

Your Extrusion Allies

 **bausano**

PROFILES EXTRUSION



Single-Screw Extruder Series

Our company successfully developed a small profile production extrusion line suitable for the different requirements from clients. This small profile production line is based on single screw extrusion technology. There are many outstanding features of this small profile line, like good plasticizing, high output capacity(kg/h) and low energy consumption.

- Extruder barrel made in nitrided or bimetallic steel
- Extrusion screw nitrided or hard metal coated
- Made in Italy certified reducers
- AC motors in a laminated package, driven by inverter

TECHNICAL DATA

Models		E-GO 45	E-GO 60	E-GO 70	E-GO 75
Screw diameters	(mm)	45	60	70	75
L/D ratios	L/D	25-30	25-30	25-30	25-30
Heating zone	no.	4	4-5	4-5	4-5
Cooling zone	no.	4	4-5	4-5	4-5
Total power	(kW)	25-30	41-50	41-60	57-65

Data contained in this catalogue are purely indicative and may change.



Application

Extruded plastic profiles can be used in a wide variety of applications. Examples of application are the lighting industry and shelf construction, for high-quality displays or many other areas: There aren't any limits on potential application, profile extrusion is highly customizable. With an extrusion line based on a Single Screw Extruder, First-class quality profiles are extruded with precision and surface quality, to create a precise fit and high functionality. Profiles are Extruded and Co-Extruded in Polycarbonate, Acrylic, ABS, PC/ABS and PVC in Clear, Opal, Satin and Colored materials with various surfaces to satisfy the most particular technical needs and requirements of customers.

PLASTIC PROFILES FOR **LIGHTING**

- Technical
- Industrial
- Architectural
- Rail Train and Subway
- Outdoor & Indoor
- Illuminated advertising

PLASTIC PROFILES FOR **LED**

PLASTIC PROFILES FOR **ELECTRONICS**

PLASTIC PROFILES FOR **FURNITURE AND KITCHEN**

PLASTIC PROFILES FOR **AUTOMOTIVE**

- Bus and Trains

PLASTIC PROFILES FOR **BUILDING**

- Partitions Wall Systems
- Glass Wall Partitions

Profile Die Head

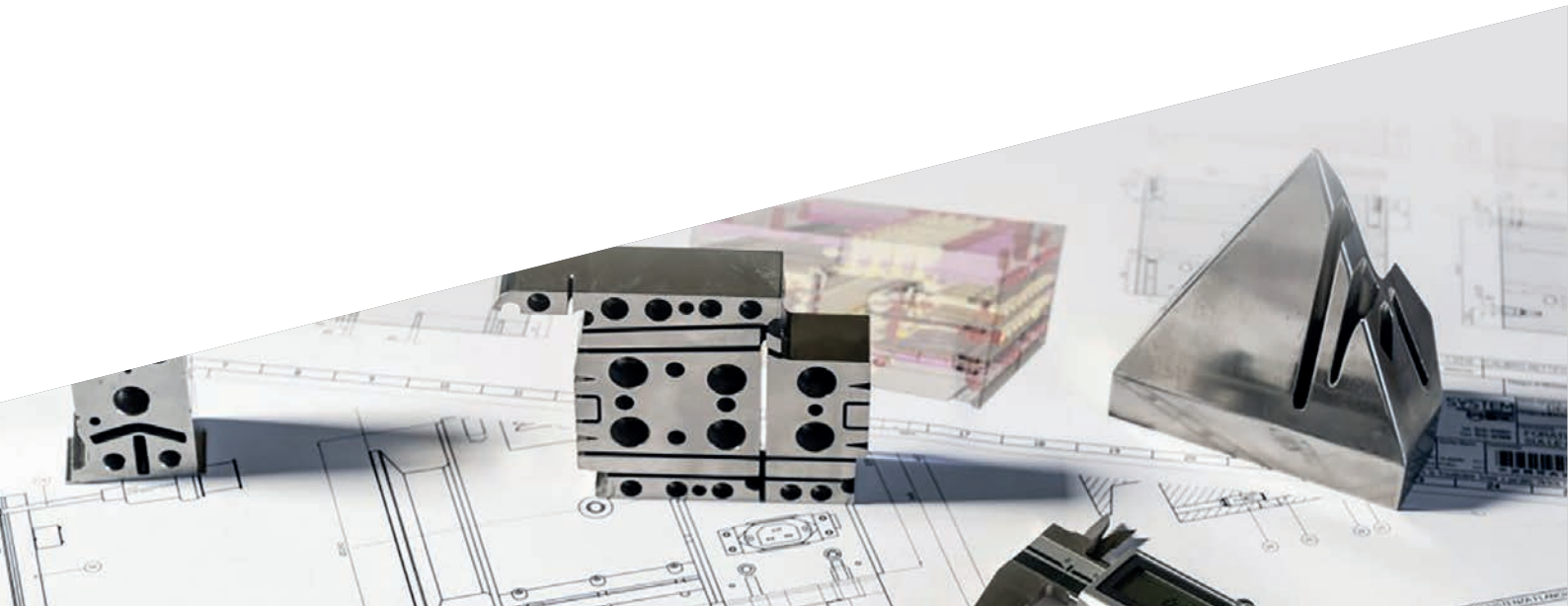
The profile die heads are designed to make extruded shapes along the desired profile and they are associated to a tailor designed cooling system. Bausano relies on well-known partners to deliver the tooling for its complete profile lines.

Our partners can manufacture dies and calibrators for the extrusion of profiles in RIGID PVC, FOAM PVC, COEXTRUDED AND SOFT PVC, ABS, PC, POLYAMIDES PA 6.6. and WPC, typical of the automotive, furnishing and building fields. The equipment is made using stainless steel with high content of chrome, with one or more exits according to the customer's needs.

The planning of the dies and calibrators is carried out starting both from drawings of the profiles supplied by customer and from our drawings studied in close collaboration with customer in the way to respect his exigencies and the production constraints. This preliminary phase is followed by the real planning, that defines the geometry of the tool and the working phases of the raw steel block which the final mould must be obtained from.

Calibration Tool

The calibration toolings are made from stainless steel for better life due to the abrasive nature of filled plastics rubbing over the polished surfaces. The internal surface is cut in the shape of the desired profile and highly polished for low drag resistance. Cooling channels are cut into the tooling for flow of the critically important cooling water. In addition, channels are cut into the tool for vacuum to draw the plastic part out against the calibrator wall to make good contact to ensure cooling and obtaining the proper dimensions.





Cooling Bench

CENTRALIZED CONTROL PANEL

The centralized location of the extrusion line control panel near the die allows for convenient and efficient management of the entire profile extrusion line. There is the option to mount the panel to a swivel boom.

The modular design of Bausano's profile calibration bench ensures accurate and efficient set-up. It is possible to save time changing the profile calibration module with another module which has been preset, switching quickly from one profile to another. For exceptionally wide profiles Bausano offers an auxiliary tank mounted on the calibration table after the initial calibration tooling to offer additional cooling for the profile.

The cyclone unit ensures higher vacuum stability in the tanks, and the improved positioning of the water discharge pump ensures that the extracted water is safely returned to the water circuit. The upstream dirt particle filter protects the water discharge pump from contamination or even failure.

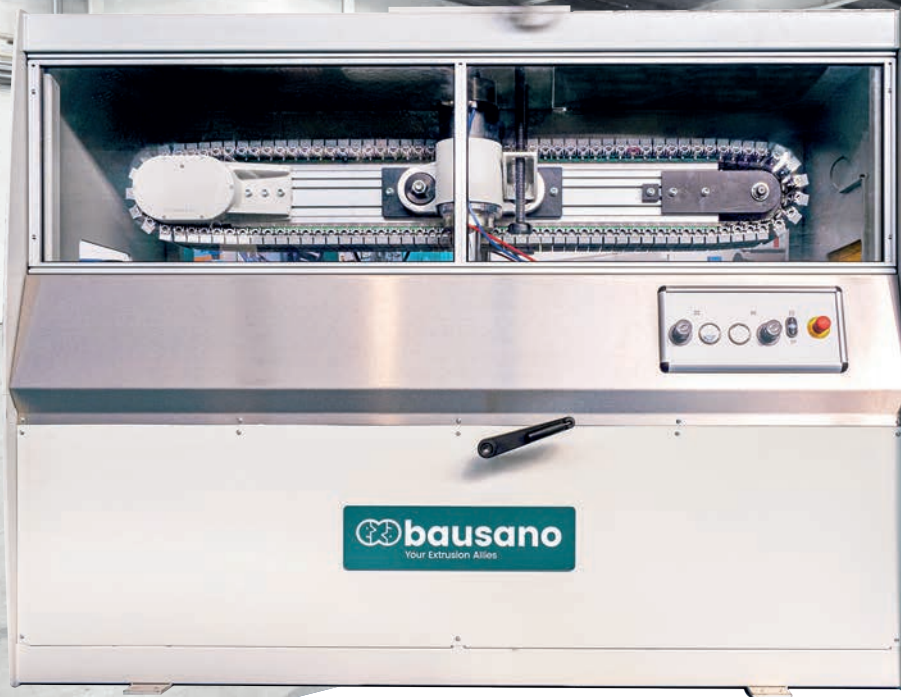
ADVANTAGES:

- Reduces vacuum fluctuations to the technical minimum
- Avoids vacuum shocks, thus preventing profile surface defects
- Possibility of controlling vacuum pumps by means of an inverter

TECHNICAL DATA

	BP3/2P4/ML	BP6/2P4/MB	BP6/2P5.5/MB	BP6/3P7.5/MB	BP10/4P9/MB
Length of calibrator holder beam (mm)	3500	5600	5600	5600	10000
Longitudinal transverse of calibrator holder beam (mm)	1000	1000	1000	1000	1000
Transversal displacement (mm)	40	40	40	40	40
Vertical adjustment (mm)	880-1130	880-1130	880-1130	880-1130	880-1130
Vacuum pump (nxkW)	2x4	2x4	2x5.5	3x7,5	4x9

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Haul-off unit

Bausano's profile take-off units are driven by dual independent epicyclical gear motors with variable frequency inverters for smooth continuous speed adjustment over a wide range.

The upper tilting track is pneumatically actuated with micrometer adjustment; the lower track is equipped with a mechanical vertical adjustment. The traction pads, which are of a sectional design for easy replacement, are easy to adapt to specific profile requirements.

Whether the profile is small or large that requires a lot of power, Bausano's take off units can manage it without leaving marks or deforming the shape.

TECHNICAL DATA

	TNP10-50N	TN 10-70N	TNP15-110ML	TNP20-150MB	TNP20-250MB	TNP80-250MB	TNP120-250MB
Track length (mm)	belt 500	belt 700	1100	1500	2500	2500	2500
Track width (mm)	100	100	150	200	200	800	1200
Max track opening (mm)	70	100	95	160	160	160	160
Hauling speed (m/1')	0,25-120	0,25-120	0,2-10 1-25	0,2-6 0,8-24	0,2-6 0,8-24	0,2-2,7 0,8-10	0,2-2,7 0,8-10
Take off force max (KN)	2,4	7,6/1,5	23	70	70	50-192	50-192

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Caterpillar Haul-off

The Bausano pad haul-offs are characterised by their robustness and versatility. Easy to use, robust, versatile, compact and simple to maintain. The tracks are easily accessible for fast replacement of the cleats:

- Different dowel dimensions guarantee gentle removal of the profiles without influencing the profile geometry or surfaces (cleat marks)
- Special cleats adapted to the profile shape
- Cleat quick-change system
- Both chain carriages are fully accessible at the front for easy pad exchange

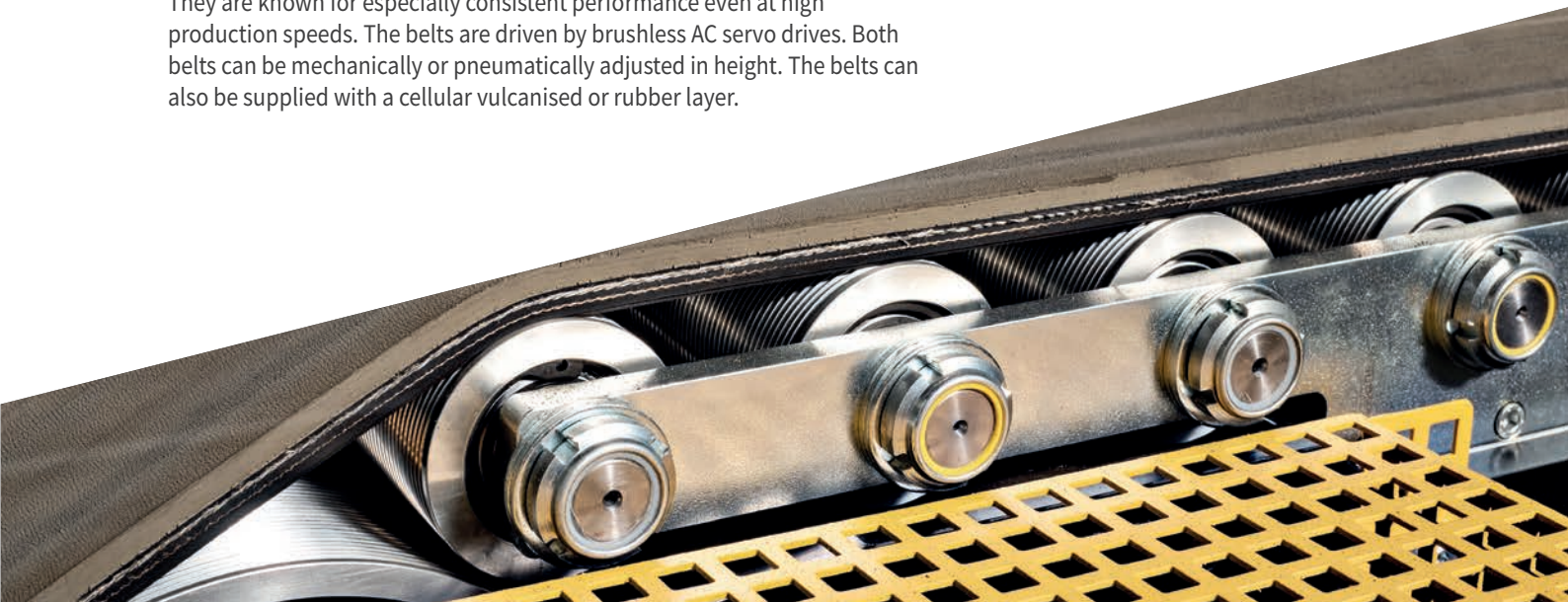
For both versions, we can propose a large range of contact lengths and widths, min. and max. linear speeds as well as haul-off forces with associated torque.

All our chasses are precision-welded in order to guarantee overall stability.

Belt Haul-off

Bausano supplies a wide range of haul-off belts which ensure high resistance to abrasion, excellent grip properties and a precise finishing that guarantee an homogeneous coating, for a perfect adherence to the extruded material.

The Bausano belt haul-offs are used for continuous extrusion of profiles. They are known for especially consistent performance even at high production speeds. The belts are driven by brushless AC servo drives. Both belts can be mechanically or pneumatically adjusted in height. The belts can also be supplied with a cellular vulcanised or rubber layer.





Cutting Unit

KNIFE HEATING SYSTEM OPTION

An alternative to the standard cutter is the knife heating system. Heating the knife blade can improve cut quality for some rigid plastic extrusions. A hot knife can also reduce the number of imperfections of plastic that can form when cutting some products. The blade is heated by heating blocks located on both sides of the knife. The blade stops in this position between the cuts. A thermocouple controls the temperature of the blocks and prevents overheating.

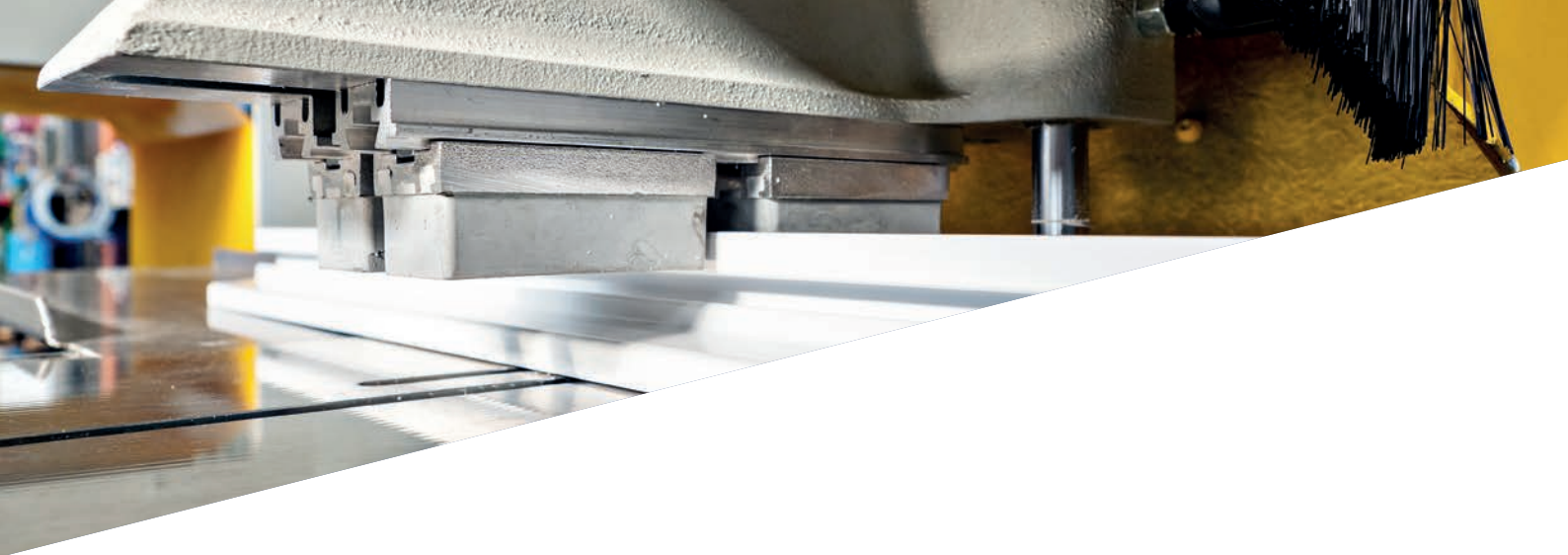
Bausano has carefully engineered the vertical profile cutter to satisfy the most stringent safety requirements without a loss of operational functionality.

All standard production adjustments, cut-off length, feed speed and carriage return are controlled electronically. Bausano offers a special Horizontal Cutter for exceptionally wide profiles. The optimized Bausano cutters ensure clean perfect cutting, for any profile, from basic to even material combinations profiles.

ADVANTAGES:

- Variable cutting speeds for more flexibility
- Electronic device for the pre-setting of cutting length, controlled by encoder
- Ball-bearings sliding on hardened and chrome-plated guides
- Milling cutter-holder carriage

Bausano's profile cutters also have the option for movement of the carriage with the brushless motor (for more precise cutting).



VERTICAL CUTTER

	TAV/90	TAV/160
Cutting system	millar	millar
Cutting movement	vertical	vertical
Max cutting stroke (mm)	95	160
Min cutting length (mm)	300	500
Cutter power (kW)	1,5	1,5
Power of suction motor (kW)	1,1	1,1
Air consumption per cycle (NI/cy)	1,5	1,5

HORIZONTAL CUTTER

	TAO/500	TAO/800	TAO/1200
Cutting system	millar	millar	millar
Cutting movement	horizontal	horizontal	horizontal
Max cutting stroke (mm)	600	850	1250
Min cutting length (mm)	200	200	200
Cutter power (kW)	1,5	1,5	1,5
Power of suction motor (kW)	2,2	2,2	2,2
Air consumption per cycle (NI/cy)	2	2	2

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