

®



EXTRUSION
ISO 9001-2008



Model FK/BFS-55/65/55-1400VR



Model FK/BFS-65-1300HR



Model FK/BFS-55/65/55-1400HR



Model FK/BFS-70-2200TS

BFS Series

MONO LAYER
MULTI LAYER CO-EXTRUSION
BLOWN FILM LINE



MONO LAYER MULTI LAYER CO-EXTRUSION BLOWN FILM LINE

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FKI offers one of the most advanced and adaptable blown film lines for various applications, such as shopping bags, vest bags, garbage bags, agricultural film, construction film, packaging film and lamination film, etc. The workable materials that can be used are such as LDPE, LLDPE, MLLDPE, and HDPE. The film production range is from 200mm to 7 meters in tubular width, and the production output rate is from 40 kg/hr to 800 kg/hr.

Based on 30 years of experience, FKI is capable of offering blown film lines with reliability and versatility to meet different requirements from mono layer, double color, double layer, and three layer to four color designs. The models range from simple, compact, manual film cut, to fully automatic system control provided from the gravimetric dosing system, internal bubble cooling system, oscillating haul off, fully auto fill, cut and changeover winder, to the thickness and width control system.

Main Features:

1. The extruder is built with a screw barrier flight design at the length ratio of 28:1 and 30:1 with a grooved feeder barrel in order to achieve the best plasticization, mixing result and high extrusion output rate. A heavy duty gear box with SKF thrust bearing of Swedish origin is complete with forced type lubrication oil pump and cooler, to ensure longer running life.



3. The take-up unit is designed and built with a heavy duty steel frame structure. Its height is adjustable by motor for HDPE film processing and with tower height fixed for LDPE/LLDPE film processing. The oscillating haul off unit is available in a vertical or horizontal design, as per the customer's request, which is a design that gives a much better film gauge distribution compared to a rotating die head. A collapsing frame is also available with guiding bars, made from wooden rods or aluminum rollers, for choice.



2. The extruding die adopts the latest technology with spiral channel design to give smooth parison flow and allow pressure drop to avoid the die line. The air ring of the aluminum casting chamber with high precision machining and a polished air surface gives an even air flow and maximum stability. Heat insulation is provided in between the air ring and the die head to give a better control of air cooling. The turbo blower with inverter control gives accurate volume adjustment, and is the standard device. A bubble cage, with height and diameter adjustable by motor, is also the device for LDPE/LLDPE film processing.
4. The surface friction type design winder provides hand-free operation from film winding to reel change. Film cutting is controlled by the auto counter to sound the alarm when the setting meter is reached and the film is to be automatically cut by the air knife, which is operated by the rod less air cylinder. Labor is only required to load the empty winding shaft and move away the finished film roll. The winding air shaft is the standard attachment. The double station winder positioned as back to back, face to face, or up and down is an option when the open film is to be cut into single layers.



MONO LAYER **MULTI LAYER CO-EXTRUSION** **BLOWN FILM LINE** >>> **BFS series**

Standard Parts:

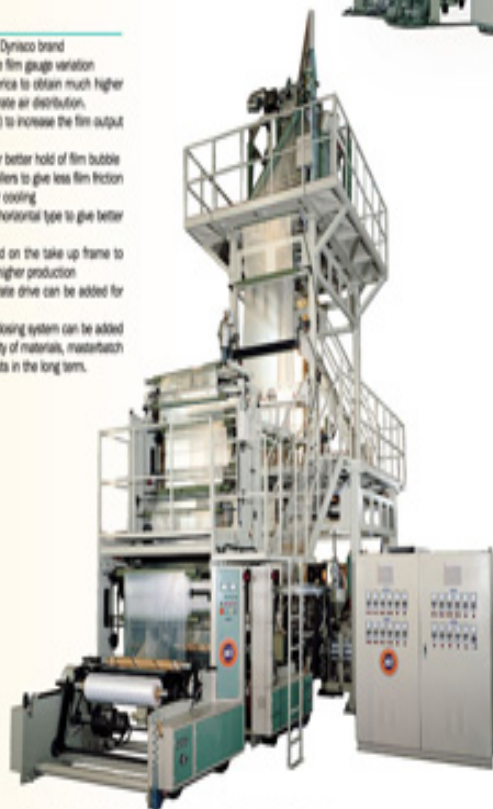
- Main drive with dc motor or ac vector inverter
- Gear box with SKF thrust bearing and oil cooler and oil pump
- Swing type screen changer
- Die carriage
- Stabilizer for HDPE processing
- Bubble cage with motor adjusting height and diameter for LDPE processing
- PLC control system for winder
- Winder with auto film cut and change over
- Winder with air shaft
- Screw rpm meter, line speed meter and auto counter
- Auto loader with magnetic separator

Optional Device:

- Melt pressure and thermo gauge, Dynisco brand
- Rotary die head for distributing the film gauge variation
- Air ring imported from North America to obtain much higher film quality by its stable and accurate air distribution.
- Internal bubble cooling device (IBC) to increase the film output rate as well as better film quality
- Bubble cage of heavy duty type for better hold of film bubble
- Collapsing frame with aluminum rollers to give less film friction and higher heat transfer for better cooling
- Oscillating tower of vertical type or horizontal type to give better film gauge distribution
- Heat setting sealer can be added on the take up frame to obtain multi film tubes in line for higher production
- Embossing roller units with separate drive can be added for HDPE film processing
- 3 or 4 components of gravimetric dosing system can be added to control precisely the right quantity of materials, masterbatch and additives to save material costs in the long term.



Model FK/BFS-55/65/55-1400HR



Model FK/BFS-55/65/55-1400VR



Model FK/BFS-65-1300HR



Model FK/BFS-70-2200TS

MONO LAYER MULTI LAYER CO-EXTRUSION BLOWN FILM LINE >>> BFS series

SPECIFICATIONS:

MODEL			BFS-45-600	BFS-55-1000	BFS-55-1300	BFS-65-1600	BFS-70-2000	BFS-70-2300	型號
Applicable Resin			HDPE, LDPE, LLDPE						適用原料
Film width	HDPE	mm	350-500	600-900	800-1200	950-1500	1200-1900	1400-2200	產品寬度(HDPE)
	LDPE	mm	250-500	500-900	700-1200	1000-1500	1200-1900	1500-2200	產品寬度(LDPE)
	LLDPE	mm	250-500	500-900	700-1200	1000-1500	1200-1900	1500-2200	產品寬度(LLDPE)
Film thickness		mm	HDPE: 0.01-0.02 / LDPE: 0.025-0.1 / LLDPE: 0.02-0.1						產品厚度
Extrusion Output (Max.)	HDPE	kg/hr	60	90	110	130	150	180	押出量 (最大)
	LDPE	kg/hr	75	100	120	140	170	200	
	LLDPE	kg/hr	60	90	110	130	150	180	
Extruder			With Grooved Feeder						押出機
Screw diameter		mm	45	55	55	65	70	70	螺桿直徑
Screw length		L/D	28:1				30:1		螺桿長徑比
Barrel cooling		hpxset	1/4 x 4	1/4x3+1/2x1	1/4x3+1/2x1	1/4x3+1/2x1	1/4x3+1/2x1	1/4x3+1/2x1	套筒冷卻
Temperature control		zone	4						溫度控制
Main drive		hp	40	50	50	60	75	100	主傳動馬力
Extruding Die									押出模頭
Die Diameter	HDPE	mm	60 / 75	100 / 125	125 / 150	150 / 200	200 / 250	225 / 275	模頭尺寸
	LDPE/LLDPE	mm	100 / 125	150 / 225	250 / 300	300 / 350	400 / 450	500 / 550	
Bubble cooling		hp	3	5	7.5	7.5	10	10	膠管冷卻
Temperature control		zone	2	2	2	3	3	3	溫度控制
Take-up Unit			Height Adjustable for HDPE; Fixed height for LDPE / LLDPE						引取裝置
Main pinch roller		mm	Ø160	Ø215	Ø215	Ø215	Ø215	Ø215	主引取輪組
Drive motor		hp	1	2	2	3	3	3	傳動馬達
Line speed		m/min	10-120	20-120	20-120	20-100	20-80	20-80	引取線速度
Tower Height	HDPE	mm	4000	5000	6000	6300	7000	8000	引取高度(HDPE)
	LDPE/LLDPE	mm	4500	6300	7000	7500	9000	10500	引取高度(LDPE)
Oscillating tower height		mm	2000						旋轉台高度
Winder			Auto Surface Friction Type / Single Station or Double Station						捲取裝置
Winder roller		mm	Ø300						捲取輪
Winding motor		hp	1	2	2	3	3	2	捲取馬力
Winding speed		m/min	120	100	100	80	60	60	捲取速度
Winding diameter		mm	900	900	900	700	700	700	捲取直徑
Paper core diameter			I.D.:75 m / O.D.:90 mm						紙管尺寸
Machine Dimension		M	5.5 x 3.5 x 4.5	7 x 3.7 x 6.3	7 x 4 x 7	7 x 4.3 x 7.5	8.5 x 4.7 x 9	8.5 x 5 x 10.5	機械尺寸
Total/Average Power Consumption		kw	34 / 24	55 / 33	55 / 38	65 / 38	95 / 45	125 / 66	總/平均耗電量

• All specifications, design and characteristics shown above are subject to change without prior notice.

SPECIFICATIONS:		Co-Extrusion/Double Layer		Co-Extrusion/Three Layer				
MODEL	Unit	BFS-55/55-1400DS	BFS-65/65-1800DS	BFS-55/55/55-1400TS	BFS-55/65/55-1600TS	BFS-55/70/55-1800TS	BFS-65/70/65-2200TS	型號
Applicable Resin		MLLDPE/LDPE+LLDPE or HDPE/LDPE+LLDPE		MLLDPE+LLDPE / LDPE / LLDPE+MLLDPE				適用原料
Film width	mm	800-1200	1000-1600	600-1200	800-1400	1000-1600	1200-2000	產品寬度
Film thickness	mm	0.008-0.2						產品厚度
Extrusion Output	kg/hr	80-120	100-150	80-200	180-250 with IBC	250-300 with IBC	200-400 with IBC	押出量
Extruder		With Grooved Feeder						押出機
Screw diameter	mm	55 x 2	65 x 2	55 / 55 / 55	55 / 65 / 55	55 / 70 / 55	65 / 70 / 65	螺桿直徑
Screw length	L/D	28:1				30:1		螺桿長徑比
Barrel cooling		1/4hpx4sets, 1/2hpx1set						套筒冷卻
Temperature control	zone	4 zones for each extruder						溫度控制
Main drive	hp	50 / 50	60 / 60	50 / 50 / 50	50 / 60 / 50	50 / 100 / 50	60 / 100 / 60	主傳動馬力
Extruding Die		With IBC or Without IBC						押出模頭
Die Diameter	mm	250 or 300	300 or 350	200 or 300	250 or 350	300 or 400	400 or 500	模嘴尺寸
Bubble cooling	hp	7.5	10	10	15	20	20	膠管冷卻
Temperature control	zone	4	4	4	4	4	4	溫度控制
Take-up Unit		With Oscillating Tower, Vertical or Horizontal System						引取裝置
Main pinch roller	mm	Ø160	Ø215	Ø215	Ø215	Ø215	Ø215	主引取輪組
Drive motor	hp	2	3	2	3	3	3	傳動馬達
Tower Height	mm	7000	9000	7000	9000	9000	10000	引取高度
Oscillating tower height	mm	2000						旋轉台高度
Winder		Auto Surface Friction Type/Single Station or Double Station						捲取裝置
Winder roller	mm	Ø300						捲取輪
Winder motor	hp	3	3	3	3	3	3	捲取馬力
Winder speed	m/min	80	60	80	80	80	60	捲取速度
Winder diameter	mm	700	700	700	700	700	700	捲取直徑
Paper core diameter		I.D.:75 m / O.D.:90 mm						紙管尺寸
Machine Dimension	n	10 x 5 x 8.5	12.3 x 5.6 x 11	11 x 7 x 9	11.2 x 7.4 x 11.2	11.2 x 7.4 x 11.2	21 x 8 x 12.7	機械尺寸
Total/Average Power Consumption	kw	168 / 110	200 / 140	260 / 165	272 / 175	302 / 200	367 / 230	總/平均耗電量

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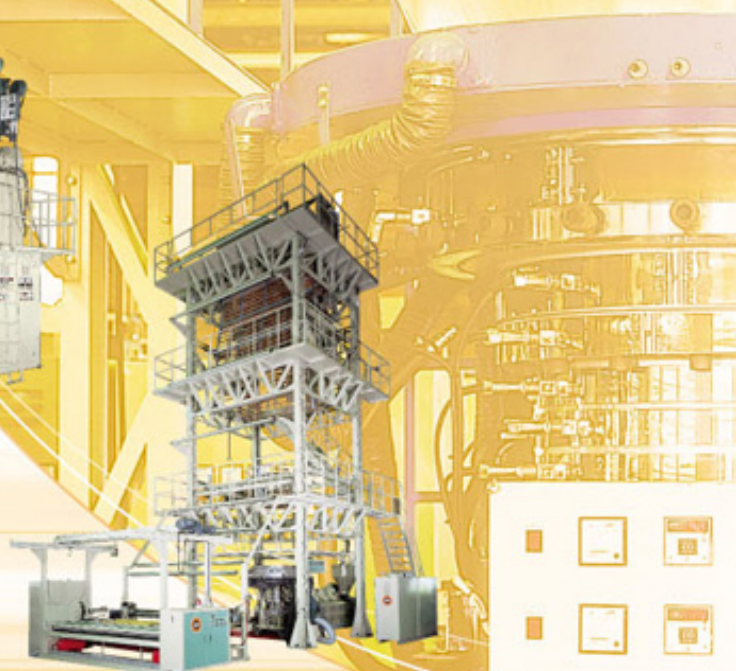
Model FK/HD-45-MH



Model FK/BFM-55-800



Model FK/PP-55-G



Model FK/AFS-125-3250



An ISO 9001-2008 Company

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