

# **RM BAKERY, LLC**

## **DRY BLEND LINE – RIBBON BLENDER PACKAGING SYSTEM**

AUTOMATIC INGREDIANT TRANSPORT SYSTEM

RIBBON BLENDER

US BUILT CONTROLS

FINISHED GOODS AUTOMATIC TRANSPORT

FINISHED PRODUCT SILO

BAG FILLER

VERTICAL FORM FILL & SEAL

ALSO AVAILABLE

METTLER TOLIDO METAL DETECTOR

EQUIPMENT STILL AND OPERATION – LIVE DEMONSTRATIONS AVAILABLE

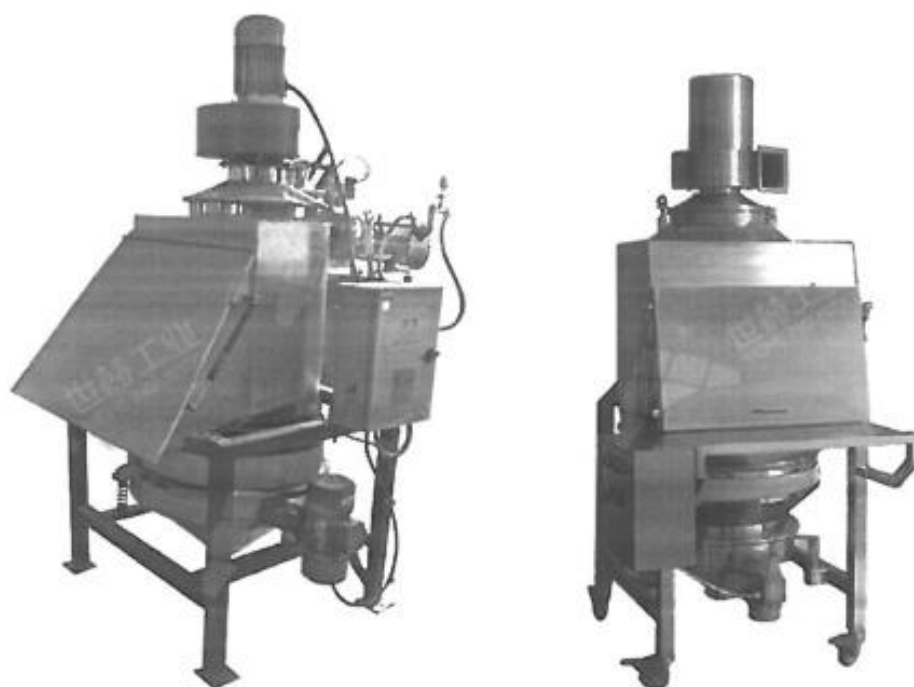






S/N	Name	Performance Parameter
1	Small bag discharging station	<p><b>Technical parameter:</b></p> <p>Power supply: 208V, 60HZ, 3P</p> <p>Bag station design, cone bottom structure, the hose at the bottom connected to ribbon mixer through vacuum receiving hopper.</p> <p>Function: opening bags, sieving, dedusting;</p> <p>The part contacting with medium is SUS304 material (the supporting leg is SS material, without wheels).</p> <p>With vibration sieve, power is 0.18kw, mesh: 60 mesh, coarse filter(impurity);</p> <p>Shelf height 800mm</p> <p>Operation door: 700*1000mm</p> <p>With quick open feeding hopper door(with hydraulic jackstay)</p> <p>With built-in dust-collector system, power is 1.5kw, 0.4um Polyester filter cartridge film, compressor flow is 1650m<sup>3</sup>/H, full pressure: 1260PA;</p>





2	Vacuum feeder	<p><b>Technical parameter:</b>  Power supply: 208V, 60HZ, 3P  7.5kw vortex pump, oil-free and water-free, compressed air consumption (17L / min, gas pressure 0.4-0.6Mpa), gas source should be prepared by buyer;  The vacuum pipes choose clamp type SS304 pipe, convenient for disassembly and cleaning;  With pneumatic material reversing valve ( used for the feeder 1 or feeder 1, switchable)  With stainless steel housing and movable wheels  Throughput (For reference): Limit throughput is 6000kg / h, measured under the condition that the material is rice powder or flour, transport distance is 5 meters (horizontal distance + vertical height). If conveying distance doubled, then throughput will be divided by half. PS, the material fluidity has a significant impact on the throughput.</p>
	Vacuum feeder 2	<p><b>Technical parameter:</b>  Vacuum hopper (Stainless steel SS304, wall thickness 1.5mm)  With built-in polyester film filter (filtering accuracy 0.4um)  With anti-blow device and pneumatic discharge door system</p>



3

**SHLD-3  
Horizontal ribbon  
mixer**

**Technical parameter:**

Power supply: 208V, 60HZ, 3P

Motor: three-phase asynchronous motor, Power: 22KW, SIEMENS/ ABB brand  
Reducer:

- 1, TONGU brand, choose TK series spiral bevel gear reducer
- 2, Model: TK128-2P22-4P-47.82-M4-I-A-CW-G
- 3, the output torque: 6425N.m
- 4, Service Factor: 1.9

Rotation Speed: 0~31rpm, inverter controls various speed, inverter use TIDA brand;

Seal: packing seal (PTFE)+ hermetic seal (double seal, increase the sealing effect)

Mixing chamber: design volume is 3000L, actual mixing volume is 900-2100L;

Thickness of the chamber: 5mm;

Mixing shaft: Mixing shaft and ribbon is 3D design (inner and outer double ribbon design)

Feeding port: vacuum feeling (also with manual feeding port, with grid, can feed material directly)

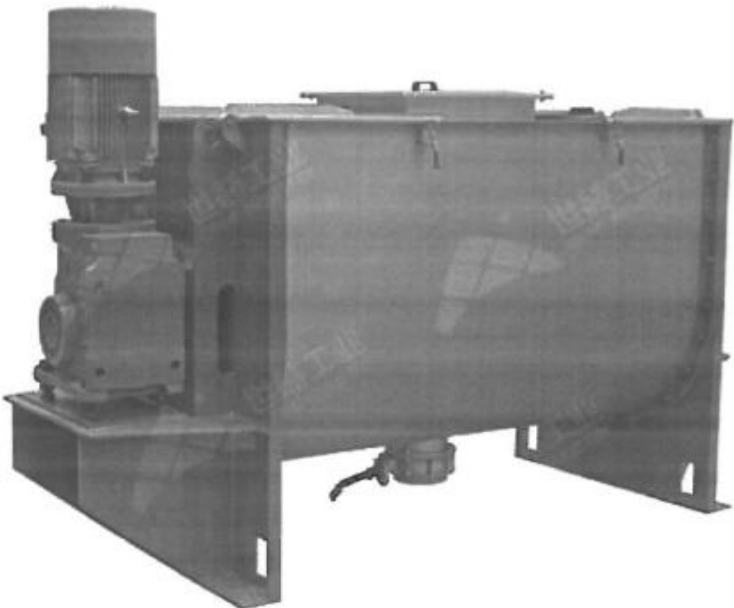
Discharging port: with pneumatic flap valve, no dead end, the material discharging control button is in the electric cabinet.

Equipment Material: media contacting part is 55304 material, inner wall is mirror polished, outer wall is matt mirror, carbon steel part paint blue epoxy coating.

Surface treatment: inner wall, main shaft and ribbon are mirror polished ( $Ra < 0.8$ ), the other stainless steel part ( $Ra < 1.2$ ), the joint part between ribbon and supporting shaft should be welded smooth, to avoid cleaning dead corner;

Cleaning door: The cover of the mixer is like this: the middle part is fixed (with liquid spraying port, a vacuum receiving hopper port and manual feeding port on this part); the other two sides are clamshell design, can open the cover by air cylinder, easy to clean, side of the barrel (the non-feeding side), open a door for cleaning; The cleaning port on the cover and the side cleaning doors are both with protection limit switch, when the switches are open, the machine can not be running;

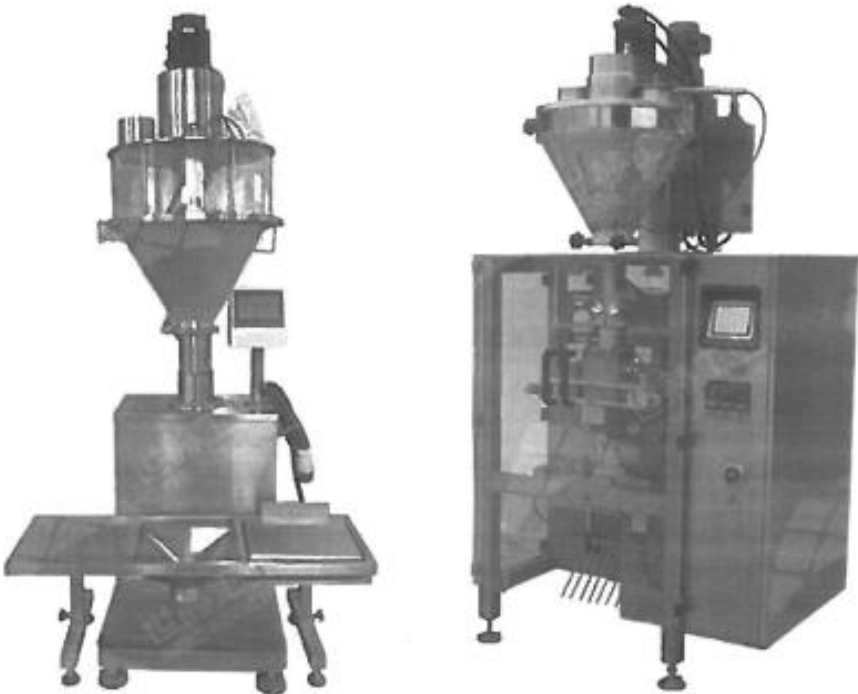
With 10L liquid tank, with quick open charging cover (four sides have screws to lock), with pressure gauge and gas entering port, there are four spraying heads on the mixer and


		<p>combined into an inlet and connected with a liquid outlet, the liquid can be sprayed in 1-3 minutes;</p> <p>With a spare Reducer, TONGLI brand Reducer model: TK128-ZP22-4P-47.82-M4-I-A-CW-G</p>
		
4	Steel structure platform	<p><b>Technical parameter:</b></p> <p><b>Frame for ribbon mixer:</b> The height is 1250mm, material is carbon steel, with reinforcing rib; Detachable structure;</p> <p><b>Feeding and maintenance cleaning platform:</b> Size: 4210*1500*2500mm(L*W*H) The guard bar of one side (1.5m) can be opened, used for forklift to feed material Carbon steel material, laying aluminum plate at the surface of the platform. With stairs and step Feeding platform can be used for temporary manual feeding, also used for equipment clearing and maintenance</p>



5	Finished product silo	<p><b>Technical parameter:</b>            Volume: 2.5m<sup>3</sup>            Equipment material: material contacting part SS304 (supporting legs are carbon steel material)            Equipment cleaning: the silo bottom has side cleaning door, convenient for works to open and clean;            Thickness: 3mm            With pneumatic arch breaking device, to avoid material bridge;  <b>Screw conveyor:</b>            Power supply: 208V, 60HZ, 3P            Power: 2.2kw, with inverter to control the feeding speed (the inverter is TAIDA brand)            Screw conveyor length: about 2000mm            Delivering capacity: 3000kgs/h;            Material: All SS304 material (including bearing/ flange etc, except the standard components)            Discharging: Reversing control, material charged from the middle part, discharged to auto packing machine and semi-auto packing machine;</p>
6	Auto packing machine	<p><b>Technical parameter:</b>            The equipment includes measuring filling head, bag making equipment, bag delivering etc.;            Bag making size: W 90~250mm, L100~350mm            Packing weight : 450-1000g            Packing precision: <math>\pm 0.5-1\%</math>            Packing speed : 25—35bags/min.            Power supply: 208V/60Hz            Power: 4.5Kw            Volume of material silo: 50L, it has a cleaning door;            Packing type: full auto packing type            Servo motor and servo drives adopts TECO brand, touch screen adopts WILLAS brand, PLC is Mitsubishi brand, level gage adopts Autonics brand            With coding function, can print production date/ expiry date/ batch number etc.;</p>



		With belt delivering; With a bundle of film;
	<b>Semi-auto packing machine</b>	<b>Technical parameter:</b> Packing weight : two nozzles, 35-100g and 450-1000g; Packing precision: $\leq \pm 0.3-1\%$ Packing speed : 5—15bags/min. Power supply: 208V/60Hz Power: 1.3Kw Volume of material silo: 50L, it has a cleaning door; Packing type: manually hold the bag packing type (with dust-collector port, can be connected to the central dust collector). Servo motor and servo drives adopts TECO brand, touch screen dopts WILLAS brand, level gage adopts Autonics brand
		
7	<b>Electrical control cabinet</b>	<b>Technical parameter:</b> Facade style electrical control cabinet, carbon steel, electrical components adopt Schneider products;

		
8	Transportation and packing	<p>Deliver to buyer's address</p> <p>Suggest 40ft HQ, it takes 25 days to reach New York (not including customs time)</p>
	Mechanical and electrical installation	<p>Discharging/ lifting/ placing the equipment should be done by buyer.</p> <p>The pipeline of condenser and dust collector should be prepared by buyer.</p> <p>The wire/ bridge and installation of equipment and electrical control cabinet should be done by buyer.</p> <p>If site installation and commissioning is required, then the Buyer shall be responsible for the return ticket fee, local transportation and accommodation fee as well as the allowance for our engineers. (100USD/day/Engineer).</p>
9	Spare parts for Vacuum feeder	<p>1, a polyester film bag (<math>\Phi 75 \times 600</math>) , 18pcs, unit price \$ 30, subtotal: \$ 540</p> <p>2, barrel ring and door ring, 4sets, unit price: \$ 40, subtotal: \$ 160</p> <p>3, circuit boards and switches, 1set, subtotal:\$90</p> <p>TOTAL: US\$790</p>
	Spare parts for Packing machine	<p>1, transverse sealing heat pipes (<math>220V \Phi 10 \times 250</math>), 10pcs, unit price \$ 20, subtotal: \$ 200</p> <p>2, vertical sealing heat pipe (<math>220V \Phi 10 \times 340</math>) , 2pcs, unit price \$ 20, subtotal: \$ 40</p> <p>3, film synchronous belt (<math>T10 \times 56 \times 25</math>), 12pcs, unit price \$ 55; subtotal: \$660</p> <p>4, belt (92XL / 112XL) , 1set, subtotal: \$30</p> <p>5, thermocouple (<math>\Phi 5 \times 50</math>) ,12pcs, unit price \$ 15, subtotal: \$ 180</p> <p>6, the cutter (<math>72 \times 250</math>) ,2pcs, unit priced \$230, subtotal: \$460</p> <p>7, solid state relays (SSR-10DA), 2pcs, unit price \$ 15, subtotal: \$30</p> <p>8, solid state relays (SSR-10DD) ,2pcs, unit price \$ 20, subtotal: \$40</p> <p>TOTAL: US\$1640</p>
	Spare parts for ribbon mixer	<p>1, PTFE packing seal, 10m, subtotal: \$100</p> <p>2. oil seal (Pneumatic seal), 4pcs, unit price \$30, subtotal: \$120</p> <p>TOTAL: US\$220</p>
		<p><b>Technical parameter:</b></p> <p>Power supply: 208V, 60HZ, 3P</p> <p>Motor: three-phase asynchronous motor, power: 3KW; SIEMENS/ ABB brand</p>