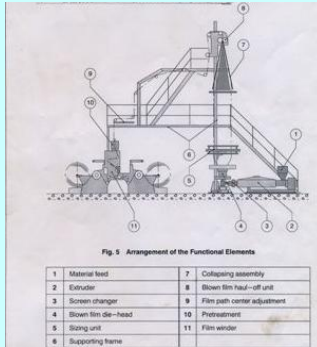


FOR SALES BLOWN FILM EXTRUSION LINE



Machine Features

- Country of Origin - Germany
- Brand Name - Reifenhauser
- Type 3.35 / 3.45
- Product width 1400 mm
- Raw material type PE- LD, PE-LLD, PE-HD (Used)
- Large film could be split to required size.

Could produce following films

- Fine Gauge Film
- General Packing Film
- Shrink Film
- PE-HD Film

Nawaloka Polysaks (PVT) LTD will offer the above machine located at factory in Nawaloka Industrial Estate, Elapitiwala, Ragama,

If you require any further information on the above machine please contact us on 0112 958221 / 5 3454403 / 5 345406, or visit our web site www.nawaloka.lk

Fax 2959302

Email polysacks.factory@nawaloka.lk

OPERATING INSTRUCTIONS -BLOW FILM HAUL-OFF UNIT
(AB-F-1400/1600-02-Ax)

D-53839 Troisdorf
Spicher Str. 46 - 48
Telefon: 02241/481-0

**Blown Film Haul-off Unit
AB-F-1400/1600-02-Ax**

Reifenhäuser
Dokumentation

2 General Description

The film bubble fixed in a polygon guide is collapsed on the film collapsing board and hauled off evenly by the haul-off unit.
The roll pair of the haul-off unit squeezes the collapsed film bubble together and thus prevents blast air from escaping. This ensures that the air column in the film bubble is as constant as possible.

The haul-off unit can either be used as a stationary unit, however it also can be mounted as a height-adjustable unit in the steel frame of the film blowing line.

Please refer to Fig. 5 for a schematic layout of the functional elements.

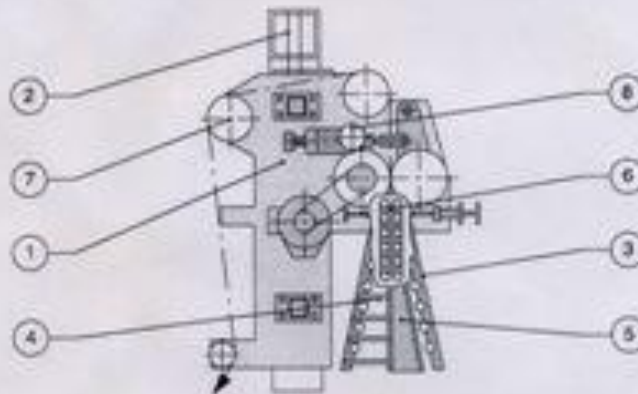


Fig. 5 General Description

1	Haul-off unit	5	Folding triangle (optional)
2	Height adjustment (optional)	6	Parallel cooling grid (optional)
3	Film collapsing board	7	Guide rolls
4	Film guide	8	Rotational pulse transmitter (optional)



The haul-off unit may only be used for the above-mentioned purpose, for which it is intended!
Improper use is forbidden!
Any deviations from this are the sole responsibility of the operator.

OPERATING INSTRUCTIONS -BLOW FILM LINE

D-53839 Troisdorf
Spicher Str. 46 - 48
Telefon: 02241/481-0

**Blown Film Line
3.35, 3.45**

Reifenhäuser
Dokumentation

PE Blown Film Extrusion Machine

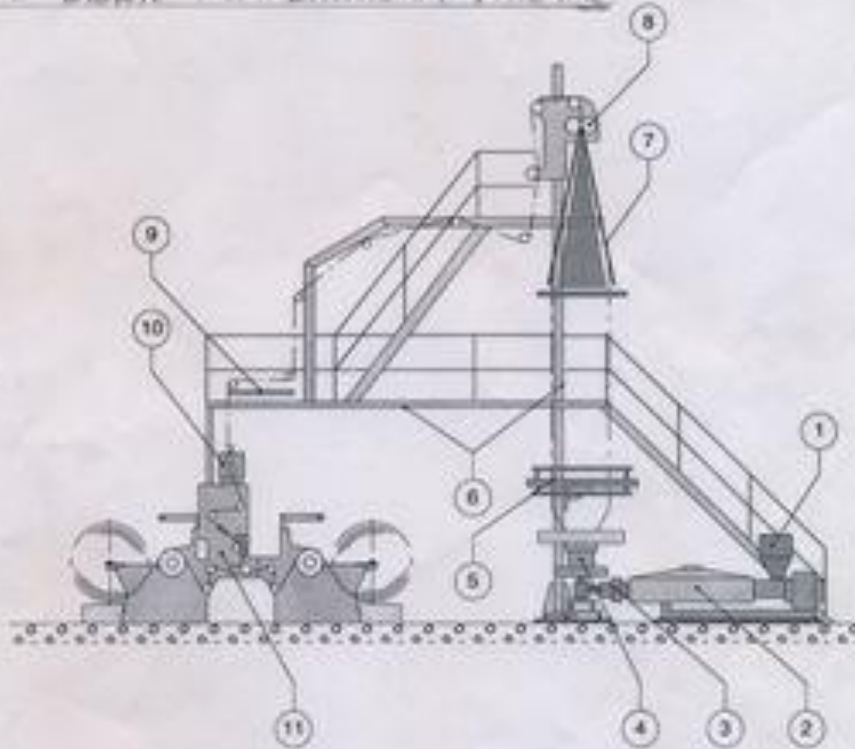


Fig. 5 Arrangement of the Functional Elements

1	Material feed	7	Collapsing assembly
2	Extruder	8	Blown film haul-off unit
3	Screen changer	9	Film path center adjustment
4	Blown film die-head	10	Pretreatment
5	Sizing unit	11	Film winder
6	Supporting frame		

OPERATING INSTRUCTIONS – SINGLE-LAYER FILM BLOWING DIE-HEAD

D-53839 Troisdorf
Spicher Str. 46 - 48
Telefon: 02241/481-0

Single-Layer Film Blowing Die-Head
BK-F 0150 / 0300 / 0350 / 0500 / 0700 -01-A3

Reifenhäuser
Dokumentation

2 General Description

The film blowing die-head enables the molten plastic compound produced by the extruder to be distributed in a ring and shaped into a blown film by means of an air supply.

2.1 Elements of the film blowing die-head

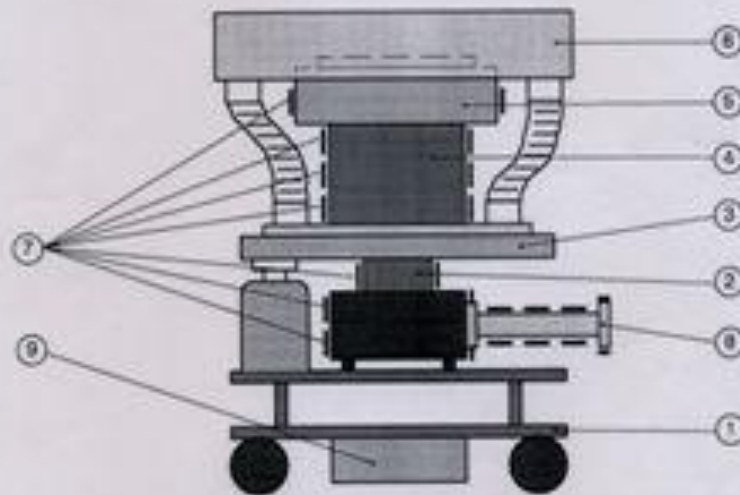



Fig. 2 Structure of the film blowing die-head

The film blowing die-head consists of the following elements:

1	Carriage	6	Air cooling ring
2	Reversing bottom section	7	Heaters
3	Air distributor ring	8	Adapter
4	Upper section	9	Air distribution tank
5	Die		

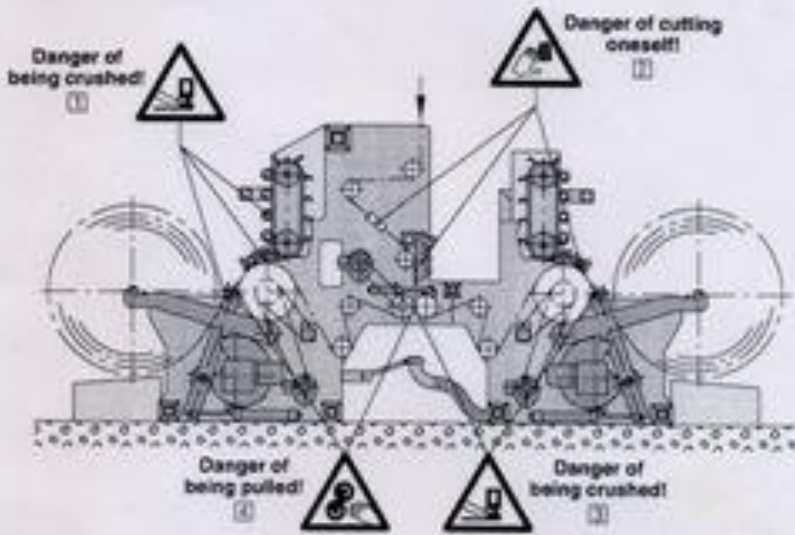
OPERATING INSTRUCTIONS –SFA WINDER

D-53809 Troisdorf Spicher Str. 46 - 48 Telefon: 02241/481-0	<h2>SFA Winder</h2>	 Reifenhäuser Dokumentation
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1 Dangerous Spots and Safety Devices

Dangerous spots of the winder are made safe by suitable safety devices. If proper safety devices cannot be mounted due to the conditions at hand, these areas are made safe by emergency stop devices.

1.1 Dangerous Spots of the Winder



The diagram shows a side view of the SFA Winder. It features two large winding shafts on the left and right, a central transfer unit, and various rollers and cutters. Four warning symbols are placed around the machine, each with a numbered callout: 1 (top left, 'Danger of being crushed!'), 2 (top right, 'Danger of cutting oneself!'), 3 (bottom right, 'Danger of being crushed!'), and 4 (bottom left, 'Danger of being pulled!').

Fig. 1 Dangerous Spots

When the winder is in operation, take care of the following dangerous spots:

- ❑ **1 Danger of being crushed** by swivel arms, winding shaft transfer unit and winding shaft!
- ❑ **2 Danger of cutting oneself** on the blades of the slitter, longitudinal cutter and transverse cutter!
- ❑ **3 Danger of being crushed** between the rolls of the auxiliary take-off unit, between the contact roll and the film reel!
- ❑ **4 Danger of being pulled** between the rolls of the auxiliary take-off unit, between the contact roll and the film reel!

Dangerous spots during assembly, alignment or maintenance works will be pointed out separately in the respective chapters.

TDO Zim-Amk-koo	Dokumentation für 233-826.1.62.00-715	Page 3
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