



MV-01B Fully Automatic Winding Machine



Machine structure and configuration

- | | |
|---------------------|-------------------------------|
| 1. Interface | 6. Gasket hanging bar |
| 2. Inner ring robot | 7. Inner ring feeding system |
| 3. Press roller | 8. Graphite feeding system |
| 4. Unloading robot | 9. Steel Strip feeding system |
| 5. Welding robot | 10. Steel Strip bobbin |

Machine main features

1. Deployed with inner ring automatic feeding system, this machine can make both basic type and inner ring type of gasket fully automatically.
2. It can load over 150 pieces of inner rings by one charge, so machine can continuously run about 50 minutes to one hour.
3. Use PLC programmed process control, and servo motor as driver, precisely control the whole winding process.
4. Build with a welding robot, make all welding points reliable and even
5. Deployed an automatic flange width measuring device, make gasket OD very accurate, and you can choose having a strip tail or welding to the end, e.g. without tail of strip.
6. With large memory storage, can save over 500 sets of parameter settings for different sizes and press classes. Each type of gaskets will be given a product code, whenever you want to make it, you only need



- to change the product code, then all parameter settings for this type will be ready to produce, save time from repetitive parameter setting.
7. Build with steel strip automatic feeding and automatic cutting off.
 8. Build with graphite tape automatic feeding and automatic cutting off.
 9. Build in graphite detector, the machine will automatically stop in any cases such as graphite break or run out.
 10. The most controlling electronic components such as PLC, relay are all high quality international brands. This guarantee the machine's reliability and productivity.

Machine specifications

Machine profile	1200*95*1750mm
Power supply	3 phase 380 V
Drive motor	750 W Servo motor
Working mode	Fully automatic
Work range	ASME standard 1/2" to 6"
Standard suitable	Suitable for all standards
Gasket type	Basic type and inner ring type
Cycle time	16 seconds for 3" gasket
Change over time	From 5 to 10 minutes
Process control	PLC programmed automatic control
Welding	Automatic
Gasket ejection	Yes
Parameter setting storage	Memory can save 500 sets of para
Filler break sensor	Yes
Steel former	Yes
Strip feeding and cut off	Automatic
Filler feeding and cut off	Automatic
Flange width measuring	Automatic
Filler control by wraps	Yes
Steel strip spool support	Yes, one charge 15 kg

Machine price 29800 USD, Including one set of ASME 1/2"-6", 150-600 psi accessories, details as below,



MV-01B ASME mandrel price 1/2"-6" 150-600 (USD)								
Item	Size	Type	Class	THK(mm)	Q'ty	Price	Amount	Remarks
1	1/2"	IR	150-2500	4.5	1	80.00	80.00	Complex mandrel
2	3/4"	IR	150-2500	4.5	1	80.00	80.00	Complex mandrel
3	1"	IR	150-2500	4.5	1	80.00	80.00	Complex mandrel
4	1 1/4"	IR	150-600	4.5	1	80.00	80.00	Complex mandrel
5	1 1/2"	IR	150-600	4.5	1	80.00	80.00	Complex mandrel
6	2"	IR	150-600	4.5	1	80.00	80.00	Complex mandrel
7	2 1/2"	IR	150-600	4.5	1	30.00	30.00	3-piece mandrel
8	3"	IR	150-300	4.5	1	30.00	30.00	3-piece mandrel
9		IR	400-2500	4.5	1	30.00	30.00	3-piece mandrel
10	4"	IR	150-300	4.5	1	35.00	35.00	3-piece mandrel
11		IR	400-900	4.5	1	35.00	35.00	3-piece mandrel
12	5"	IR	150-300	4.5	1	35.00	35.00	3-piece mandrel
13	6"	IR	150-300	4.5	1	40.00	40.00	3-piece mandrel
14		IR	400-900	4.5	1	40.00	40.00	3-piece mandrel
15	1/2"	GR	150-2500	4.5	1	70.00	70.00	Complex mandrel
16	3/4"	GR	150-2500	4.5	1	70.00	70.00	Complex mandrel
17	1"	GR	150-2500	4.5	1	70.00	70.00	Complex mandrel
18	1 1/4"	GR	150-600	4.5	1	70.00	70.00	Complex mandrel
19	1 1/2"	GR	150-600	4.5	1	70.00	70.00	Complex mandrel
20	2"	GR	150-600	4.5	1	70.00	70.00	Complex mandrel
21	2 1/2"	GR	150-600	4.5	1	70.00	70.00	Complex mandrel
22	3"	GR	150-600	4.5	1	30.00	30.00	3-piece mandrel
23	4"	GR	150-600	4.5	1	35.00	35.00	3-piece mandrel
24	5"	GR	150-600	4.5	1	40.00	40.00	3-piece mandrel
25	6"	GR	150-600	4.5	1	40.00	40.00	3-piece mandrel
26	1/2"	EJT	150-2500	4.5	1	25.00	25.00	Ejector 1
27	3/4"	EJT	150-2500	4.5	1	25.00	25.00	Ejector 1
28	1"	EJT	150-2500	4.5	1	30.00	30.00	Ejector 1
29	1 1/4"	EJT	150-600	4.5	1	30.00	30.00	Ejector 1
30	1 1/2"	EJT	150-600	4.5	1	35.00	35.00	Ejector 2
31	2"	EJT	150-600	4.5	1	40.00	40.00	Ejector 2
32	2 1/2"	EJT	150-600	4.5	1	40.00	40.00	Ejector 2
33	3"	EJT	150-600	4.5	1	45.00	45.00	Ejector 2
34	4"	EJT	150-600	4.5	1	50.00	50.00	Ejector 2
35	5"	EJT	150-600	4.5	1	55.00	55.00	Ejector 2
36	6"	EJT	150-600	4.5	1	60.00	60.00	Ejector 2
Total					36		1,825.00	

Note

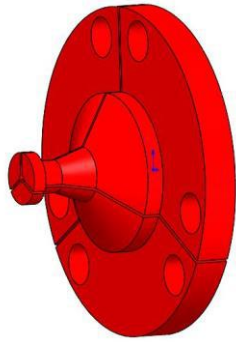
1. Basic type (GR) and inner ring type (IR) of mandrels are different even same size.
2. Same size, different class, the mandrel and ejector price remain same as class 150/300;
3. Ejector (EJT) is only used for making basic type of gasket, so basic type (GR) and Ejector is always together. 1/2" up to 1 1/4" use ejector 1; while the bigger sizes use ejector shape like ejector 2.



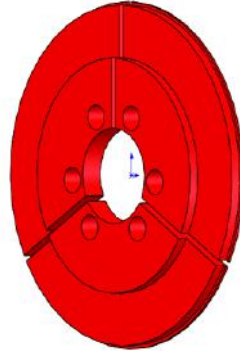
As long as the gasket winding element ID is same, the ejector will be same.

- 4. Different thickness inner ring gasket can share same mandrel if they ID is same;**

Complex mandrel



3-piece mandrel



Ejector

