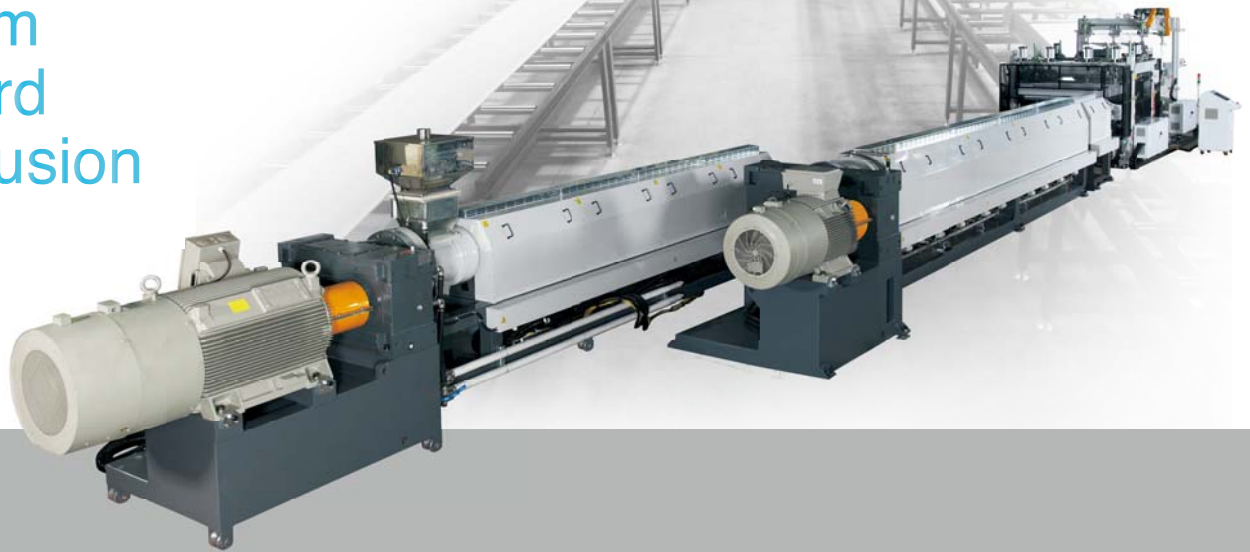




# XPS Foam Board Extrusion Line



## XPS Foam Board Extrusion Line

Sunwell Global offers a range of tandem foam board extrusion lines with complete downstream for XPS production using CO<sub>2</sub> as a blowing agent. With a capacity range from 250kg/hr to 1200kg/hr, we are able to offer board thickness from 20mm to 140mm and widths from 600mm to 1200mm.

Up to 8 raw materials including flame retardant and nucleating agent are automatically loaded and blended before being fed into the primary extruder to produce a homogeneous melt. CO<sub>2</sub>, plasticizer and / or HFC blowing agents are precisely metered using triple head ATEX compliant, diaphragm pumps with mass flow measurement to ensure a consistent foam density and quality.

The secondary extruder cools the melt using a high mixing, low shear screw and the bimetallic Barrel is water cooled with motorized valve control to minimize temperature variation.

A static mixer and homogenizing tube is positioned prior to the chrome plated flat XPS die which has quick opening and fine tune adjustment bolts and Teflon guide shoes.

The board calibrator with temperature controlled calibration plates and haul off are designed to withstand the expansion pressures of CO<sub>2</sub> Board and are fitted with a fail-safe pneumatic quick opening mechanism.

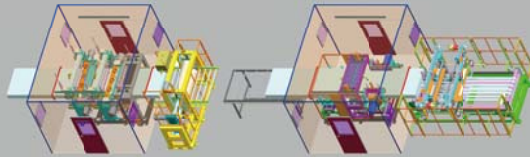
Travel conveyors allow the board to cool before the edges are milled and the board cut to length by our double blade cross cutter capable of handling high line speeds.

The board surface can be planed or grooved to meet market demands and after further cooling, all four edges can be milled again to a flat surface, tongue and groove or shiplap profile.

Sunwell provides fully automatic board stacking and 6 sided product wrapping. Product printing, sound proofing and dust extraction can also be provided.

**PARTNERS FOR  
MAXIMUM PROFITABILITY**

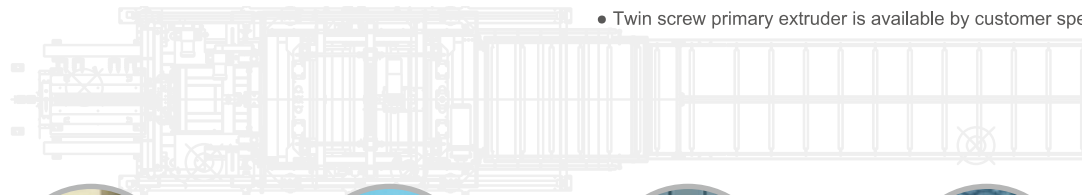
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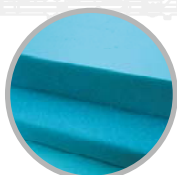
MODEL	FEX120150XPS	FEX150200XPS	FEX180250XPS
Thickness (mm)	20~100	25~160	30~200
Width (mm)	600; 900; 1,200	600; 900; 1,200	600; 900; 1,200
Length (mm)	1,000~3,000	1,000~3,000	1,000~3,000
Throughput (kg/h)	300~500	500~800	800~1,200
Density (kg/M <sup>3</sup> )	28~40	28~40	28~40
Extruder Type	Tandem	Tandem	Tandem
Screw Dia. (mm)	120 and 150	150 and 200	180 and 250
L/D	34/1 and 32/1	34/1 and 32/1	34/1 and 32/1
Blowing Agent	Hydrocarbon, CO <sub>2</sub> , DME, HCFC, HFC	Hydrocarbon, CO <sub>2</sub> , DME, HCFC, HFC	Hydrocarbon, CO <sub>2</sub> , DME, HCFC, HFC
Drive System	SIEMENS AC Drive with FLENDER Gearbox	SIEMENS AC Drive with FLENDER Gearbox	SIEMENS AC Drive with FLENDER Gearbox
Barrel Material	Bimetallic	Bimetallic	Bimetallic
Cooling System	Air Cool for Primary Proportional Motorized Water Cool for Secondary	Air Cool for Primary Proportional Motorized Water Cool for Secondary	Air Cool for Primary Proportional Motorized Water Cool for Secondary
Edge Profile	Ship Lap, Tongue and Groove	Ship Lap, Tongue and Groove	Ship Lap, Tongue and Groove
Surface Formation	Groove, Plane, Emboss	Groove, Plane, Emboss	Groove, Plane, Emboss
Floor Space (M)	80L x 15W x 6H	100L x 15W x 8H	120L x 20W x 8H



• Twin screw primary extruder is available by customer specified



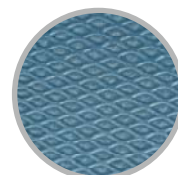
Tongue and Groove



Edge Shiplap



Surface Plane and Groove



Surface embossed

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