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TYRE RETREADING PLANT FOR TYRES UP TO 35"

A) PRODUCTION EQUIPMENT

- Position 1) Inspection Machine*
- Position 2) Robot skiving machine*
- Position 3) Sherographic machine*
- Position 4) Peeling, Buffing and Grooving Machine*
- Position 5) Cyclone and Dust Collector*
- Position 6) Cementing Machine*
- Position 7) Extruder Builder Machine*
- Position 8) Autoclave*
- Position 9) Finishing and Painting Tyre Stand + Airless Tank*
- Position 10) Kit of Production Tools and Accessories*
- Position 11) Suggested Spare Parts*

B) ANCILLARY EQUIPMENT

- Position 12) Steam Boiler*
- Position 13) Air Compressors*
- Position 14) Air Tanks (2000 Lt)*



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A) PRODUCTION EQUIPMENT

Position 1) Inspection Machine

MGT tyre stand Hercules Mini35 Hyd, for tyres up to 35"



This tyre stand is used for internal and external spot repairs.

The machine can lift the tyre up to the required height and allow easy inside and outside operations.

It is equipped with tyre rotation controlled by a foot pedal, the tyre speed is controlled by inverter.

It's designed for tyres up to 35" bead diameter.

Total installed power 3 KW



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Position 2) Robot skiving machine

REN35 OTR Robot anthropomorphic (6 Axis) Skiving / Grooving machine for tyres from 24" to 35" with following features:

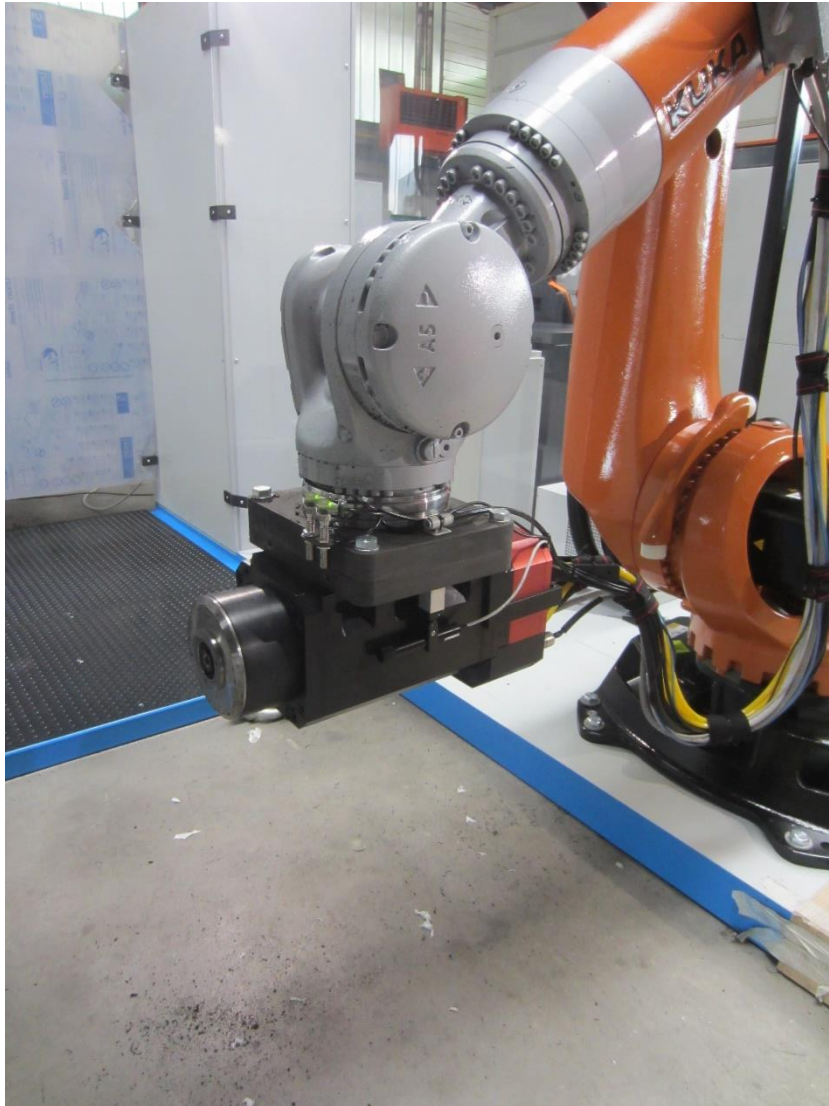




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- Reinforced frame for tire sealing;
- Robot anthropomorphic with "High Speed" tools driving motor with 18 KW installed power, water cooled and complete with water chiller;
- N°4 types of programs for skiving installed on board robots;
- Braking system for tire locking during skiving and grooving operation;
- Covered tool holding rack with 11 positions;
- Safety fences;
- Electric box with air conditioning device and with components and cables UL Listed;
- Electric installation following LME and ANSI robotic standards;
- Safety Certification as per LME rules;
- Use and maintenance manual in English language;
- 3 working conical tools 32/50/80 mm diameter
- 500 inserts for each tool (total 1500 inserts);
- Set of metric wrenches;
- Sets of bead plates 25"-29"-33"-35";



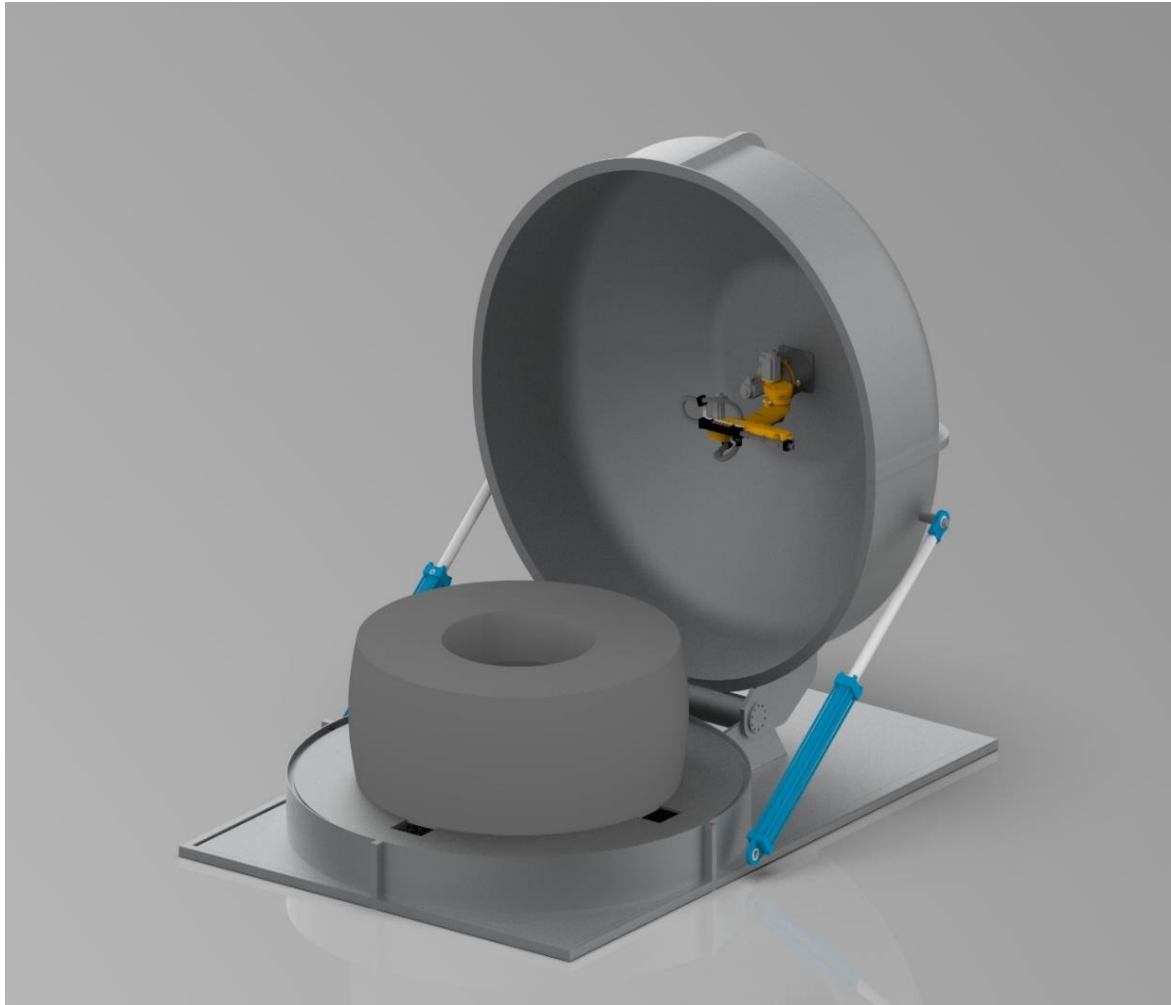
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Position 3) Sherographic machine

SE1-B Sherographic machine for tyres from 24" to 35" with following features:

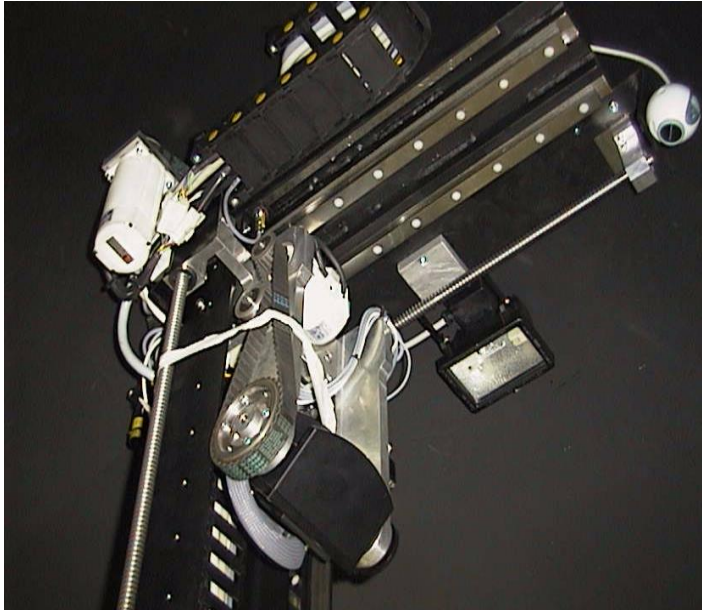




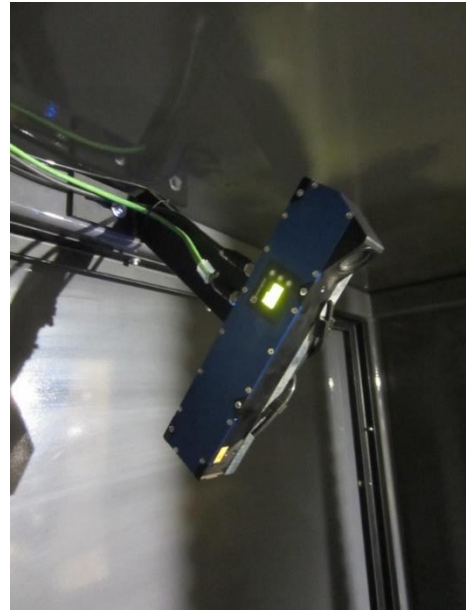
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Old version axis system



New special camera 3D



Anthropomorphic robot handling 3D sensor

- High-strength special steel construction;
- Machine mounted on special anti-vibration systems;
- Hydraulic cylinders for opening the machine cover;
- Robotic system for handling the control sensors;
- High precision 3D laser sensor;
- Large capacity vacuum pump;
- 19" touch screen panel PC;
- Three editable password levels (operator, maintenance, service);
- Possibility to change the size of the minimum test section to be processed;



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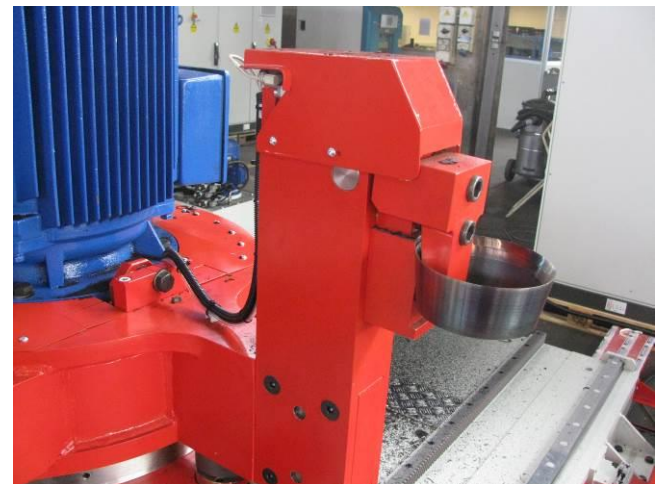
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- Security for access to hazardous areas with protective nets and safety barriers;
- User-friendly graphic interface and machine operating software;

Position 4) Peeling / Buffing and Grooving Machine

MGT One 35" OTR Cnc Controlled (5 Axis) Peeling / Buffing / Grooving machine for tyres from 24" up to 35" with following features:

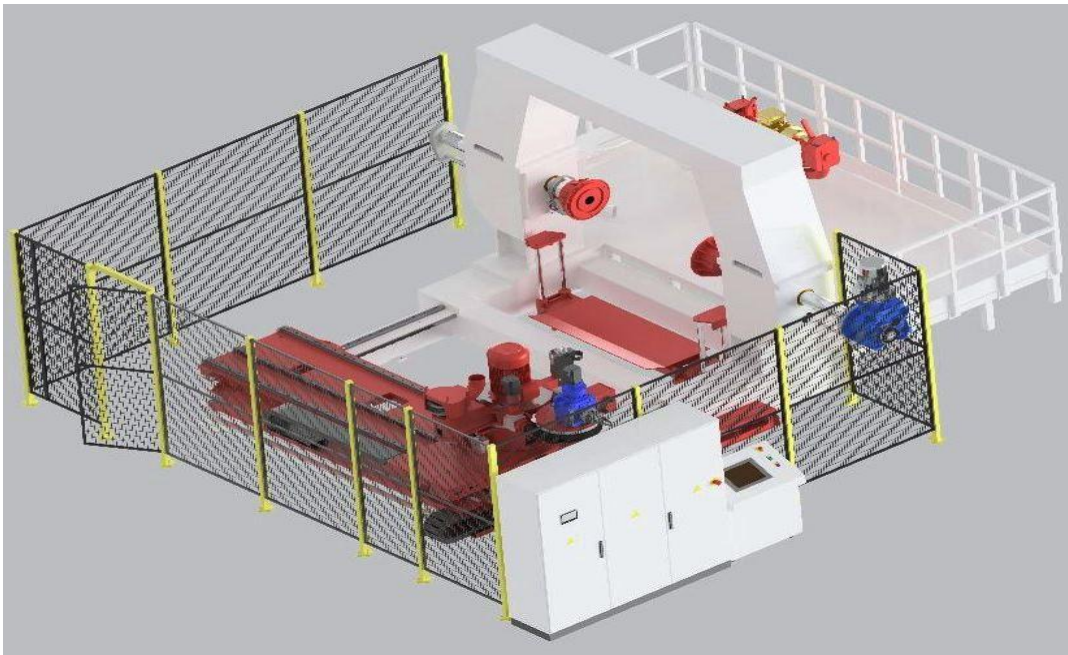




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- Reinforced exclusive tyre holding frame, design for easy loading / unloading of the tyre by overhead crane or forklift (not offered)
- High resistance linear ball bearings and trolleys
- Sumitomo gear boxes
- Tyre holding group with bead plates (low pressure inflation), tyre driving by brushless motor
The bead plates are moved by hydraulic cylinders
- Hydraulic tyre lifting device to load / unload the tyre, on floor level
- Exclusive 3 tooling frame (3 positions Peeling/Buffering/Grooving)
- 5 inches peeling gauge



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- Rockwell Allen Bradley Control Logix Plc and Kinetic 5700 Cnc
- Exclusive Touch Screen PC with Lan Connection, Ethernet Connection and USB Port for NetCam Connection
- Manual buffing arm
- Software developed on Rockwell Allen Bradley ladder language
- Total installed power 65,6 KW

Sets of bead plates:

- 25" steel plates (pair)
- 29" steel plates (pair)
- 33" steel plates (pair)
- 35" steel plates (pair)



Position 5) Cyclone and Dust Collector

Cyclone and Dust Collector



Application

Removal of rubber crumb dust and fume from the equipment listed as per your new factory layout.

Method

We anticipate installing a centralised dust/fume extraction system comprising of a Cyclofilter and exhaust fan set.

A main header transport duct will provide suction to each collection point and remove the dust/fume directly at source, minimising contamination into the work area.

The main extraction plant would be installed external to the factory and the exhausted cleaned air vented to atmosphere via the Cyclofilter.

Each connection to the extraction point would be designed for maximum capture this may require some modification work to existing hoods and machine guards.

The system has been sized from information presented by you and includes maximum air volumes and pressures listed below.



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System volume	12.000 cubic metres/hour.
Motor power	30 Kw
Electrical voltage	400 Volt – 50 Hz

System comprises:

n.1 Cyclo-Filter

The filter is complete with the following:

- Special filter utilising 104 sleeves for 125 square metres of filtration area
- Compressed air clean on demand average usage 30 nmc/hour when required
- 285 x 500 Rotary valve with electric motor of 1,1 Kw
- Access ladder and support structure included
- Main body of 2 mm panel assembly
- Main control panel and automatic filter cleaning module
- Fan assembly complete with 30 Kw electric motor – 2800 rpm
- Spigot inlet and flanged outlet
- Access door and drain socket
- V belts drive and drive guard
- Motor and slide rails
- Firefighting device
- Electric equipment
- Standard paint finish
- Total installed Power 30 KW



Position 6) 6.1 Cementing Machine (cabine + airless tank + tyre stand)

Spray Booth



Technical Specifications

Spray booth to cement the tyre.

We quote for the supply of 5 mt. width x 4 mt. deep x 5 mt. height, spray booth.

The booth on the top is equipped with a split of 300 x 2500 mm. to allow loading and unloading the tyre on tyre stand.

The total air volume handled by the system would be approximately 45.000 m³/hour.

The booth is manufactured from formed galvanised sheet steel in a panel form.

It is complete with all fixing nuts and bolts, suction on the back of booth by two hoppers with two belt drive axial type fan sets.

N.5 rows of Andreae paper filter, n.3 neon lights, electric equipment for fan sets.

Motor power n.2 electric motors of 7,5 kW – 1400 rpm each one

Electrical voltage 400 Volt – 50 Hz



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Position 6) 6.2 Airless Tank (with mixing device) for cementing

Airless Tank



*Ideal for spraying the special adhesive solution, to protect buffed tyre surfaces from oxidation. Guarantees a uniform solution and application of a constant and minimum thickness of mastic.
Complete with a mixer to ensure adhesive solution uniformity.
Operated with air compressed driven pump.
No contact between air compressed and the adhesive solution.*



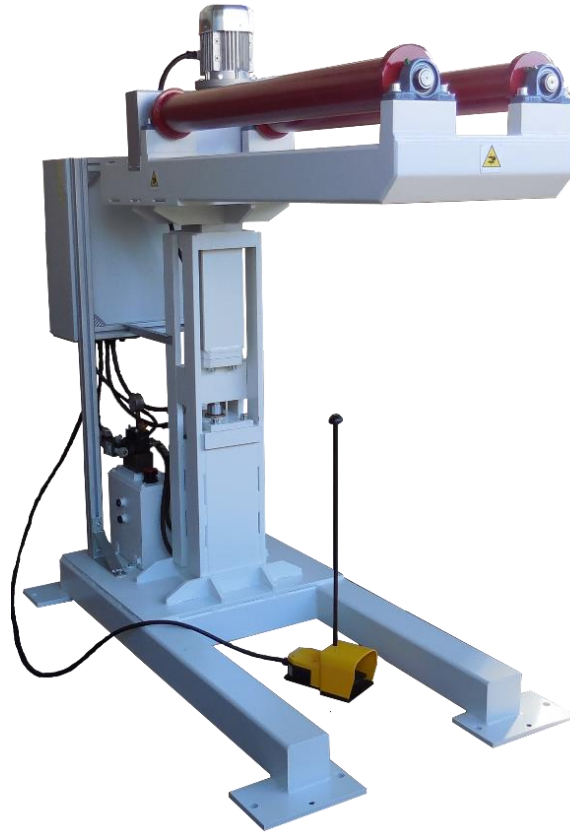
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Position 6) 6.3 Tyre stand for cementing machine

MGT tyre stand Hercules Mini35 Hyd, for tyres up to 35"



This tyre stand is used for internal and external spot repairs.

The machine can lift the tyre up to the required height and allow easy inside and outside operations.

It is equipped with tyre rotation controlled by a foot pedal, the tyre speed is controlled by inverter.

It's designed for tyres up to 35" bead diameter.

Total installed power 3 KW



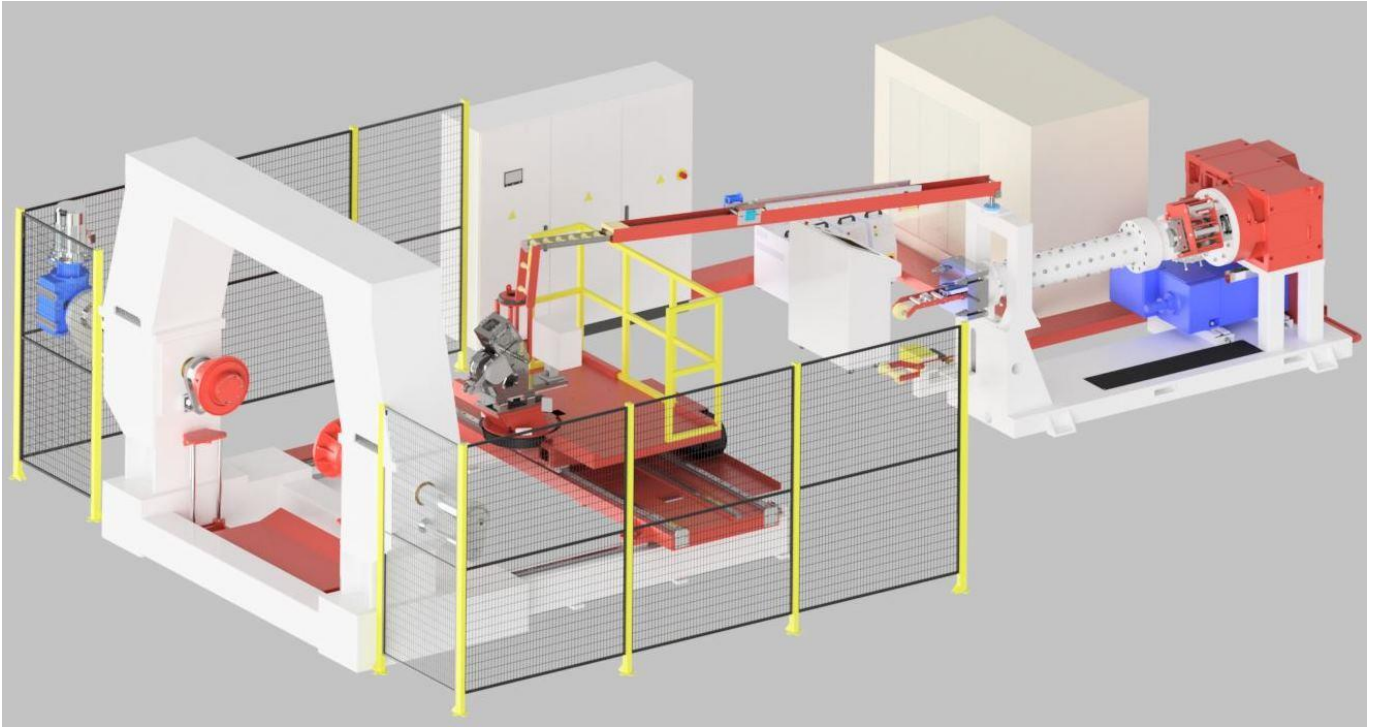
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Position 7) Extruder Builder Machine (with 127 mm Pin Type Cold Feed Extruder)

MGT Optima 35" OTR Cnc Controlled (5 Axis) Extruder builder machine (with 127 mm pin type cold feed extruder) for tires from 24" up to 35" with following features:





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- Optima 5 inches (127 mm) diameter "Cold Feed Pin Type" extruder, with ratio diameter/length 1:16
- DC motor for extruder speed adjustment (135 kw)
- Rockwell Reliance D.C. driver Flexpack 3000
- 4 temperatures control zones (nr.1 screw – nr.2 1ST half barrel – nr.3 2ND half barrel - nr.4 extruder head + calender)
- Reinforced exclusive tyre holding frame, design for easy loading / unloading of the tyre by overhead crane (not offered)
- High resistance linear ball bearings and trolleys
- Tyre holding group with bead plates (low pressure inflation), tyre driving by DC motor (Rockwell Reliance)
The bead plates are moved by hydraulic cylinders
- Exclusive 4 axis strip application unit, with calender rollers and strip supporting device
- Hydraulic tyre lifting device to load / unload the tyre, on floor level
- Rockwell Allen Bradley Control Logix Plc and Kinetic 5700 Cnc and brushless motors, For control axis X , Y , Z, and tyre rotation and calender speed control
- Exclusive Touch Screen PC with Lan Connection, Ethernet Connection and USB Port for NetCam Connection
- Software developed on Rockwell Allen Bradley ladder language
- Water Chiller MTA
- Total installed power 172 KW

Sets of bead plates:

- 25" steel plates (pair)
- 29" steel plates (pair)
- 33" steel plates (pair)
- 35" steel plates (pair)



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Position 8) Autoclave

Autoclave AIM 3.000 x 3.000 mm. with direct steam for tyre vulcanization





Autoclave technical data

Heating system	STEAM	
Fluid	Direct Steam	
Useful internal diameter	3.000	mm
Useful length of the rotative hanging system	3.000	mm
Useful internal length	3.000	mm
Highly Insulating with external protection coat	60	mm
Maximum working pressure	7,8	bar
Working pressure	6	bar
Maximum adjustable working temperature	170	°C
Project rules	VSR / EN 13445	
Structural certification	CE PED 97/23	
Quality certification	UNI EN ISO 9001:2008	
Certification	Any certification on request	
Under flux welding according to rules	VSR-288	
Construction material	P355 NH	
Radiographies covering	10%+100% cross	
Supporting cradles	2	N°
Hydraulic door opening system	YES	
Voltage	400/50/3	V
Body Position	Horizontal	
Control board	PLC Touch Screen	
Data Record	Included	

Autoclave body

It consists of a cylindrical body electro-welded with elliptic bottom at the back end, and movable elliptic bottom at the front.

The body is completed by a series of support saddles suitably dimensioned and suitable to support the autoclave frame, and the load coming from the material to be processed and required service connections.

Autoclave door opening / closure

The closing system is equipped with a sealing gasket with lip profile built in special silicone compound.

The movement of the door opening and closing system as well as the security block will be carried out through an hydraulic system.

The autoclave door is held by a suitable support which allows its perfect closure/opening with minimum overall sizes. The opening on the left or on the right side will be finalized when placing the order. The safety block, designed by Italmatic, will assure the max. safety in time.



Thermal Insulation

The outside of the autoclave will be coated by a suitable thermal insulation. Its thickness guarantees that the temperature of the external side of the autoclave is into the requested limits by the current rules, with exception of the thermal points.

The external thermal insulation will be protected by zinc-steel, particularly fixed to allow a free dilatation of the covering elements.

Valves and service piping

- Regulation valves
- Closure valves
- Piloting electro valves
- Pressure switch
- Manual exhaust valves
- Disconnection points
- By pass for pressure tests
- Piping
- Manometers
- Thermometers

Power control board

The power section, consisting of standard modular racks of primary producers, contains all of the components needed for the power electric feeding of the different components of the plant.

Inside the boards spare spaces are foreseen, according to the current rules.

When not specified by the Customer, the colour of the control boards is grey.

Control and managing system

The control system by PLC, assuring all the following operations:

- Data recording
- Control of cycle parameters
- Indication of data running



Securities and autoclave controls

Security system regularly approved by the current rules.

Made up of:

- Manual cam for the blocking of the door connected to the pressure warning light valve to control that there is no pressure before the opening of the door
- Pneumatic cylinder which prevent the rotation of the cam which blocks the door with the autoclave under pressure
- Electric device which does not allow to pressurize if the door is not closed
- Manual button to stop the autoclave and abort the cycle in case of emergency
- Over pressure valves (Safety certificated valve)
- Atmospheric pressure switch which allows the door opening
- Analogic manometer and thermometer to visualize the pressure and the temperature inside the autoclave
- Pressure switch at max pressure to unload possible over pressure
- Thermostat at maximum temperature at manual rearmament, to abort the cycle in case of emergency of high temperature in autoclave
- Emergency Stop Push Button

N.1 Final Cooling System with water

N.1 Rotative hanging system (max. weight 6.000 kg), tyre loading by forklift

OPTIONAL

N.1 Carrier for the autoclave

The carrier embedded in front of the autoclave moves hooking the tyre holder from the Autoclave and inserting and withdrawing it (see drawing 4200-1 in the next page)

N.1 Any certification on request

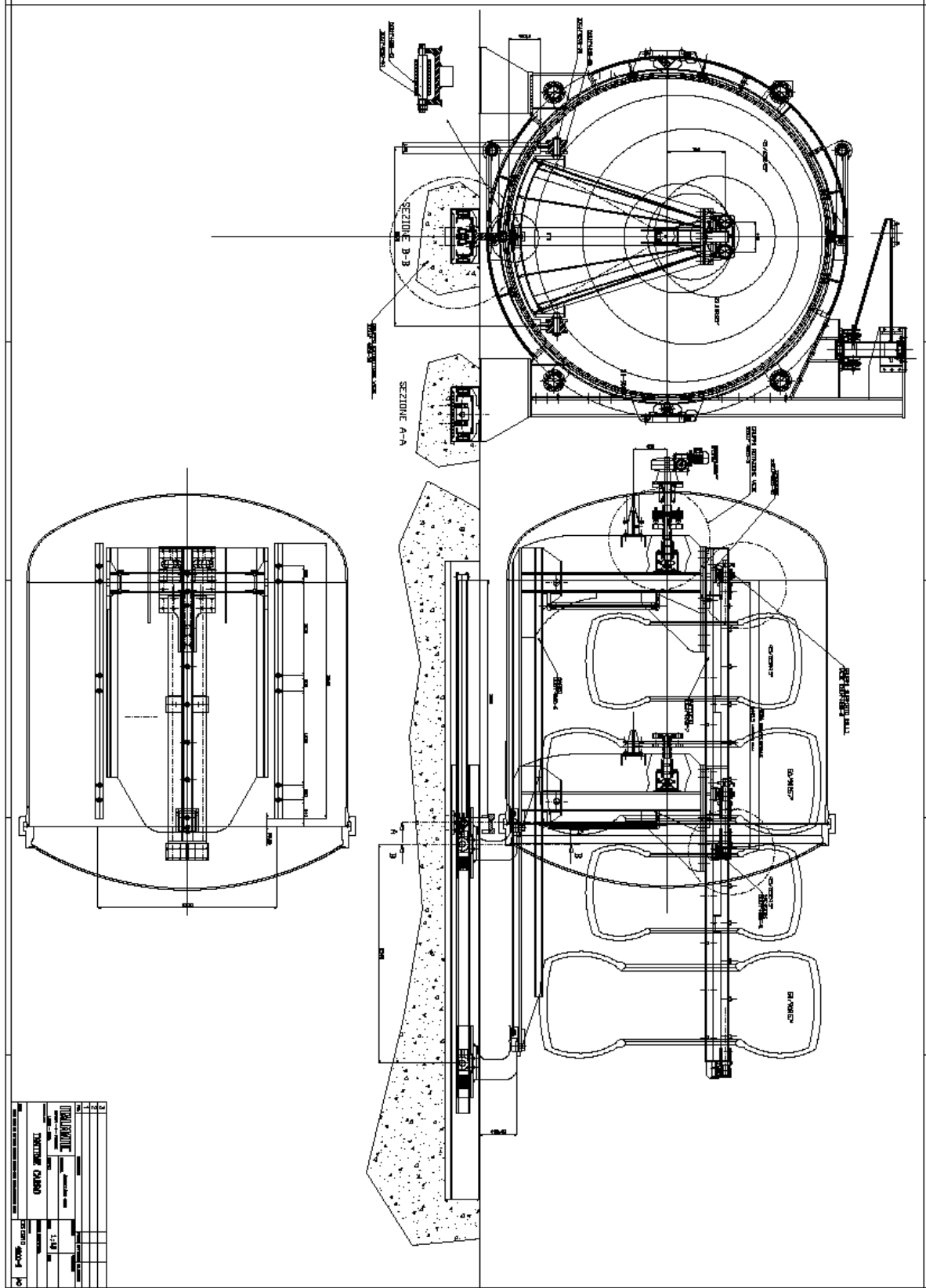


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Carrier for the autoclave





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Position 9) Finishing and painting tyre stand + Airless Tank for painting

MGT tyre stand Hercules Mini35 Hyd, for tyres up to 35"



This tyre stand is used for internal and external spot repairs.

The machine can lift the tyre up to the required height and allow easy inside and outside operations.

It is equipped with tyre rotation controlled by a foot pedal, the tyre speed is controlled by inverter.

It's designed for tyres up to 35" bead diameter.

Total installed power 3 KW

N.1 Airless Tank with Mixer (see position 6.2 for details)



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Position 10) Kit of Production Tools and Accessories

Kits of consumable accessories for the machineries and tyre repairing, see also our accessories catalogue N.23



*Position 10) 10.1 Kit of consumable accessories for One 35"***Kit of consumable accessories for One 35" composed by the following items:**

CODE	QUANTITY	ITEM DESCRIPTION
2110364	n.2	Picking awl with conical nail
2110363	n.2	Steel wire cutting nippers 7 1/2"
2130446	n.2	Decimal meters length 20 mt. - enameled steel
2020029	n.2	Blades sharpener compete with sharpening tool
2140477	n.2	White work gloves in cow soft leather
2140483	n.2	Safety glass with arm
	n.10	Conical peeling cup diam. 130 mm.
	n.1	Set of regrooving blades
2070265	n.3	Brush R10236B Lit Kullen diam.230x60
	n.200	Set of buffing blades
2110351	n.2	Bail cutting knife for rubber

*Position 10) 10.2 Kit of consumable accessories for Optima 35"***Kit of consumable accessories for Optima 35" composed by the following items:**

CODE	QUANTITY	ITEM DESCRIPTION
2130446	n.2	Decimal meters length 20 mt. - enameled steel
2140477	n.2	White work gloves in cow soft leather
2140483	n.2	Safety glass with arm
2130448C	n.1	Ifra-red rays thermometer
2110351	n.2	Bail cutting knife for rubber 12"

*Position 10) 10.3 Kit of patches for internal tyre repairing***Kit of patches for internal tyre repairing composed by the following items:**

CODE	QUANTITY	ITEM DESCRIPTION
3070101	n.1	Box of n. 15 patches for OTR bias tyres 220x220 EM DC4 12-304
3070101B	n.1	Box of n. 10 patches for OTR bias tyres 260x260 EM DC6 12-306
3070101D	n.1	Box of n. 8 patches for OTR bias tyres 325x325 EM DC8 12-308
3070101F	n.1	Box of n. 6 patches for OTR bias tyres 380x380 EM DC10 12-310
3070101	n.1	Box of n. 5 patches for OTR bias tyres 440x440 EM DC12 12-312
3070101M	n.1	Box of n. 5 patches for OTR bias tyres 475x475 EM DC14 12-314
3070101P	n.1	Box of n. 2 patches for OTR bias tyres 535x535 EM DC16 12-316
3070102	n.1	Box of n. 5 patches for OTR radial tyres 155x440 BUL DC46 12-070
3070102B	n.1	Box of n. 5 patches for OTR radial tyres 215x585 BUL DC50 12-071



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3070102D	n.1	Box of n. 5 patches for OTR radial tyres 265x595 BUL DC52 12-072
3070102F	n.1	Box of n. 2 patches for OTR radial tyres 210x750 BUL DC56 12-073
3070102K	n.1	Box of n. 2 patches for OTR radial tyres 210x1005 BUL DC60 12-074
3070103	n.1	Box of n. 5 patches for OTR radial tyres 229X190 BUL DC45 12-069
3070103B	n.1	Box of n. 5 patches for OTR radial tyres 330X254 BUL DC55 12-075
3070103D	n.1	Box of n. 3 patches for OTR radial tyres 405X305 BUL DC65 12-076
3070103F	n.1	Box of n. 3 patches for OTR radial tyres 533X432 BUL DC75 12-077

Position 10) 10.4 Kit of consumable products for cementing and painting

Kit of consumable products for cementing and painting composed by the following items:

CODE	QUANTITY	ITEM DESCRIPTION
2190220	n.6	Tank of spray cement for extruder - 18,9 Lt.
2190251	n.6	Tank of black tyre paint - 18,9 Lt.

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www.italmatic.net*Position 10) 10.5 Kit of consumable accessories for inspection and internal repairing***Kit of consumable accessories for inspection and internal repairing composed by the following items:**

CODE	QUANTITY	ITEM DESCRIPTION
2100331	n.1	Professional pneumatic grinder machine UG 65 EBR
2100343	n.1	Pliers for shaft diam. 6 mm. for grinder UG 65 EBR
2100330	n.1	Professional grinder machine UG 38 NA
2110364	n.2	Picking awl with conical nail
2110363	n.2	Steel wire cutting nippers 7 1/2"
	n.1	Castor-mounted flexible shaft unit type E/2 - Kw 1,1 – 2800 rpm
2040087	n.5	Cup gouge diam. 50 mm.
2050242	n.2	Adaptor diam. 10 mm. H. 60 stem 6 mm.
2050144	n.3	RFBOT diam. 50x10 hole 3/8"x24 UNF
2050240	n.1	Adaptor diam.3/8"x24 UNF H. 47 stem 6 mm.
2050112	n.2	CW diam. 76x32 mm. hole 14 - grit 36
2050113	n.2	CW diam. 102x38 mm. hole 14 - grit 36
2050101	n.2	UW unit wheel diam. 76x25 - grit 36
2050243	n.2	Adaptor diam. M14x2 stem 6 mm.
2130395	n.4	Air quick connector 1/4"
2130396	n.4	Air nipple 1/4"
2130392A	mt.30	Air hose 8x17
2130381	n.1	Blowing gun AZZ
2130421	n.4	Male coupler 1/4" screw spigot 7 mm.
	n.10	Steel hose clamp 14 / 24 mm.
	n.6	Reduction Male / Female
3080020	n.3	Box of white chalks diam. 14 mm. / 12 pcs.
2140477	n.2	White work gloves in cow soft leather
2140483	n.2	Safety glass with arm
	n.1	Decimal meters length mt. 3 - rigid steel strip
2140479	n.20	Dust protecting mask 3M
2190212	n.5	Fiber Bond brush cement 3,8 Lt. 16-349
	n.1	Steel flanges hole 16 mm. (pair)
	n.100	Composable ring brush diam. 100 mm. - wire 0,15
	n.1	Adaptor diam. 16x1,5 mm. x composable brush - Flex E/2
2090320	n.1	Serrated stitchers diam. 40x2,5
2090321	n.1	Serrated stitchers diam. 40x10
2090322	n.1	Serrated stitchers diam. 40x18
2090323	n.1	Serrated stitchers diam. 40x46

*Position 10) 10.6 Kit of consumable accessories for external repairing***Kit of consumable accessories for external repairing composed by the following items:**

CODE	QUANTITY	ITEM DESCRIPTION
2100332	n.1	Professional pneumatic grinder machine URYU UG 1250
2090318	n.1	Convex rasp 75x35
2010003	n.1	Box of steel nails 1,5x12 (1 box = 3000 pieces)
	n.1	Adaptor diam. M12 for 2090318 - UG 1250
2090317	n.1	Spherical rasp diam. 40 mm.
	n.1	Adaptor for 2090317 - Flex E/2
2130381	n.1	Blowing gun AZZ
2130395	n.4	Air quick connector 1/4"
2130396	n.4	Air nipple 1/4"
2130392A	mt.30	Air hose 8x17
2130421	n.4	Male coupler 1/4" screw spigot 7 mm.
	n.10	Steel hose clamp 14 / 24 mm.
	n.6	Reduction Male / Female
3080020	n.3	Box of white chalks diam. 14 mm. / 12 pcs.
2110351	n.2	Bail cutting knife for rubber 12"
2110368	n.1	Knife heater with adjustable thermostat
2050143	n.5	RFBOT diam. 50x10 hole 3/8"x24 UNF - grit 16
2050144	n.5	RFBOT diam. 50x13 hole 3/8"x24 UNF - grit 16
2050145	n.5	RFBOT diam. 50x19 hole 3/8"x24 UNF - grit 16
2050151	n.5	TBOTP diam. 19x50 hole 3/8"x24 UNF - grit 16
2050152	n.5	TBOTP diam. 25x50 hole 3/8"x24 UNF - grit 16
2050153	n.2	TBOTP diam. 19x102 hole 3/8"x24 UNF - grit 16
2050154	n.2	TBOTP diam. 25x102 hole 3/8"x24 UNF - grit 16
2050170	n.5	PR diam. 6x65 stem diam. 6 mm. - grit 16
2050171	n.5	PR diam. 6x102 stem diam. 6 mm. - grit 16
2050172	n.2	PRB diam. 20 stem diam. 6 mm. - grit 16
2050159	n.3	DW diam. 100x19 - grit 16
2050240	n.5	Adaptor diam. 3/8"x24 UNF H.47 stem 6 mm.
	n.1	Adaptor diam. 18 mm. x DW 100x19 for 2100332
		Castor-mounted flexible shaft unit type E/2 - Kw 1,1 – 2800 rpm, see above internal repairing
	n.3	Special steel peeling cup diam. 50 mm.
	n.1	Adaptor diam. 14x1,5 mm. x special peeling cup - Flex E/2
2080290	n.60	Mushroom stone for metallic diam. 30x6 stem 6 mm.
2080291	n.60	Mushroom stone for metallic diam. 30x8 stem 6 mm.
2080289	n.10	Wheel for metallic diam. 127x16 hole 16 mm.
	n.1	Adaptor diam. 16x1,5 with flanges x 2080289 for UG 1250



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2080294	n.5	Cylindrical wheel for metallic diam. 40x30 stem 6 mm.
2080292	n.30	Conical wheel for metallic diam. 20x40 stem 6 mm.
2080306	n.2	Spherical grey wheel - rubber diam. 35 stem 6 mm.
	n.1	Decimal meters length mt. 3 - rigid steel strip
2140477	n.2	White work gloves in cow soft leather
2140483	n.2	Safety glass with arm
2140479	n.20	Dust protecting mask 3M
2110363	n.1	Steel wire cutting nippers 7 1/2"
2110364	n.1	Picking awl with conical nail
2060248	n.1	Portable extruder type EM, rubber production 40 Kg. / H.
2060245	n.1	Portable mini extruder type Ingersoll, rubber production 18 Kg. / H.
2060259	n.3	Roll of rubber for portable extruder (5 Kg.)
2060251	n.1	Balancer with 6-8 Kg.
2060250	n.1	Balancer with 2-4 Kg.
2070271	n.3	Brush diam. 50x15 stem 6 mm.

Position 11) Suggested Spare Parts (for 2 years of good functioning) for:

Position 1) Inspection Machine

Position 2) Robot skiving Machine

Position 3) Sherographic Machine

Position 4) Peeling, Buffing and Grooving Machine

Position 5) Cyclone & Dust Collector

Position 6) Cementing Machine

Position 7) Extruder Builder Machine CNC

Position 8) Autoclaves

Position 9) Finishing & Painting Tyre Stand + Airless Tank

Position 13) Steam Boiler

Position 14) Air Compressor



B) ANCILLARY EQUIPMENT

Position 12) Steam Boiler

N.1 Steam Boiler type 400.000 Kcal/h composed by:

N.1 Steam generator with a production of 600 Kg/H. at a design pressure of 12 Bar with all required accessories

N.1 Water and condensate tank manufactured in carbon steel, completely insulated and with a capacity of 2.000 Lts.

N.1 Chimney of six meters formed by modules. Manufactured in carbon steel

Position 13) Air Compressors

N.2 Air Rotary Screw Compressor



Rotary air compressor with air production of 5.540 Lt/min. (5,54 m³/min.) at 10 Bar, complete with special filter and post air dryer refrigerator.

Installed Power 45 KW each one

Position 14) Air Tank

N.2 Air compressed tank capacity 2000 Lts with max pressure of 11,5 Bar and complete with safety valve, manometer and 2 inches in and out connections.



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Typical layout for tyre retreading plant for tyres up to 35"

