

Automatic powder coating line including Pretreatment, dry-off oven, cure oven and conveyor

Efficient automatic powder coating line in good condition, designed for industrial surface treatment of metal components, aluminum and steel. The treated surface is calculated at 840 m²/hour. The components to be painted are hung on an overhead conveyor system and are routed through the different treatment steps of the plant. Part opening: Height 1800 mm, width 1000 mm, max product length 5000 mm (see layout page 3).

The Accustrip 2007 plant that is for sale contains the following main components:

- 1) 2-step washing/degreasing
- 2) Dry-off oven—heated by propane gas
- 3) Cure oven—heated by propane gas

Pretreatment—washing/degreasing

The heating of vessel 1 occurs with a flue gas heat exchanger with a power of 350 kW. The flue gases are released above the ceiling, 255 Nm³/h at a temperature of approx. 200 ° C.

Emissions A1.

Extraction from tunnel:

Extraction fan: Input 1 X XX m³/h at 40 ° C

Conveyor slot 1 X XXX m³/h at 40 ° C

Total emissions from A2 11300 Nm³ / h. Dim. Ø 630 mm V = 10.2 m/s. Discharge air contains indoor air and water vapor.

The water supply takes place according to the following principle: After rinse step 2, there is a cascade rinse mounted which in principle, supplies the whole plant. It is adjusted on the flow meter so that the plant is in balance, ie the water filling valve to step 2 "never" opens. Step 2 is supplied from cascade rinse and stage 1 is supplied via transport pump from step 2. Consumption is between 6-800 l/h.

Dry-off oven

After pre-treatment, the components are transported through the dry-off oven where the water film is dried at the temperature of 100-150 ° C. The oven power is 250 kW and is heated directly with propane gas.

Extraction from the oven:

Extraction fan 2 x 1250 m³/h at 50 ° C

Oven 1 x 1000 m³ /h at 125 ° C

Extract fan and oven extract run together and blow out over an air to water heat exchanger. In total, the A3 drier releases 3500 Nm³/h. Dim. Ø 400 mm V = 7.7 m/s. The released air consists of indoor air, water vapor and combustion products from propane gas.



Cure oven

After the components have been applied to powder, they are transported into the stove where the powder cures by an air temperature of approx. 180 ° C for 10 minutes.

The oven's power is 250 kW and is heated directly with propane gas.

From the oven is sucked out:

Extraction fan 1 x 2500 m³/h at 60 ° C

Oven 1 x 1500 m³/h at 200 ° C

Extractor fan and oven extractor run together, and blown out over an air to water heat exchanger. Total emissions from woodburning stove A4 4000 Nm³/h. Dim. Ø 400 mm V = 8.8 m/s.

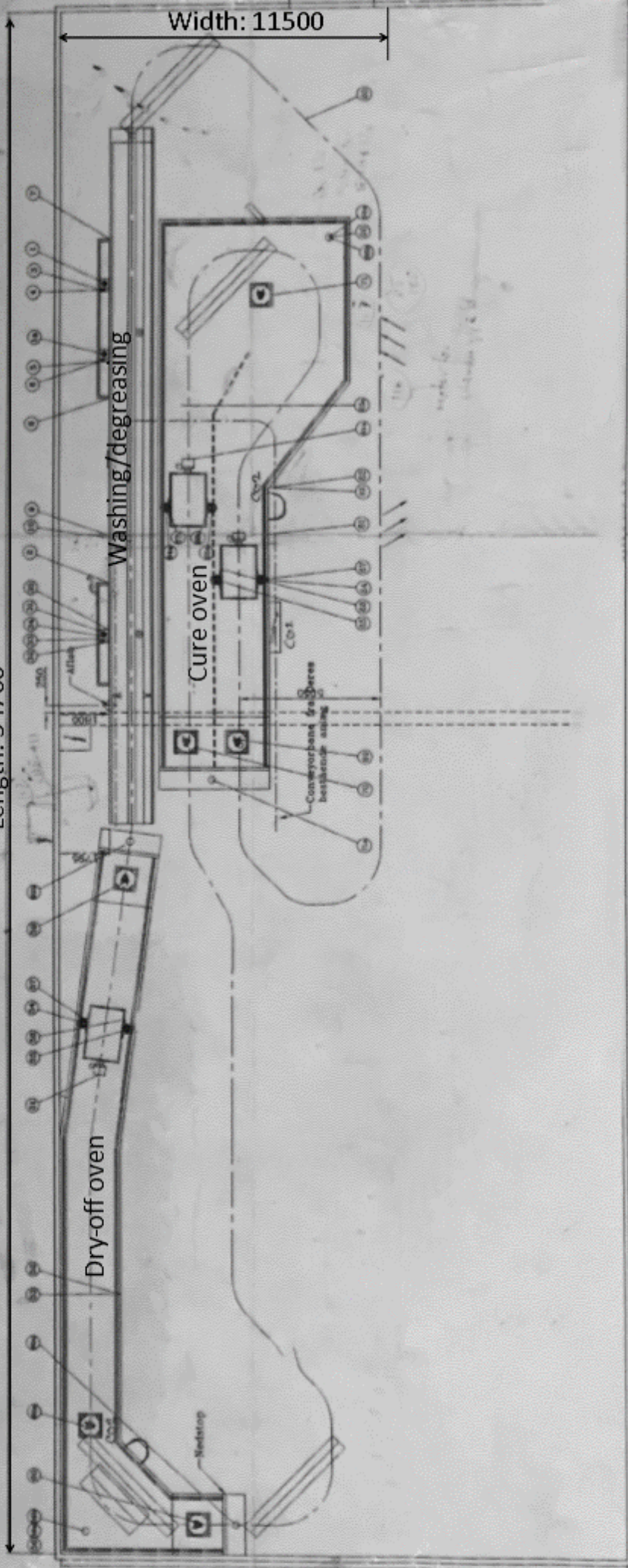
Emission air consists of indoor air, flue gases from the curing process of the powder and N-gas combustion products.

We disclaim responsibility for any typographical errors.



Length: 54700

Width: 11500



NB!
All measurements
in mm.

