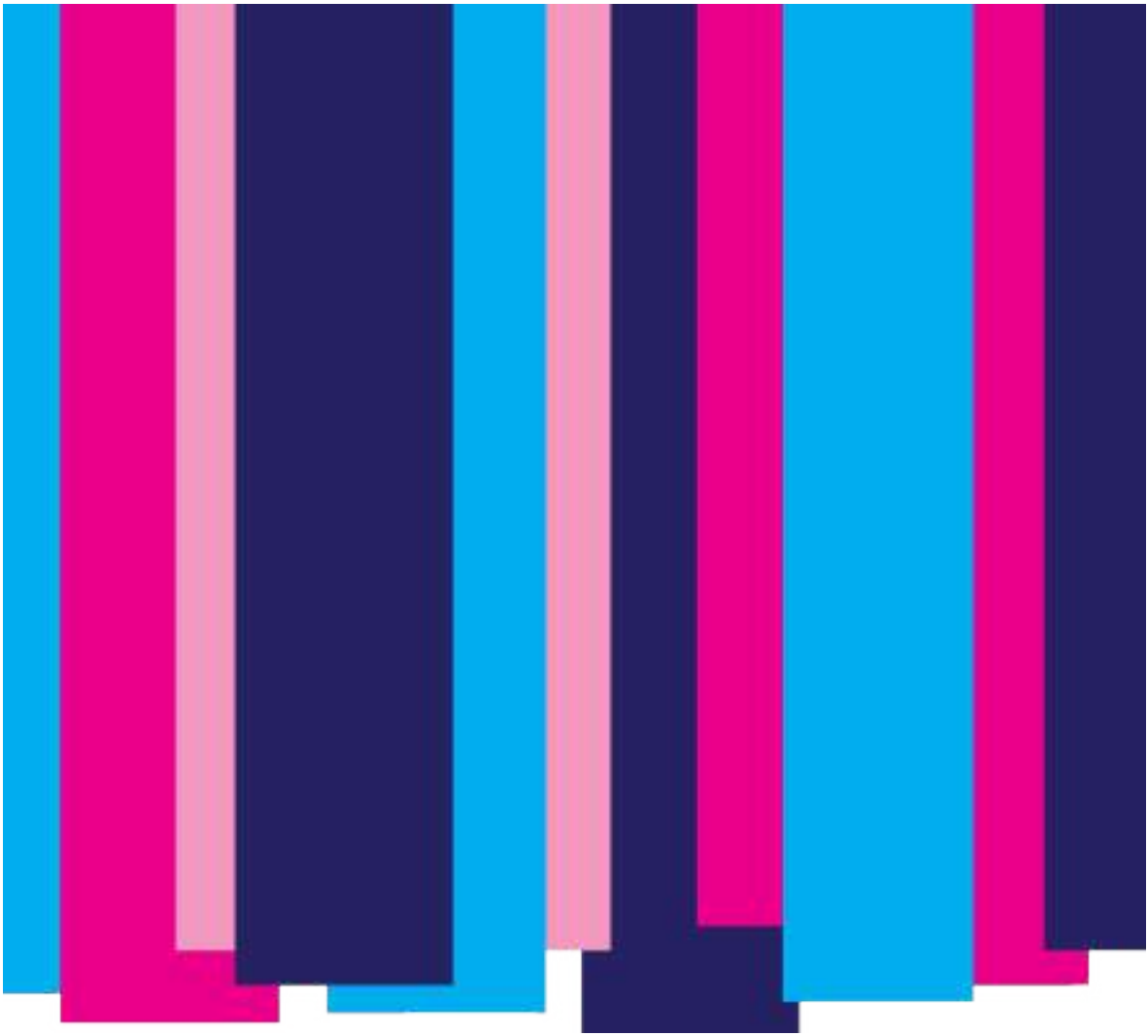


CHANGZHOU RUIYI NON-WOVEN PRODUCTS CO., LTD
常州瑞伊无纺制品有限公司

Needle
Punching
+Thermal
Bonding
Non-woven
Fabric
Production Line



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**CHANGZHOU RUIYI
NON-WOVEN PRODUCTS
CO., LTD**

**常州瑞伊
无纺制品有限公司**

COMPANY BRIEFING

常州瑞伊无纺制品有限公司多年来致力于各种机械产品的研制和开发，1998年始即成为我国较早生产无纺机械设备和制品的专业厂家，技术力量雄厚，公司生产的成套设备有：浸胶、热轧、针刺、无胶棉、喷胶棉、撒粉、浆点、双点涂层等传统无纺布生产线。新近开发了高速杂乱梳理机，梳理木浆复合水刺生产线，气流纯棉水刺生产线，水溶性绣花布生产线等。

常州瑞伊无纺制品有限公司位于遥观镇建农工业园，占地三万多平方米，厂区内建有万余平方米的金属加工车间和产品总装配调试车间，具有各种先进的刨床、镗床等机械加工设备，具备年产100条生产线的能力。

依靠科技求发展，不断为用户提供满意的高科技产品，是我们始终不变的追求。公司以其雄厚的技术力量、奋进的生产团队，势必创造出更加辉煌的业绩！

CHANGZHOU RUIYI NON-WOVEN PRODUCTS CO.,LTD HAS BEEN FOCUSING ON THE DESIGN&DEVELOPING OF NON-WOVEN MACHINES SINCE 1998,OUR COMPANY HAS MATURE TECHNOLOGIES IN PRODUCING

MACHINES LIKE:DIPPING,THERMOL-BONDING,NEEDLE PUNCHING,NON-COLLODION,COLLODION,ETC. CHANGZHOU RUIYI NON-WOVEN PRODUCTS CO.,LTD IS LOCATED IN JIANNONG INDUSTRIAL PARK,YAOGUAN TOWN,CHANGZHOU CITY, AREAS OF 30,000CBM,IN WHICH MORE THAN 10,000CBM FOR MACHINING CENTER AND ASSEMBLING,EQUIPPED WITH PLANING MACHINES,BORING MACHINES,ETC, IT HAS PRODUCTION CAPACITY OF 100+SETS ANNUALLY. OUR PURSUIT IS TO PROVIDE SATISFIED PRODUCTS FOR CUSTOMERS ON THE BASIS OF ADVANCED TECHNOLOGY. ALSO WE CAN PROVIDE NECESSARY SERVICE FOR OUR MACHINES AND SUGGESTIONS FOR NON-WOVEN PRODUCTS MANUFACTURING CONTINUOUSLY AT ANY TIME.

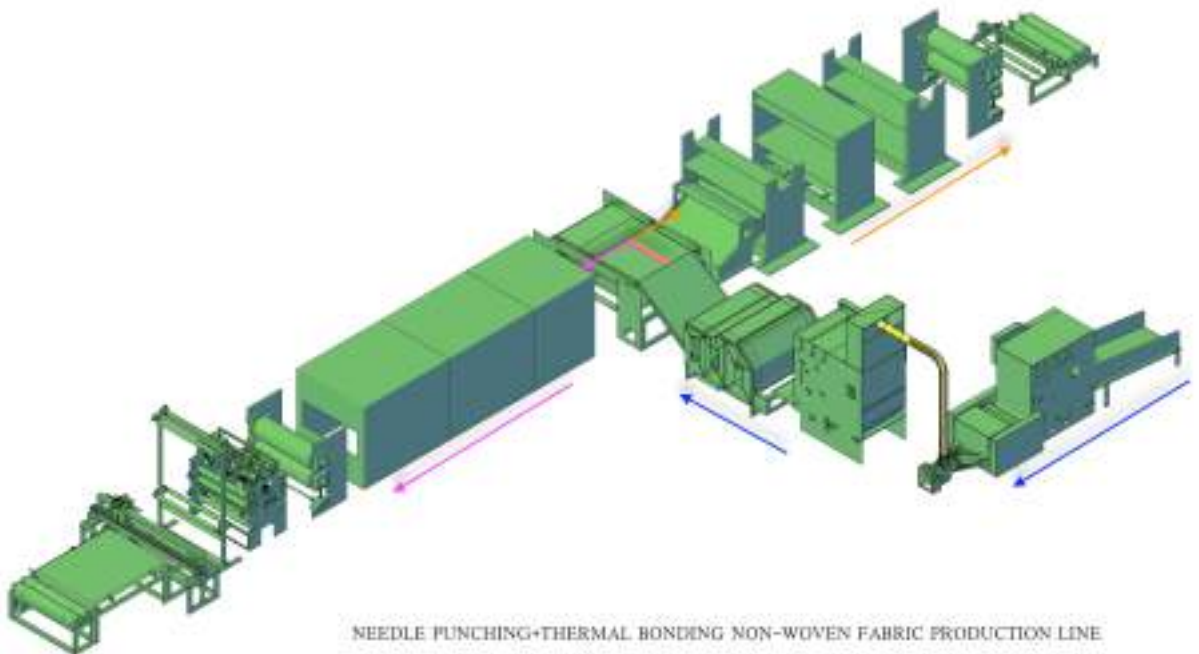
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Specifications:

Model:NPTB1500

1. Finished product: Needle punching fiber and Hard Polyester fiber
2. Product thickness: 5~100mm
3. Working speed: 10-40 m/min
4. Width of the finished product: 700 mm ~1200 mm
5. Raw material:
 - 5.1 Thermal bonding production line & Needle punching cotton line: polyester, cotton, jute, woolen
6. Heating method: Electricity boiler (Capacity :90kw)
7. Dimension of the Machine: Please refer to the layout.Max height:3200mm

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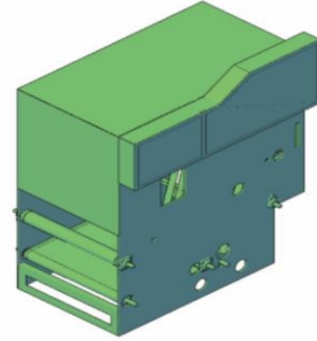
3D PROCESS LINE

CHANGZHOU RUIYI NON-WOVEN PRODUCTS CO., LTD
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❖ **Raw Material Conveyor**

❖ **ZW913/100 Blender**

- Dimension: L*W*H 2200*1000*2000mm, weight : 850KG
- Feeding curtain size: L*W 4550mm*980mm. Rotation speed: 20-30rpm. Motor: 10-59-1.1KW
- Capacity: 150-180KG/h
- Spiked curtain size: L*W 3700mm*980mm. Motor: 11-17-1.5KW
- Nail rod and beater size: W 980mm. Nail beater diameter: ϕ 390mm. Beater diameter: ϕ 260mm. Motor: 6P-1.1KW.
- Vibration and photoelectric switch control.
- In& out curtain size: L*W 1870mm*980mm



Blender



Opener

❖ **ZW901/100 Opener**

- Dimension: L*W*H 1500*1000*500mm, weight: 1000KG
- Four feeding roller, rack type feeding. Size: D ϕ 75mm* L 980mm. Motor: 10-59-1.1KW
- Rack type two roller opening. Two big rack opening roll, one rack space is 2.5mm, another is 2mm. Size: D ϕ 350mm* W 980mm. Motor: 4P-2.2KW.
- Adopt horn mouth, square transition and fan motor. Feeding motor: 4-3KW

❖ **Fiber Conveyor Fan**

❖ **ZW912/130 Vibrating hopper With Volumetric Feeder**

- Vibrating Hopper & Volumetric Feeder with Feed silo Working width mm 800- mm 1200 including
- Horizontal Feed conveyor
- Inclined spiked apron
 - Fiber dosing device
 - Fiber discharging device
- Spiked curtain size: L*W 3700*1300mm. Motor: 11-17-1.
- Nail rod beater size: D ϕ 390mm* W1300mm. Motor: 6P-1.1KW
 - Vibration and photoelectric switch control.-
 - Feeding curtain size: L*W 1870*1300mm. Out curtain size: L*W 1320*1300mm.-
 - Horizontal discharging conveyor for next carding process
- Adjustable photoelectric control fiber storage bin



Vibrating Hopper

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Carding Machine

❖ **ZW9803/150 Three doffer Pre-carding machine**

- Three doffer Pre Card mod. **ZW9803/150** Working width mm 800-mm 1200 including
- Dimension: L*W*H 2300*1550*1750mm, weight: 6000KG
- Feed Table
- Feed rollers with licker-in-roller
- Breast roller with 4 pair of workers and strippers
- Transfer roller
- Main cylinder with 6 pair of workers and strippers
- Doffer with doff-comb & Seven carding points by doff-comb
- Feeding roller: 4pcs, D ϕ 75mm* W1550mm. Motor: 10-59-1.1KW with feeding table
- Cylinder size: D ϕ 860* L1550mm. Motor: 4P-7.5KW. Rotation speed: 0-600rpm.
- Doffer: 2pcs, D ϕ 400* L1550mm. Motor: 11-17-2.2KW6.5 Working roller: 5pcs, D ϕ 140* L1550mm
- Stripped roll: 7pcs, D ϕ 90* L1550mm. Stripped roller: 4pcs, D ϕ 76* L1550mm
- Licker: 1pcs, D ϕ 260* L1550mm
 - Random roll: 4pcs, D ϕ 230* L1550mm
- Stripped roll: 2pcs, D ϕ 102* L1550mm
 - Big undercover: R430*570*L1566mm
 - Small undercover: R130*255*L1566mm



Cross Lapper

❖ **ZW2103/1518 Cross lapper**

- Feed in Width : mm. 800-mm1200 useful
- Fibre lap width : mm. 1000-mm 1660
- Floor apron width :mm. 1400-mm1800
- Motor: 3.7Kw. Weight: 3000KG.
- Adopt advanced synchronous AC motors+Inverters drive system, controlled by PLC
- Machine speed: 0-40m/min
- Feeding curtain size: L*W 7400*1660mm
- Reciprocating curtain size: L*W 4650*1660mm - Flat curtain size: L*W 3010*1660mm
- Bottom curtain size: L*W 5300*1800mm

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❖ Needle Punching Unit

- Web feeding /Needle Punching Feeding system working with mm. 1000
- Conveyor material: PVC belt
- Double web fiber feeding system with conveyor material of PVC belt
- Main cylinder with plastic fingers.
- Conveyor driving by AC motor with gear reducer, controls by inverter.
- Pre-Needle Loom working width mm. 1000
- Needle density : 5000 per linear meter
- Total Needles : 5000 x 1 =5000
- Stroke frequency : 1000 stks/min
- Needle beam broke : 50 mm
- **Barbed Needle Punching Loom Included Which working width mm. 1000**
- **Needle density : 5000 per linear meter**
- **Total Needles : 5000 x 1 =5000**
- **Stroke frequency : 1000 stks/min**
- **Needle beam broke : 50 mm**
- Installed power:both 8.1kw
- Needle punching speed:0~6m/min
- Final/Main Needle Loom working width 1000
- Needle density : 6500 per linear meter
- Total Needles : 6500 x 1 =4000
- Stroke frequency : 1000 -1200 stks/min
- Needle beam broke : 40 mm
- Installed power: 8.1kw
- Needle punching speed:0~6m/min



NeedlePunching

❖ Calender unit

- Dimension:1000mm*(1600-3000mm)*2000mm,weight:8000-12000Kg
- Calender roller:Heated by high thermal oil, the temperature for each roller can be adjusted individually,
- the max. working temperature is 180°C, the Dia. of the calender roller is 505mm.
- The distance between upper and bottom rollers is adjusted by lifting the bottom roller, which driven through worm reducer with worm pole, the adjusted range is 0~100mm
- Dimension of the heating device:1000*900*2000mm,weight:1000Kg,two separate thermal oil tanks for heating calender rollers respectively, electricity heating power:45kw*2,



Calender Unit

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- Max. thermal oil temperature:80~180°C,the power of the oil circulation pump:4KW.



Cutting&Rolling

❖ Cutting and Rolling Unit

- Double hard rubber rollers for rolling, electrical meter, required length reminding function, manually electrical cutting with selvedge cutting.
- Dimension:2000*2060*800mm,weight:600kgThe rolling motor is cycloidal-pin gear speed reducer BWD1-1 : 17/2.2KW.

❖ Thermal bonding Unit- Hot-air dryer (Oven)

- -Working width mm. 1200
- -Dimension: 5000*1600*2000mm
- -Weight : 800 Kg
- -Number of conveyor : 2 Layer Conveyor
 - Bottom conveyor for fibre lap transportation
 - Top conveyor for material calibration
 - Top conveyor nip-adjustment by magnetical lifting up system
 - Conveyor belt:High temperature resistance Teflon coated net belt, width of the net:1500mm .
 - Thermobonding chamber length mm. 5000-total
 - Number of thermobonding chambers : 1
 - Heating System by direct Natutal gas burners ,150000 Kcal/h
 - Number of burners: 2 Pcs, Riello (Italy) Brand.
 - Burners type : Pilot+ modulating flames
 - Hot air circulation system by controlled blowing + sucking cycle
 - Number of blower : 2-centrifugal fan type , driving by AC motor with inverter controlling, upper suction and bottom blow/upper blow and bottom suction interchange system.
 - Working Temperature 80-200 Centigrade.
 - Linear speed 0-15 m./min , depending on material weight
 - Main Drive System: AC motor + Inverter , cycloidal-pin gear speed reducer BWD3-1 : 59/5.5KW, individual belt driving system Driving motor power:5.5kw .
 - Control Panel Included.
- Two Bowls cold Calender system working width mm. 1200
- -Bowls cooling system: by cold water circulation
- -Bowls nip manual adjustment
- -Bowls rotating drive through compensating clutch mounted on the upper bowl
- -Calender pressure through compressed air pistons



Hot-air Dryer

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- -Max calendaring pressure : 5 tons
- -Drive : AC motor
- Cooling Section Working width mm. 1200 including
- -Air sucking section-material through forced type
- -Drive : AC motor + Inverter

❖ **Lengthway Cutting Unit**

- Dimension:1000mm*(1600-3000mm)*1800mm,
- weight:1000-2000Kg
- Lengthway motor power:0.75kw,
- Ratio of the reducer:1:5, quantity:3pcs.
- The cutting width will be done by screw pole Pulling system:cycloidal-pin gear speed reducer BWD1-1 : 17/1.5KW
- Lifting cylinder for lengthway cutting:SC-63*150, quantity:3pcs

❖ **Storage Frame**

❖ **Crosswise cutting and rolling unit**

- Dimension:3650*(2815-4315)*1400mm,weight:1000kg.
- It can cut the thick hard cotton crosswise and thin hard cotton off by lengthway as per required length.
- Action process:when block cutting for thick hard cotton—convey pause—plate pressing—cutting motor and moving motor start—to the other side to touch the distance switch to stop—plate releasing—fabric convey again.
- Required rolling length:photoelectrical meter makes signal as per setting length—rolling pause— plate pressing—cutting motor and moving motor start—to the other side to start distance switch to stop—plate releasing—fabric convey again.
- Rolling motor:WPDO 2.2KW, crosswise cutting motor:0.75kw,gear reducer ratio:1:5, moving gear reducer:BWD1-1 : 9/1.5KW.
- Cotton pressing plate pneumatic cylinder:SC-63*150.

❖ **Rolling Unit**

❖ **Control Cabinet**

- 3 Control cabinets for front process, needle punching process, Thermal bonded process respectively

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