

Re:BCW/151007

No. 1 bag weaving plant STARLINGER, using PP and PELD & HD, LLDPE Tapes 2.5 and 3.5mm, consisting of:

- extrusion 105 mm w. 192 take-ups,
- with 24 nos. circular looms STARLINGER,
- finishing (sewing & cutting),
- printing, waste recycling and accessories

Extrusion line RP 105, model M105 BV-30D

Diameter of Screw (D) 105 mm
Length of Screw (L) 3150 mm Ratio 30 = L/D
T-Die Width 1060 mm
Working Width 1000 mm
Gap Fr. 0.2 to 0.8 mm
No. of Heating Zone 5
Heating Capacity 18 Kw

Automatic Screen system

Screen Specs RDW 4 1/2" X 60`
Mesh 132 X 14 SS
Heating Capacity 5 Kw
System Continuous System
Oven Type Hot Plate Table
Condition The Top Plate has to be changed but generally it is working good.
Barrel and Screw are still the original one. They are still in good shape.
No modification has been made yet.

Cross Winder (Starlinger)

Model: Fil 23
Type: Magnetic drive by Electric Motor 0.18 Kw/winder
Bobbin Core : ID 35 mm
OD 40 mm
Length 218 mm
Traverse Length 203 mm
Approx. 12:1 Transmission Ratio
Condition: Generally all 192 winders are in good conditions except some thread guides have to be replaced due to normal wear and tear.

Circular Looms (Starlinger)

Model : HDN 4
Working Width : 200 mm - 850 mm DFW (Double Flat Width)
Max. weaving ring dia: 541 mm. (21.3 inches in dia.)
Weft insertion: 640 picks per min
Weft Density : 22-67 Filaments per 10 cm.
No. of shuttles: 4-Shuttles
Weaving Capacity: Rating of the machine is 640 picks per min, at a weft density of 9 picks per inch. is only 108 meters per hour (100%)
at 12 picks per inch is only 81 meters per hour (100%)

8 picks per inch is only 122 meters per hour (100%)

Output at:

1000 Dn., 2.5 mm Tape using 190 winders at 85 % eff. Is 162 Kgs/ hr.

750 Dn., 3.0 mm Tape using 164 winders at 85 % eff. is 120 Kgs/hr.

The output will vary depending on the denier and width of tape being produced.

The Tape Tenacity is between 5.5 to 6.0 Kg/dn. and will vary greatly with the type of resin and the percent concentration of the additives added.

Normal High quality Virgin Pellets gives the tenacity of;

Virgin Pellets (1000 Dn.) - 6.0 kgs/Dn. using a lower conc. of additives

Wide Specs (1000 Dn.) - 5.0 Kg./Dn. using a lower conc. of additives

Conversion lines Starlinger, 2 units:

1 unit Autokon conversion line designed to process cutting, sewing, and final stacking of bags made out of endless tubular cloth.

1 unit Polykon conversion line specially designed for cutting, sewing, 2 color one side printing and final stacking of bags made out of endless tubular cloth.

Recycling Machine Starlinger

Model Indumat 250 (Recycling machine)

Type, output capacity PP 150 kgs per hour

PE (HDPE, LDPE & LLDPE) 100 - 120 Kgs. per hour

The output capacity will depend on the quality of waste to be regranulated.

Die -Face Cutter of Repelletizer

The melt is pressed out through a perforated plate, cut off in hot condition by a rotating knives and pelletized by a centrifugal water cooling system. Runs through the vibration sieve for drying and with the quick rotary motion concludes the drying prior to transporting finished pellets to the cyclone for temporary storage.

The Agglomerator process is done between the shredding process and the feeding process through the conical long - term nitrated screw plasticizers and homogenizes the material in one operating cycle

Age of machinery:

The machineries were installed and put in operation in the late July of 1988 till recently.

The plant was in operation for 19 years.

During the 10th year of operation, the plant runs only a 50% capacity, 15th year of operation 25 % till stop.

Plant Capacity :

Processing 20" cloth width 11X 09 mesh, 850 denier

Weaving output at 108 mtrs/ hrs, 21.75 hrs per day, at 85% eff.

weaving output per 5 days 47,900 X 5 day = 239,500 meters

Kg output (77 grams per meter) = 18,440 Kgs.

Extrusion line output at 85% eff. = 130 Kgs. per hour

Kg output at 24 hrs. 7-days = 21,840 Kgs per 7-days

Net output at 12.5% waste = 19,110 Kgs per 7-days

Estimated out per month at 22 wd, 2% waste loss,
bag size 20X40 1109 weave = 960,840 bags per month

