

# **POSSIBLE ORIGINAL** **SALE QUOTES**

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"We hereby offer for a limited period of 30 days following the date hereof the items described below and/or in the specifications, if any, consisting of the pages attached hereto. **This offer is subject to the terms and conditions contained herein and attached hereto and in the specifications, if any, and to no others whatsoever. We object to any additional or different terms.**"

### EQUIPMENT SUMMARY

Item 1 Extruder

- A. 6" 34:1 L/D Davis-Standard Scrap Reclaim Extruder
- B. 6" 34:1 L/D Davis-Standard Extrusion Screw
- C. Temperature Control Panel
- D. 500 HP AC Drive

**FINAL DISCOUNTED SYSTEM PRICE: \$297,055.00**

Item 2 Hydraulic Slide Plate Screen Changer

- A. Model EH-80
- B. Hydraulic Unit

**FINAL DISCOUNTED SYSTEM PRICE: \$37,145.00**

Item 3 Water-Ring Pelletizing System

- A. Model WRP-35S Pelletizer

**FINAL DISCOUNTED SYSTEM PRICE: \$71,150.00**

Options:

Treated lumber skids and crates

Price adder: \$1,000.00

Budget estimate for freight to Santa Teresa, NM for each 40' trailer (DS will charge the actual cost of this freight; note more than a single trailer could be required for the complete line; this cost is subject to changes in fuel surcharges not known at this time) Price adder:  
\$3,600.00

Budget estimate for start-up service including travel and living expenses; 3 days on site

Price adder: \$8,100.00

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## EQUIPMENT SPECIFICATIONS

### DAVIS-STANDARD SCRAP RECLAIM EXTRUDER

Davis-Standard 6” 34:1 L/D, vented, water-cooled DS Scrap Reclaim Series Extruder with extrusion screw, temperature control panel, and AC drive including the following:

- Rugged base weldment with leveling pads and integrally mounted front barrel support.
- Heavy duty gear reducer with double reduction helical gears, nominal reduction ratio of 17:1. Rated 530 HP at 100 RPM with a 1.50 service factor.
- Thrust bearing with a B-10 life of 509,000 hours at 100 RPM and 5,000 PSI.
- Lubrication system with shaft driven pump, filter and heat exchanger.
- Direct coupling of motor to input shaft, coupling and guard included.
- One piece flanged 10,000 PSI alloy steel, vented barrel with centrifugally cast bimetallic liner.
- Vent stack and plug are included.
- Barrel discharge is flanged to mate to downstream equipment.
- Rupture disc plus spare, rated at 9000 PSI.
- Melt pressure transducer, model DST-101 (1% regulation), 0-10,000 PSI rating.
- Tangential scrap feed throat with extra wide opening, grooved horizontal liner, water-jacketed with screw shaft seal, designed specifically for reclaim materials.
- Chute type hopper with sight glasses **and additional inlet designed to accept your hopper loader for use in feeding the flake material.**
- Seven electrically heated, water-cooled barrel zones with cast aluminum heaters.
- Base mounted closed loop cooling system
- Insulated barrel hoods.
- 6” (152mm), 34:1 L/D extrusion screw with Deloro 55 hard-faced flights designed for the specific application.
- 500 HP (393 kw), 1750 RPM AC Variable Frequency Drive (Yaskawa F7) with DPFV motor
- DS-TPC provides a touch panel solution to replace discrete temperature controllers, temperature indicators, pressure indicators, pressure controllers, drive operators, and drive indicators
- The DS-TPC includes a 12.1 inch color touch screen with built in PLC processor, subpanel mounted multi-loop temperature control, and PLC I/O modules required for the system
- The DS-TPC is designed to offer touch-screen control - **AT THE SAME PRICE** as discrete devices performing the same functions. This is accomplished through the use of fixed hardware components and preconfigured engineering solutions
  - Standard features common to all DS-TPC systems include the following:
  - 12.1 inch Color HMI mounted in the extruder control panel
  - Extruder melt temperature indication
  - Extruder drive controls including speed and load indication
  - Extruder discharge pressure monitor including 2 alarms
  - Melt Temperature monitor
  - Cold start inhibit - Barrel only
  - 10 Recipes (temperature only)
  - ( 7 ) extruder heat/cool zones

- ( 5 ) heat only zones (3 screen changer, 1 adapter, 1 die)
- Solid-state contactors and circuit breaker protection on each control zone
- Main circuit breaker with external interlock to disconnect incoming power when servicing
- A control transformer is provided in the panel for all control circuitry
- Solid-state contactors and circuit breaker protection on each control zone- Forced air ventilation system with filters
- Pelletizer controls included through touch screen
- Wired for 460V/3ph/60Hz operation.

### **HYDRAULIC SLIDE PLATE SCREENCHANGER**

- Fully assembled and arranged for connection to extruder discharge.
- Downstream reducer bushing.
- Two breaker plates.
- Solenoid operated directional valve integral with hydraulic cylinder.
- Pre-wired extend/retract push-button controls interlocked with guard limit switches and hydraulic unit pressure switch.
- Body heaters arranged for 460 volt power.
- Slide plate heated by heat pipes or cartridge heaters.
- Requires three zones (EH-80) of temperature control.
- Fully enclosed electrically interlocked slide plate guards.
- Power cord and thermocouple lead with plugs for connection to extruder plug box.
- Hydraulic power unit:
  - Reservoir.
  - Accumulator.
  - Power on and pressure ready lights.
  - Hydraulic hoses with plumbing fittings.
  - Electrically interlocked with the slide plate guards.
  - Arranged for operation on 460 volt, 3 phase, 60 hertz power

### **WATER RING PELLETIZER**

- Pellets are cut in air at the die face, and then quenched in a ring of cooling water.
- Hot, dry cutting provides simple start-up with no critical timing sequence.
- Production is continuous and is insensitive to flow disruptions caused by screen changes or loss of feed.
- "Flex Blade" design eliminates adjustment, automatically compensates for blade wear, and provides long blade life. No micrometer adjustment is required and critical alignment of the cutter shaft to the die face is eliminated.

- 'Fines' generation is reduced since contact force of the blade against the die plate is controlled, insuring that pellets are always discrete and well formed.
- "Slurry Quench" provides the ultimate in pellet cooling efficiency. Total immersion of the pellet production in the slurry allows an instant quench of the entire pellet surface as compared to other water ring pelletizer designs where only 50%-60% of the pellet is cooled as it floats in a trough.
- Pellet contact and subsequent agglomeration are virtually eliminated, as is excessive off-dryer pellet temperature.

**Upstream Adapter** to connect to screen changer

- Straight flow adapter made from heavy walled ASTM A106 Grade B pipe, arranged for connection between inlet of the WRP and screen changer.
- Includes band heater and attachment bolts.
- One (1) Zone of temperature control required.

**Water Ring Pelletizing System** including:

- Unit rated for 600° F max operating temperature and 3,000 psi pressure
- **Crosshead Die Assembly:** Electrically heated die body with low restriction mandrel provides even distribution of polymer to the die plate for uniform hole-to-hole flow. Two (2) zones of temperature control are included.
- **One Die Plate:** Heat-treated and nitrided alloy steel for wear resistance and long life. Specific hole geometry and quantity based on your application data.
- **Flexible Blade Assembly:** Self-adjusting, low contact force, flexible cutter blades eliminate all operator attention. Blades are made from heat-treated tool steel and rotate eccentric to the die holes for long life. Blade Holder is nickel-plated and accepts two (2) or four (4) blades.
- **Cutter Drive:** Variable frequency AC drive, directly coupled to cutter shaft, provides easily adjustable, maintenance free control of pellet length.
- **Centerline Height:** The unit will easily accept centerline heights from 36.5" to 45". No centerline height adjustment is required.
- **Cooling Chamber:** Heavy-duty two-piece design allows simple lift-n-turn separation of the lower tube section for immediate blade access. Upper section, containing plenum and nozzle remains in position during blade change. Chamber is electrically interlocked with system for safe operation.
- **Feed Trough - Tank:** Fabricated from heavy walled stainless steel, integral slurry feed trough allows easy startup and in-process pellet inspection prior to submersion in the underwater slurry. Tank is open for easy access and cleanout.
- **Underwater Pellet Slurry:** The slurry pump accepts the pellet sluice and draws in additional water from the tank. Pellet submersion in the highly turbulent water stream maximizes heat transfer efficiency; virtually eliminating agglomeration and assuring desired off-dryer pellet temperature control.
- **Water Circulating System:** Includes dial thermometer, level controls, pump and optional heat exchanger, all plumbed and assembled. Circulating water temperature is best maintained by using the optional heat exchanger package.
- **Dewatering Unit and Dryer:** Pellet and water separation is accomplished prior to the dryer in an adjustment- free dewatering unit. The dryer is supplied with a 'pellet free' rotor and removable screens for fast, thorough cleanout and an integral blower for moist air removal. Single large panel

door design provides increased structural integrity and is electrically interlocked to prevent system operation if the door is opened.

- **Total Fines Management:** Circulating water is continuously filtered through four (4) high capacity bag filters fitted to the dewatering unit and dryer drain lines. The bags are capable of filtering large quantities of fines and can be changed or cleaned in seconds while on-line and making pellet.
- **Support Cart:** Fabricated from structural shapes and contains above apparatus except pelletizing head and cooling chamber, four (4) swivel "V" groove casters for operation with or without "V" track.
- **Electrical:** System is pre-wired to a junction box with disconnect cables for connection to the extruder junction box.
- **Pelletizer Controls:** Are mounted in extruder control panel, including Start and Emergency Stop buttons, 10 turn cutter speed pot, cutter RPM meter, and pellet/purge selector switch which allows the die to be purged to the floor.
- **Heat Exchanger:** Heat Exchanger less cooling water controls, mounted and plumbed, sized for up to 3500 lbs/hr, capable of maintaining 120° F circulating water bath temperature assuming 100 gpm of 85° F cooling water and 450° F melt temperature.
- **Regulating Valve:** Manually adjustable valve with temperature gauge and sensor, adjustable between 70-130° F (tank water) plumbed to cooling water inlet port above heat exchanger.
- **Discharge Duct:** Flexible Dryer Discharge Duct for discharging pellets into Gaylord or similar container. Duct is supplied 5.5 feet long and may be cut to length as desired.
- **Support Stand:** Cutter head/cooling chamber support stand provides movable support for pelletizing head and cooling chamber. Stand is fabricated from structural shapes and includes adjustable mounting plate to match extruder centerline height. Four (4) swivel "V" groove casters are included for use with or without track (Optional track to be provided by MCS).