

Specifications VI-3-1500 Machine

VI -3-1500 is a bi-axial machine with traveling furnace. **VI-3-1500** has two straight arms with capacity to mount two moulds of 500 liter or two moulds of 750 liter on each straight arm and one offset arm with capacity to mount one mould of 1500 liter.

VI-3-1500 is a fuel efficient rotational molding machine with low electrical load, low manpower and hence very low production cost.

VI-3-1500 includes the following equipments:-

1. Traveling Furnace:

The traveling furnace is constructed by using ERW hollow square & rectangular sections; inner structure of oven is very compact and hence fuel efficient. Furnace doors are electrically operated with geared motor and safety over load protection clutch. For reducing the heating losses pneumatic system are used for door locking. For multilayer tanks top loading system is provided with ladder. For better appearance and long life the oven is painted with Polyurethane paint.

2. Turret:

Turret rotates on heavy duty base ring. The base plate of turret is one piece round plate which insure smooth indexing of turret. Rotation of turret is controlled by heavy duty gear motor with over load protection. Uninterrupted electrical supply is given to rotating arms through "Slip Ring Assembly". This slip ring assembly offers trouble free operation for years together.

3. Burner:

Italian "REILLO" make burner, which is suitable for diesel is used. The burner is most fuel efficient with low noise and smoke free firing. For higher efficiency and low maintenance a two stage 10 micron filter is used. It has flame failure indication along with safety feature which meets International safety standards. LPG and natural gas burner is optional at extra cost.

4. Re-Circulating Blower:

VI-3-1500, impeller is made of stainless steel and is dynamical balanced. It is a high capacity, low R.P.M and low noise blower. The blower shaft is supported on both sides with maintenance free high quality bearing. 5.0 Hp TEFC standard motor is used to run blower. Standard taper lock make pulleys are used.

5. Straight Arms:

Heavy duty straight arms can take up two moulds of 500 liter or two moulds of 750 liters each and offset arm can take up one mould of 1500 liter. The main shaft of each arm has a diameter of 130mm and is ultrasonically tested. Mould rotates in both X and Y directions with 8 R.P.M max. Variable speed A.C drive duty motors are provided. Heavy duty gear box is used for smooth operation. Chain drive is used for low maintenance. Mould mounting is very easy & fast.

6. Control Panel:

A user friendly control panel is provided. Toshiba and Schneider made drives are used for controlling speed of major and minor axis motor. For getting uniform thickness auto reversal facility is provided. Digital voltmeter for three phases, digital temperature controller, phase indicator lamp, and cycle timer are provided for easy operation & control. Hooter, flame failure lamp, safety interlocks are provided for safety propose.

Operating Parameters

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|----|-----------------------------|--|
| 1. | Production on straight arm: | 750ltr x2, 500 ltr x 2 or 300 ltr x 2. |
| | Production on offset arm | 1500 ltr x 1 or 1000 ltr x1. |
| 2. | Total Cycle Time: | 25 min. |
| 3. | Production Per day: | 63,000 ltr. Max (24 hrs). |

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|-----|-----------------------|--|
| 4. | Production Capacity: | 90 tanks/day. |
| 5. | Electrical Load: | 18.5 Hp(415 volt 3 phase). |
| 6. | Diesel Consumption: | 12 liter/hr |
| | OR | |
| | Gas Consumption: | 10.2 kg/hr |
| 7. | Process Temperature: | 180 degree. |
| 8. | Space for Machine: | L 12 Mtr x W 9 Mtr x H 5.7 Mtr. |
| 9. | Machine suitable for: | Double layer, Triple layer, Four layer and Foam /Insulated tank. |
| 10. | Manpower: | 3 Semi skilled persons. |

Technical Specifications :

Model No. : VI-3-1500

Spindles.....	3
Maximum Weight on each Straight Arm.....	500 Kg
Maximum Weight on Offset Arm.....	250 Kg
Spider Diameter.....	1200 mm
Major Axis R.P.M. (x-axis).....	0-8
Minor Axis R.P.M. (y-axis).....	0-8

Furnace / Oven

Maximum Kcal / Hr.....	124000
Usage Normal (Kcal/cycle).....	60,000
Maximum Temperature °C.....	250.0
Circulating Blower C.F.M.....	12000

Electrical

Supply Voltage.	415 V, 50 Hzs 3 Ph & Neutral
Oven Circulating Blower H.P (1 Nos.).....	5.0
Major Axis Drive AC Motor H.P(3 Nos.).....	2.0
Minor Axis Drive AC Motor H.P(3 Nos.).....	1.5
Burner H.P.....	0.5
Door Motor(2 Nos.).....	0.5
Furnace traveling motor.....	1.0
Turret indexing motor.....	1.0
TOTAL=	19 Hp

Scope Of our Supply :

Scope of supply includes machine and control panel as specified above.
Customer will have to provide for

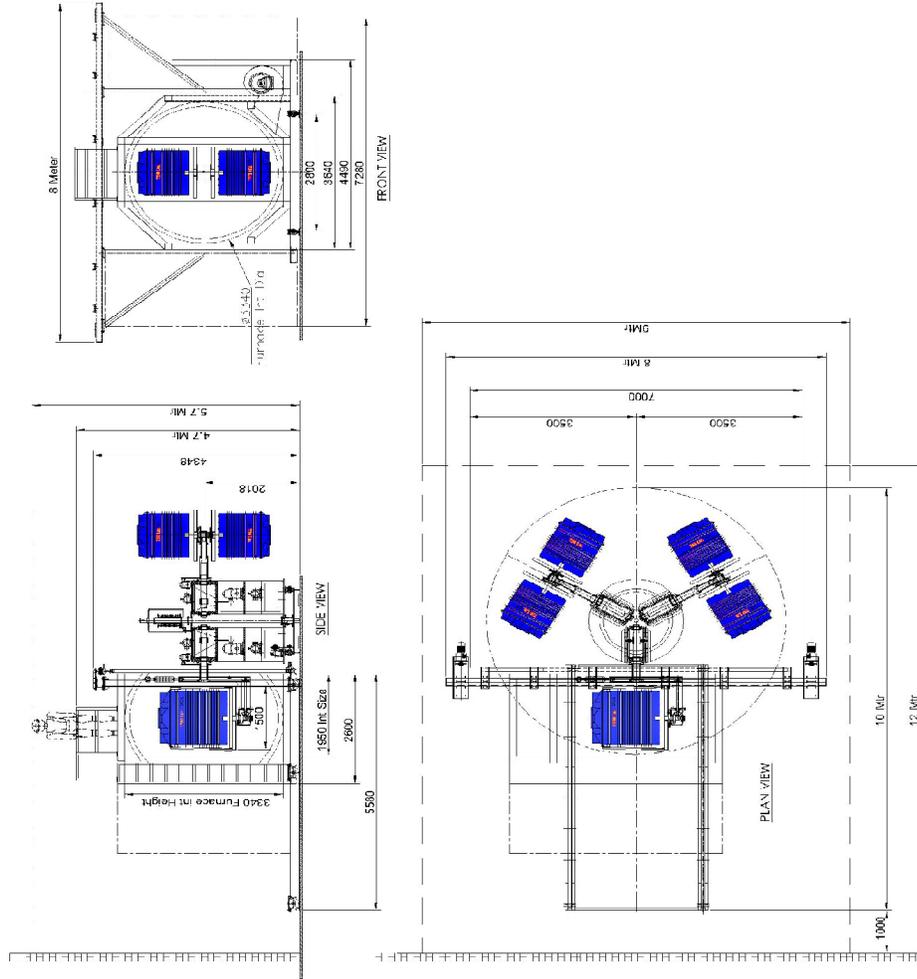
- 1 Foundation and civil work as required.
- 2 Electrical connection up to panel .
- 3 2 T electric hoist for Loading / Unloading of mould and product.
- 4 Erection and commissioning as per agreed terms.
- 5 Diesel Storage Tank.

Note:

Vinodrai also manufacture touch screen PLC based control panel on buyer's demand. It's a semi-automatic panel with ALEN BRADLY make PLC.

- ❖ Specification is subjected to improvement and development.

Vinodrai Engineers Pvt Ltd



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