

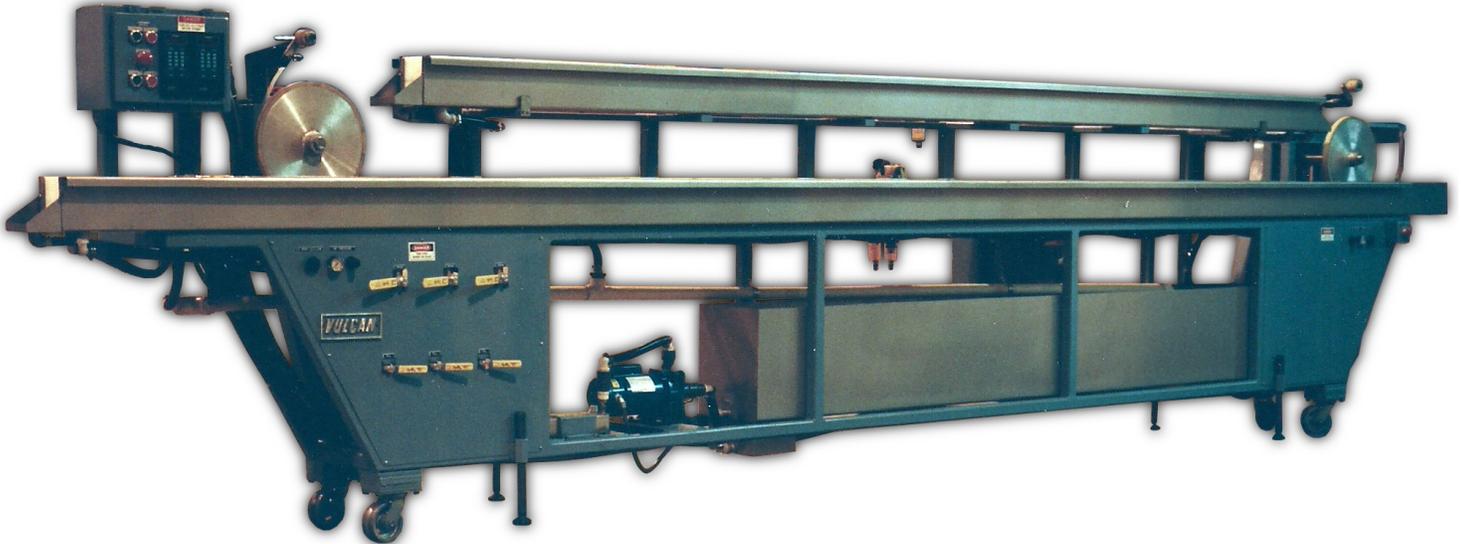


VULCAN MACHINERY CORP.

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Engineering Makes The Difference™

**TRIPLE PASS SIZING/COOLING SYSTEM
CS Series**



Model Number	Triple Pass Tank	Sizing Pulley	Powered Intermediate Pulley	Powered Take-Off Unit
CS60S	X	X		
CS60SI	X	X	X	
CS60ST	X	X		X
CS60STI	X	X	X	X

APPLICATION:

- The Triple Pass Sizing/Cooling System is designed with the sizing unit (puller) inserted upstream from its normal position in the extrusion line such that sufficient elastic recovery time is available after the pulling operation to prevent collapsing or damaging to the extrudate cross-section during subsequent coiling operations. Increasing the elastic recovery time after sizing, and before cutting, is also important in most cut-to-length operations.
- It has a digitally controlled AC servo-driven, low durometer, rubber covered pulley located at the end of the first pass that draws the material out of the die. Another identical pulley is located at the end of the second pass, which can be furnished with or without a servo drive. The triple pass unit is also offered with or without a take-off unit mounted at the end of the third tank to control take-off speed of whatever unit that is used. The controls on the last two drives are designed to reduce tension in the product and allow for dimensional recovery from the strains produced in drawing the product out of the die and through the line.

PROGRAMMABLE CONTROLS:

- 4.1" LCD touch screen HMI
- Proprietary software driven display
 - Guides operator through set-up and prevents input errors
- Sizing, driven intermediate and take-off pullers
 - Start and stop pushbuttons
 - Emergency stop pushbutton
 - Nip open and nip close (for take-off puller only)
- Sizing puller – start, stop, and emergency stop
- Manual counter override with counter reset
 - Pushbutton for reset after package

TANK:

- Tank lengths
 - First pass – 21'
 - Second pass – 15'
 - Third pass – 21' (includes 2' air wipe section)
- Tank cross sectional dimensions – 6" x 6"
- Tank is built from 12 gauge, 304 stainless steel
- Centerline height adjustment – 40" to 44"
- Four UHMW hold down rollers provided for each tank section
- Water height control managed by separate adjustable overflows in each tank piped to drain manifold
- Drip trays located at each end of the tanks; air wipe compartment drain and tank drains are all piped to common drain manifold
- Supply water manifold with valved lines to each tank

DRIVE TRAIN:

- Drive Motor are class H, low inertia, brushless AC servo motors

FRAME:

- Heavy wall tubing, steel plate and structural sections
- Two rigid and two swivel casters and hold-downs
- Screw type floor jacks
- 16 gauge expandable guards
- Fully guarded drive train and electrical components

ELECTRICAL:

- Standard Electrical is 230 Volt/3 Phase/60 Hertz
 - Electrical other than the above is available as an option



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