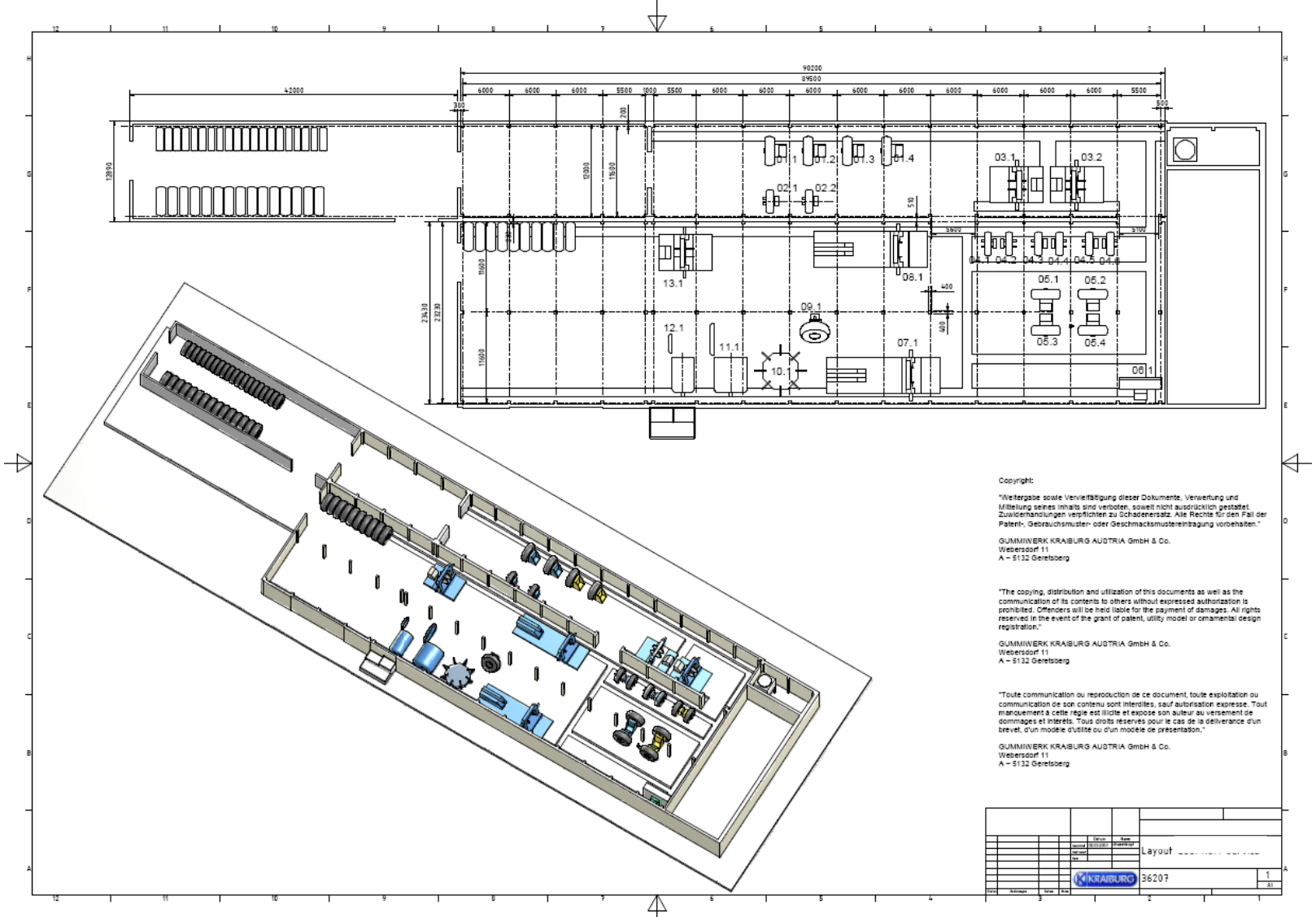


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LAYOUT AND CONSUMPTION DATA (Example for OTR retreading facility)

1. LAY-OUT



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KRAIBURG		36207	1
Layout			AT

2. Consumption of Retreading Plant

Pos.	Description	Power supply	Power consumption	Air-pressure consumption	Water consumption	Suction output	Steam consumption	Weight
A	Buffing Machine	400 Volts-50 Hz-3 phases	78 kW 125A	6000l/h 8 bar	5-6 Liter	3400 m³/h	NO	26 ton
B	Building Machine	400 Volts-50 Hz-3 phases	25 kW 50A	6000l/h 8 bar	NO	NO	NO	20 ton
C	Autoclave 4.300	400 Volts-50 Hz-3 phases	12 KW 30A	10 bar	25 m³/h	NO	3500 kg/h	31 ton
C1	Autoclave 2.500	400 Volts-50 Hz-3 phases	9 kW 25 A	10 bar	13 m³/h	NO	1900 kg/h	11 ton
D	Envelope spreader KES 25-57"	400 Volts-50 Hz-3 phases	15 kW 35A	300 l/Reifen 10 bar	NO	NO	NO	8 ton
E	Twin table KT	400 Volts-50 Hz-3 phases	8 kW 16A	NO	NO	NO	NO	5 ton
F	Inspection spreader MT/35	400 Volts-50 Hz-3 phases	6,6 kW 16A	NO	NO	NO	NO	3 ton
G	Cutting Unit for Rubber Sheets	400 Volts-50 Hz-3 phases	2 kW 16A	NO	NO	NO	NO	500kg
H	Tyre Lifter- Type: TEM-C/57 Standard	400 Volts-50 Hz-3 phases	~ 12,5 kW	350 l/h 8bar	NO	Mobile	NO	10 ton
I	Airless spraying system	AIR	NO / EX	400l/h	NO	4000 m³/h EX	NO	400 kg

3. Consumption of Mobile devices

Device	bar	l/min	Pulse duty factor in %	Number of engines	l/min
Solution spraying system	4,5	230	40%	1	92
Air Gun	6	65	65%	10	422,5
Drilling machine	6	400	15%	3	180
Passenger Car impact screwdriver	6	350	15%	3	157,5
Truck impact screwdriver	6	500	15%	2	150
Grinding machine	6	300	60%	8	1440
Air hammer	6	400	15%	3	180
Hexagonal Steemtool carrier	6	400	60%	8	1920
Staple gun	6	150	25%	5	187,5
Extruder	6	300	30%	6	540
Total					5269,5

4. Basic Information

- **Building requirements:**

- Levelled, dust-free concrete floor B15 (DIN 1045:1988-7) with minimum thickness of 40 cm.
- For the Machine areas special foundations (according the manufacturer) can be required.
- Needed anchors for mounting of machines are required
- Minimum height of production area: 7 m
- Dry and heated production area: min. 20° C
- Fire protection has to be supplied by customer.

- **Compressed air supply:**

- Dry and oil-free compressed air is required
- Air tank with approx. 9 m³
- The needed compressor with air dryer has to be supplied by customer
 - Approx. 10 bar working pressure
 - Min. 13 m³/min
- The piping has to be supplied by customer
- We recommend a closed circular pipeline with a minimum diameter of approx. 2"
- Branch pipe to working stations and machines 1" diameter.
- The branch pipes should be equipped with ball valves and maintenance units (1" diameter)
- The ball valve has to be located close to the machines / working stations (1–2 m) by customer.
- The hole machinery has to be connected to the air supply by customer

- **Exhaust piping – Autoclave**

- The exhaust piping of the autoclave has to be connected and mounted by customer
- Wall breakthrough has to be supplied by customer
- Noise reducing actions (outside the building) is not included in delivery.
- Connections:
 - Autoclave pressurizing compressed air connection: 1" diameter
 - Safety valve pressure discharge connection: 1" 1/4
 - Automatic pressure discharge connection: 1" (outside building)
 - Manual pressure discharge connection: 1"

- **Water supply**

- Water has to be supplied by customer.

- **Electric power supply:**

- The electric power supply has to be ensured by customer.
- The dimensioning of cabling must fulfil the requirements and specification of the local law and has to be installed by a qualified person.
- A qualified person will be required for connection of machinery.

- **Rubber dust:**

- The needed cyclone with exhauster will be supplied by KRAIBURG
- For save mounting of the cyclone a concrete floor with a calculated thickness is required.
- The piping will be delivered by customer
- Wall breakthrough has to be supplied by customer

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- **Spraying cabinet:**

- Wall breakthrough has to be supplied by customer
- Needed piping for compressed air has to be supplied by customer.
- Fire protection has to be supplied by customer.

- **Miscellaneous:**

- Needed lifting tools (forklift/cranes) has to be supplied by customer. The lifting tools have to be operated by qualified persons.
- The workers have to be trained for working safety instructions.
- Machines have to be stored in dry conditions after delivery.
- KRAIBURG has to be informed about damages caused by transportation
- KRAIBURG make Delivery inspection
- KRAIBURG will supply the needed tools for mounting.
- KRAIBURG will take care over the mounting of machinery delivered by KRAIBURG.

All data mentioned above are examples and will vary due to the exact quantity, brand and type of the machinery. All data are placed, just to get an impression about what´s approximately needed consumption for an OTR retreading facility.