

States Machinery & Supplies Corporation

**P.O. Box 280. Manhasset, New York 11030
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(2) USED GLOUCESTER BLOWN FILM EXTRUSION/BAG LINES FOR SALE

(Designed To Run Bags On A Roll, Separated Bags Or Industrial/Converter Grade Films)

1. 3.5" 24:1 L/D 4-Zone Lowboy Extruder-Contracool Series (RH)

1. (1) Barrel - Heavy duty 4140, centrifugally cast, alloy lined (Xaloy 101 or equivalent).
2. Hopper/Feed Throat Section - Single piece section machined from ductile iron and jacketed for cooling (4.0 GPM at 40-80° F). Oblong feed opening. Ref.WO#38195
3. Screw - Reference Item 03.
4. Gear Reducer - Double reduction helical design. Gears are carburized, hardened and ground to a minimum AGMA rating of 12. Housing constructed of machined cast gray iron with integral thrust bearing. All bearings are spray lubricated (thrust bearing is force lubricated). Lubricating oil externally cooled using a closed loop heat exchanger system. Gearbox is directly coupled to drive motor shaft. All reducers are test run prior to shipment. Mechanical rating of 250 HP with 1750 input at 100 RPM (1.0 S.F.) with auxiliary cooling.
5. Thrust Bearing - Tapered roller bearing with B-10 rating of 299,000 hrs. at 5000 PSI and 100 RPM.
6. Base - Heavy duty full length steel weldment, stress relieved and precision machined across entire component mounting surface for accurate alignment of gear box thrust system and barrel.
7. Control Panel - Reference Item 06.
8. Heaters - Heavy-duty deep finned cast aluminum heaters. (Special high wattage heaters on first zone, reference Delta WO#38195).
9. Contracool® - Multi-zone Contracool® with central exhaust blower. Airflow vertically down drawing heated air away from process area. Zone temperature controlled through automatic damper actuators located in extruder base.
10. Hopper - Not included (Customer supplied).
11. Barrel Cover - Heavy gauge lift off design for easy access.
12. Accessories - Screw pusher, three-piece gate clamp, rupture disc rated at 7500 PSI, gearbox oil pump, filter and heat exchanger. Heat exchanger uses 1.5 GPM of water at 40-80° F.
13. Safety signs to be in English and Spanish.
14. 96 SRPM.

B. 3.5" 24:1 Extruder Screw

1. Barrier design with mixing section.
2. Manufactured from alloy steel.
3. Colmonoy 56 flights.
4. Cored through feed section.

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5. Polished surface.
6. Price included in Item 01

C. Addition to 3.5" 24:1 Extruder Screw for Colmonoy 83 Flights

D. Addition to 3.5" 24:1 Extruder Barrel for Xaloy 800 Liner

E. Extruder Control Panel

1. Cabinet - Free standing, force ventilated, and straight faced NEMA 12 cabinet with "through-the-door disconnect.
2. Temperature Controllers - Barber Coleman 7EM 1/8 Din temperature controllers are provided for each extruder barrel zone. Controllers are mounted flush in panel face and are completely prewired to a numbered terminal strip. Additional instruments for down stream equipment are quoted in Item 10. Ammeters are provided for each zone.
3. Melt Temp. - Digital melt temperature meter, control panel mounted, with receptacle located in extruder junction box.
4. Contactors - Solid State contactors are provided throughout as standard.
5. 5. Operator Devices - Start/Stop stations provided for extruder drive, cooling system, air ring, primary nip and treater.
6. 6. Wiring - All wiring is color coded, fused, and sized according to the national electrical code. Wiring terminations are numbered, both on the conductor and at the terminal strip to which it is connected. Power and signal wiring are separated to avoid electrical noise. Interconnections between extruder and other equipment and to supply source are customer's responsibility. (Note: UL Approval on equipment Reference Item 48).
7. Addition for Premounted Digital Screw Speed Indicator and DC Ammeter.
8. Dynic UPR690 Panel Mounted, digital pressure gauge and transducer with horn, indicating light and shut down.
9. Addition for 2 Level Alarm Circuitry with first level horn, indicating light and horn silence; second level with shut down, indicating light and revolving light.
10. (8) Barber Coleman Eighth Din Temperature Controller.
 - Automatic tuning on demand
 - Separate displays for process and set point
 - Setting value (set point) lock function
 - Power failure memory
 - Temperature alarm indicator
 - Prewired and premounted in cabinet.
 - (1) Zone for Screen Changer
 - (1) Zone for Adapter
 - (1) Zone for Block/Rotator

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- (3) Zones for Die (2) Zones for Heated Die Lips (240V, 1PH)
- 11. Melt Thermocouple - Fixed Length 3/4"
- 12. 150 HP DC Safronics Drive - Analog
- 13. 1. DC6 Series Controller
 - Stand-alone NEMA 1A, gasketed and blower ventilated or mounted in BGE power panel.
 - Power module rated 150% for 60 seconds.
 - Fully rated DC armature contactor.
 - 50mV Shunt in armature circuit.
 - Circuit breaker with door interlock handle.
 - Fused blower motor starter.
 - Field loss relay.
 - Field economy circuit.
 - 100VA Control transformer.
 - Field trim resistor is standard, field regulator provided for extended speed range.

F. G.E. DC Motor, 1750 RPM Base Speed

1. Drip proof blower ventilated. F1 or F2 Conduit box location.
2. Normally closed thermostat.
3. Blower and filter (Note: Blower to be oversized).
4. PY Series tachometer mounting kit with tachometer
5. For +/- 1% speed regulation over a 10:1 constant
6. Torque range.
7. Start-up of drive included.

G. Addition to 150 HP DC Drive for Isolation Transformer.

1. 460V Pri/230V Sec

H. 3.5" Dynisco Extek EM Manual Screen Changer

1. Proven design and precision workmanship provide leak free operation with minimal maintenance.
2. Screen changer and seals designed for leak free operation up to 10,000 PSI.
3. Body bolts to extruder barrel. Slide plate and two (2) breaker plates included.
4. Unique multi position handle design allows better operator access to screen changer.
5. Plated flow surfaces.
6. Extruder screw may be pulled through the screen changer while mounted on the extruder barrel.
7. Wired for one (1) heat zone (includes heaters, type J thermocouple and appropriate connector/connection).

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8. Reference item 10 for temperature control instrument.
- I. **1-Piece Downstream Adapter to Connect 3.5" Barrel Flange to Die Block/Rotator**
 1. Adapter machined from 4140 steel on CNC Machinery.
 2. All flow surfaces are electroless nickel-plated.
 3. Includes 2-piece quick clamp and heaters.
 4. Wired for one (1) heat zone (includes heaters, type J thermocouple(s) and appropriate connector/connection. Reference Item 10 for temperature control instrument.
- J. **C-Style (525) Rotator w/Mobile Cart for 12" Non-IBC Die**
 1. Cart adjustable +/- 2" from the standard centerline height of 21".
 2. Rotator machined from 4140 alloy steel using CNC machinery. All flow surfaces electroless nickel-plated.
 3. High capacity thrust and radial bearings provide smooth operation, low maintenance, and extended service life.
 4. Graphite impregnated Teflon provides seal between polymer flow path and housing.
 5. Chain driven rotator drive with 1/6 HP motor. Rotator speed is .2 rpm. Chain guard is provided.
 6. Wired for one (1) heat zone (includes heaters, type J thermocouple(s) and appropriate connector/connection. Reference item 10 for temperature control instrument.
- K. **360° Oscillation System for Rotator.**
 1. Oscillating power cable eliminates slip rings for reliable electrical connections and thermocouple signals.
 2. Covered stainless steel tray and Gleason Power Track protects power cable for long, reliable service life.
 3. Backup limit switch prevents over-rotation in either direction in case of primary switch failure.
 4. Gradual acceleration/deceleration provides for smooth direction changes without disturbing the bubble.
 5. Track to carry compressed air for bubble inflation (non-IBC).
- L. **12" Single Layer Non-IBC Radial Fed Die (.095" Die Gap) (Special 14" Body)**
 1. Die machined from 4140 drop forged, through hardened and stress relieved alloy steel to give uniform grain structure and to prevent warping of die parts during heating and cooling.
 2. Die is safely oven cleanable up to 850° F, as frequently as necessary.
 3. Computer designed spiral flow channels optimized to provide maximum versatility on the range of resins specified.
 4. All flow channels designed to minimize polymer residence time and to keep polymer shear rate high enough to minimize gel build-up and enhance product changeovers.

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5. Die machined on precision CNC machine tools, resulting in tighter tolerances and more consistent flow surfaces, enhancing film gauge variation control.
6. Alignment of die parts assured by the "Taper Lock" design pioneered by Gloucester Engineering Co. Self-aligning features eases assembly and disassembly.
7. Removable mandrel extension (pin) and sizing ring for easy cleaning and to allow the die diameter to be changed without changing the entire die.
8. Die includes die pin inserts which allow quick change of die gap. Taper lock fit for positive alignment.
9. Massive components assure thermal homogeneity of entire piece resulting in uniform die temperature, flow rate, and gauge control.
10. Electroless nickel plating provides durability against abrasive and corrosive materials and insures complete plating in deep port passages.
11. Die is wired for three (3) heat zones. (Includes heaters, type J thermocouples and appropriate connector/connection. Reference item 10 for temperature control instrument).

M. 12" Die Lip Heaters (High Wattage)

1. Die heaters are wired for (2) heat zones. (Includes heaters, type J thermocouples and appropriate connector/connection. Reference item 10 for temperature control instruments).

N. 12" Air Ring

O. Air Ring Blower with Variable Frequency A.C. Drive System. Includes:

1. 2200 CFM blower with 10 HP A.C. motor and Variable Frequency A.C. drive.
2. Air maze inlet filter to prevent clogging of downstream equipment.
3. Operator control station with easy-to-read 3-digit speed pot and large Allen Bradley start-stop push buttons.
4. Controls integrated into discrete instrument panel.

P. Polycool Coils Heat Exchanger for use with 12 Diameter Air Rings. Model 2430.

1. Heavy gauge galvanized sheet metal construction.
2. All parts subject to cold air are sealed with vapor proof insulation.
3. All sheet metal joints are welded.
4. Cooling coil has large face area, deep rows of copper tubing with aluminum fins, and lead free solder.
5. Deep drain pan with 1 1/4" diameter drain.
6. Smooth airflow across the coil is assured by the exclusive air diffusion of the Polycool design.
7. Coil is protected by an easily accessible filter.
8. Air inlet and outlet are 8" diameter for 10" - 14" air rings and 10" in diameter for 15" - 16" air rings. Both are rated for 2200 CFM.

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9. Chill water inlet and outlet are 2" in diameter and uses 48 GPM.
10. Note: Diverter located in coil to keep condensation from filling up air hoses.

Q. 84" Bubble Containing Shafts on rack and pinion mechanism

1. Actuated by chain. For mounting above bubble cage. Chain to be 16' long.

R. 84" Nip Roll, Primary (Standard)-(600 FPM) Primary Nip Roll Assembly includes the following:

1. 8 3/8" Diameter rubber covered nip roll pneumatically actuated.
2. 8 3/8" Diameter chrome plated, cored for water-cooling, driven roll.
3. 5 HP AC flux vector drive motor and controller.
4. Collapsing frame upper adjustment hardware.
5. Operator controls including nip pressure controls, open/close pushbuttons, speed pot, tachometer and on/off switch.
6. Safety cables also provided.
7. Spot face shaft at set screws for locking gearings.
8. Designed for fully retractable gusset boards.
9. Rubber nip roll to have 0.010" crown.
10. Idler rolls to be locking-collar type with spot face.

S. Collapser, Primary Nip (Nylon Covered Slat) - 84" Collapser Assembly for Primary Nip Unit including the following:

1. Two 84" W X 144" Long Collapsing frames.
2. Collapsing surface; 3" nylon covered wooden slat fastened to an aluminum frame.
3. Hardware and heavy duty single point adjustment mechanism for the lower portion of the collapsing frames.

T. Addition for Deep Gusset Tri-Boards - 84" Nip Roll.

1. Designed to be fully retractable with mounting brackets 3" lower than standard to avoid contact with nip roll when being retracted.
2. Gusset boards to be 13' long.

U. (10) 01-060040Z Tower Idler Rolls - 3.5" X 84"

1. 3.5" precision machined aluminum rolls
2. Precision bearings for free turning rotation
3. Includes through shaft and mounting blocks
4. Spot face shaft at set screw for locking bearing.
5. Shafts to be standard length, Customer will modify as necessary for mounting.

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- V. (1) 01-060262Z 84" Machine Mounted Frame for Slit Sealer**
1. Including Idler Rolls and retracting cylinder for post gusseter mounting. For Amplas slit sealers (Slit Sealer Head Supplied by Customer))
- W (1) 01-060292Z Addition for 84" Bowed Roll Mounted in Slit Seal Frame.**
- X (1) 01-060312Z 84" Post Gusset Mechanism 14 ft Center Line Height (Special)**
1. Drive - 2 HP Electronic variable speed drive with all controls. Automatically speed mated to line speed via pneumatically controlled dancer. Timing belt drive.
 2. Frame - Free standing tubular frame with Blanchard ground mounting plates. NOTE: Frame depth to be increased by 12".
 3. Idler Rolls - 3.5" diameter precision machined and polished aluminum rolls with through shafts and precision ball bearings for frictionless rotation.
 4. Anodized protective coating on rolls.
 5. Nip Rolls - 5.75" diameter rubber nip rolls pneumatically actuated from remote control station.
 6. Spot face shaft at set screws for locking bearing.
 7. Timing belt drive.
 8. Gusseting Mechanism - To be quoted separately (Reference Item 33). Basic hardware for mounting to be supplied.
 9. Collapser - Hard maple slats - 3" contoured pieces on 4" centers.
 10. Platform and ladder not supplied.
 11. Safety cords and cables.
 12. Add additional support to start-up idler
 13. Line speed 400 FPM.
 14. Rubber nip roll to have 0.010" crown.
 15. Idler rolls to be locking-collar type with spot face.
- Y (3) 01-060330Z Addition to Post Gusset Mechanism for Gusseting Assembly**
1. Including two (2) gusseting adjusting castings plus
 2. One (1) set of guide rolls and two (2) tri-boards. (Customer to specify gusset depths and size.)
 3. 2. Gusset blades to be 5 ft. long.
- Z (1) 01-100090Z 80" Model 450HE Bag Machine Includes:**
1. Frame:
 - 1" Thick side frames.
 - 6" Cross girts.
 2. Drive:3 HP AC Inverter Flux Vector drive:
 - Hydraulic power transmission.

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3. Twin Sealing Head:
 - 2 Seal bars, with high wattage heating elements, bottom seal or side seal bag production. 5/32" Radius seal bars.
 - Perforation blades 27 tooth coated.
 - Non-rubber footed film strippers.
 - Hydraulically controlled seal pressure is infinitely variable.
 - Electronic dwell time control.
 - 5/8" Heavy-duty head lift turnbuckles.
 - Replaceable spring guide inserts.
4. Nip Rolls:
 - Dual input and output nips.
 - Neoprene covered rolls, grooved exit nip roll to prevent air entrapment.
 - Differential speed control between input and output nips provides web relaxation/tension control in shuttle for consistent sealing and perforating.
 - Locking collar bearing on chrome rolls.
5. Speed Mating/Tension Control:
 - Input dancer with solid-state sensor mates bag machine speed to incoming web speed from film extrusion line, or unwind stand.
6. Hydraulic System:
 - Darmex Synthetic Oil
 - Built in cooling bundle in hydraulic tank is standard.
 - Hydraulic fittings have long life O-rings to prevent leakage.
7. Control Panel:
 - Main controls mounted on a common, user-friendly console.
 - Barber Coleman MAE solid-state temperature controllers with mercury contactors.
 - 3 temperature controllers provided. Front and rear seal bars, and platen temperature are independently controlled.
 - Digital displays via a microprocessor based counter and rate meter of
 - Batch count
 - Bag total
 - Preset number of bags
 - Preset number of batches
 - Bag length
 - Film speed
 - Cycle rate
8. Lubrication:
 - Central lubrication system for all piloted bearings. (Special large diameter tubing).
9. Maximum web width - 78".

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10. Minimum draw length - 10".
11. Maximum film speed - Customer specification up to 300 feet/minute.
12. Cycle speed - Customer specification up to 120/min.
13. Electrical requirements - 230 Volts.
14. Front and rear safety cables.
15. All idler rolls to be locking-collar type with spot face.

AA (1) 01-100000Z Addition to 450 for Rear Nip Lockdown Assembly.

AB (1) 01-100000Z Addition to 450 for Anodizing Idler Rolls.

AC (1) 01-100000Z Addition to 450 for Shut-Off Valves for Tank to Head and from tank to shuttle.

AD (1) 01-081208Z 84" Model 1007-D Dual Turret, High Speed Shaft Type Winder with Automatic Indexing and Cut-off. 84"

1. Thick side plates, Blanchard ground for perfect flatness, vibratory stress relieved prior to machining on CNC equipment to maintain accuracy of all holes to within .001" of true position. Positive alignment of frame and crosswise members is maintained.
2. Solid-state compensator positioning electronic drives. Individual core drive motors mounted on turret arms.
3. Incoming cores are speed mated to existing line speeds at cutover. Timing belt drives. Controls are prewired and mounted in operator's console.
4. Power indexing by integrally mounted gearhead motor.
5. Tension control by GEC dancer control with diaphragm, pneumatically actuated. Remote tension controls and gauge premounted in operator's control console.
6. Idler rolls are 3.5" diameter precision machined and polished aluminum with precision ball bearings for low friction rotation. Protective coating on rolls.
7. Lay-on Roll Assembly - Special- Aluminum roll mounted steel lay-on roll arms, Idlers to be through shafts. Bowed rolls - Reference Item 45 for driven bowed rolls. Automatic positioning for automatic start-up. Pneumatic loading by remote control.
8. Plunge knife cutover, top cut on top turret and bottom cut on bottom turret (outside wind).
9. Programmable logic controller (PLC), electronic counter, and all pneumatic controls prewired and integrally mounted.
10. Air actuated tailstocks with pneumatic release, actuated by manual controls premounted on turret arms.
11. Integral nip roll assembly with one (1) chrome plated driven roll and one (1) 55 Durometer rubber roll, pneumatically actuated. Chrome roll speed controlled through dancer assembly. Nip roll station includes two (2) pneumatically actuated trim knives. All controls

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prewired and mounted in operator's console. Safety cables also provided. Spot face shaft at set screws for locking gearings.

12. Maximum roll diameter - 24".
13. Counter to count Feet and or bags
14. Safety Cradles - For 3" and 6" airshafts. Machine designed for both 3" and 6" shafts.
15. Special - Green light to be mounted on back of winder indicating nip roll is closed and running, reference
16. Supply Air Shaft fill hose with nozzle.
17. Force open switch to be on both sides of nip.

AE (1) 01-090000Z 82" Air Shafts (Supplied by Customer)

AF (1) 01-080000Z Addition to 84" 1007-D Winder for Motor Driven Bowed Rolls

- Bowed roll for each spindle.

AG (1) 01-080000Z Addition to 84" 1007-D Winder for Static Transfer

1. Includes static bars and power supply for dual turret winder.

AH (1) 01-090062Z Electro-Pneumatic Taper Tension (Double Turret)

1. Optional electro-pneumatic taper tension for double turret winders. This option can be applied to dancer tension systems. The taper tension system provides for a reduction in air pressure to the dancer bellows, which reduces the winding tension as the roll increases in diameter. Tension settings are controlled via 2 pots, and the amount of tension decrease is controlled by the taper pot. This system eliminates need for compensation when a transmission is included or when core sizes are changed.

AI (2) 01-091248Z Static Eliminator Bar for 84" 1007-D Winder (Shock Type)

AJ (1) 01-091260Z Static Eliminator Transformer Power Supply

AK (2) 01-091246Z 80" Simco Ionizing Air Blower Static Eliminator

1. Includes 2 ionizing blowers and 1 power unit.
 - Note: Two required for top turret and two required for bottom turret on dual turret winders.

AL (2) 01-090238Z Mounting System for Pneumatically Actuated Center Slitting at Winder Lay-on Roll; including the following:

1. Mounting bar for one (1) winder lay-on arm.
2. Actuating arm, pneumatic valve/cylinder and bearings.

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3. Associated hardware and pneumatic tubing for mounting equipment in lay-on arm assembly.
4. Pneumatic slitter head(s) are not including in this item.

AM (8) 01-090240Z Pneumatic Actuated Slitter Heads for Winder Lay-on Rolls including the following:

1. Slitter head assembly designed for lay-on roll mounting (mounting system prices separately).
2. Pneumatic rotary system for rotating the blades into and out of the film web.

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