World Class Machines

For

World Class Tyres

SPECIFIC
ENGINEERING CORPORATION

Specific Engineering Corporation Pvt Ltd

Our Other Machines

Tyre Curing Press

Electric Hydraulic Press

Hot Feed Extruder

Rubber Mixing Mill

Tube Spilcer

4-Roll Calender

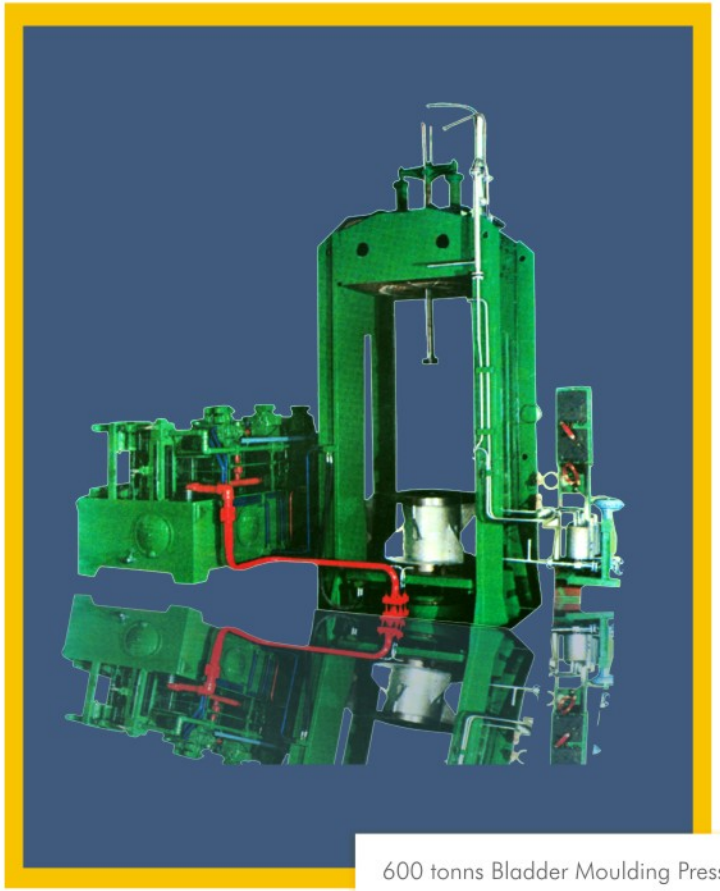
Bladder Moulding Presses

Range of SEC SBV Bladder Moulding Presses

SEC- SBV - 300
SEC - SBV - 400
SEC - SBV - 600
SEC - SBV - 1100

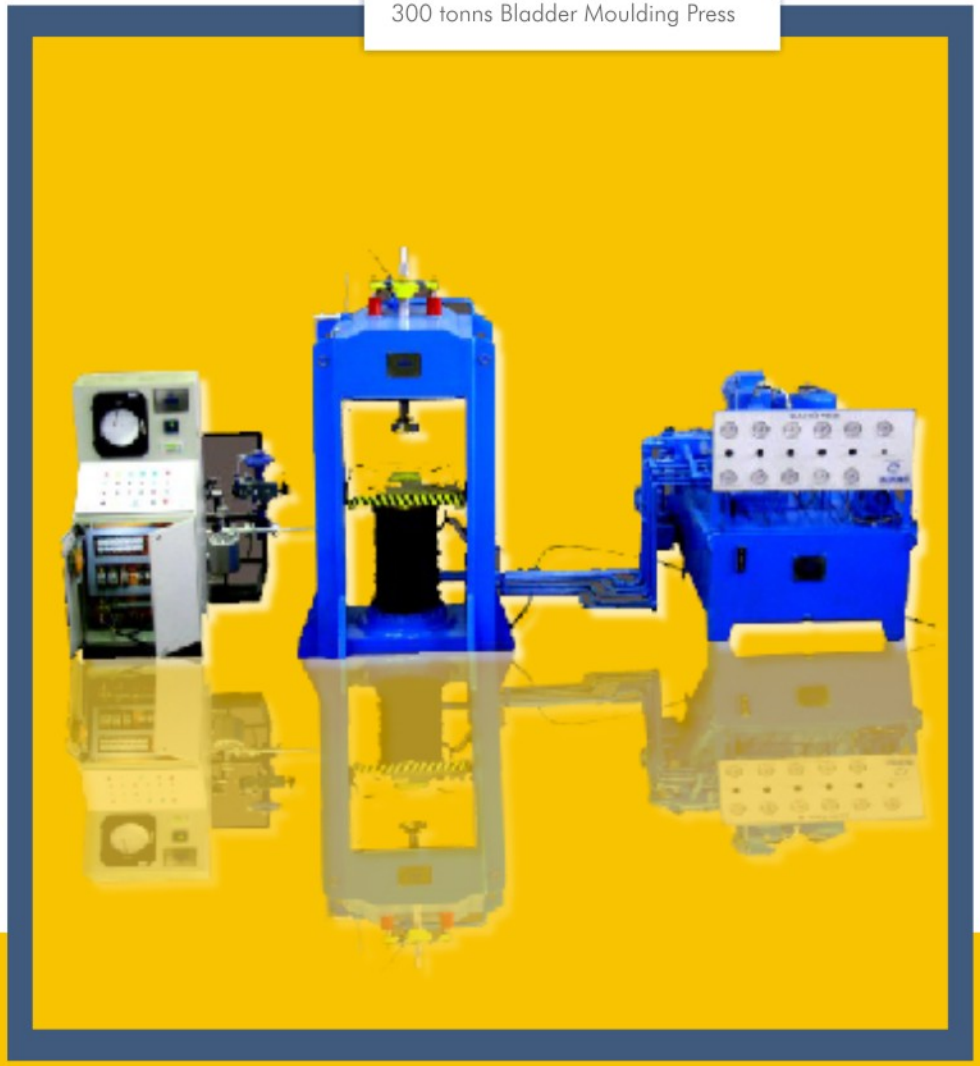
Contents

Product Pictures



600 tonns Bladder Moulding Press

300 tonns Bladder Moulding Press



Bladder Moulding Press

Technical Description

The SBV Bladder presses are designed especially for manufacturing and curing the bladders used in the AUBO, BOM &AUTOFORM presses.

The control of hydraulic system included in the equipment is designed such that the lower mould half carrying the uncured rubber approaches the upper mould half with high velocity during the first closing stage, reducing the total closing period to minimum.

In the beginning of the pressing operation, the closing speed is slackened automatically in order to obtain slow and uniform compression of uncured material.

After laps of the curing time, the press opens up automatically and the bladders for AUBO and BOM presses are removed from the lower core plate. the bladders for AUTOFORM presses are detached by a pneumatic device which is included in the delivery on request.

The moulds which are generally executed according to customer's drawings are made of high grade steel. The two external mould portions and the core are cured by a direct steam connection.

The presses and hydraulic power unit are delivered, complete and ready for connection, excluding curing platens. A timer for automatic press opening after termination of the curing period as well as steam and condensate pipings are normal features of supply. supervision of erection, installation and commissioning.

Machine Features

The press is complete with all ancillaries necessary for the proper function of the bladder moulding operation and provided with terminations for appropriate connection by others to the battery limits of site services .

The press is equipped with a mould lifting fixture and removable mould roll-in, roll-out table to facilitate mould changing .

All components of the press structure, hydraulic system and associated items of the plant are designed so as to safely carry all loads imposed by the use of the press moulding Tyre press bladders and rated for the maximum design press closing force.

The press structure is designed to safely carry a normally imposed load of at least 15% excess of the designed maximum closing force.

The hydraulic system is designed so as to deliver a maximum of 5% excess of closing force above the design maximum closing force.

All electrical equipment is suitable for connection to the site electricity supply at 440 volts, 3 phase & neutral 50 Hz, control voltage to be 110 volts, 50 Hz single phase from panel transformer.

Included Items

One hydraulically operated Bladder Moulding Press complete with main RAM for applying varying press closing forces & auxiliary RAM systems for mould core and ring movements together with means of locating and retaining mould cores, upper & lower mould halves in the press and suitable for a range of Tyre press bladder mould sizes up to the maximum sizes and rated for the maximum design press closing force.

One electric motor driven hydraulic power unit continuously rated to provide varying press closing forces for moulding.

One complete press control system complete with all valves, controls, instruments, gauges and actuators necessary for the safe operation of the press and the control of the moulding operation including recording of cure cycle time, temperature & operating parameters recording when moulding a range of tire press bladders.

One Electrical control cabinet to house all items associated with electrical control system complete.

One set of compressed air pipe work and fittings for supply of air requirements which is to include air rectification units to remove fine entrained contaminants and droplets, an air receiver to continue the operation in the event of a compressed air supply failure & for removal of cured bladder at the end of cure, pressure regulation to the requirements of recorder / controller is to be provided together, the site battery compressed air limit at (7) kg / cm^2.

All necessary drawings, details and general assistance to enable others to prepare foundations & other installation requirements will be provided with the machine.

Additionally

Spare parts list for normal two years operation.

Training of three engineers (operation, maintenance, quality control).

The supervision of erection, installation and commissioning will be provided at an additional cost.

We guarantee that the equipment when correctly mounted properly operated and maintained, shall give satisfactory performance for a period of 12 months from the date of start- up.

Bladder Moulding Press

Technical Data Sheet

Specification	SEC SBV-300	SEC SBV-400	SEC SBV-600	SEC SBV-1100
Press Closing Force	300 tonns	400 tonns	600 tonns	1100 tonns
Mould Range from 12" - 20"	Cycle & Motor-cycle bladders	11"-20" / 12"-24"	*18"-24" / 25"	14"-34"
Diameter of main RAM	350 mm	450 mm	640 mm	865 mm
Hydraulic oil pressure	250 kg/cm^2	250 kg/cm^2	180 kg/cm^2	180 kg/cm^2
Stroke of main RAM	670(std) / 1000 (sp.)mm	1000(std) / 1250(sp.) mm	2500 mm	3300 mm
Core cylinder force at :	180 kg/cm^2	180 kg/cm^2	180 kg/cm^2	180 kg/cm^2
- Raising force	20 tonns	30 tonns	40 tonns	40 tonns
- Downward force	10 tonns	15 tonns	20 tonns	20 tonns
Ejector cylinder force at :	180 kg/cm^2	180 kg/cm^2	180 kg/cm^2	180 kg/cm^2
- push-up force	10 tonns	15 tonns	20 tonns	20 tonns
- pull down force	9 tonns	12 tonns	15 tonns	15 tonns
Stroke of core cylinder	150 mm	520 mm	850 mm	1220 mm
Stroke of core ring	230 mm	680 mm	850 mm	1250 mm
Distance between side links	820 mm	960 mm	1450 mm	1500 mm
Thickness of mould (max./min.) ht	250 / 100 mm	850 / 550** mm	1300 / 500 mm	1900 / 508 mm
Platen Dimensions				
- Bottom (w & l)	750 mm	850 mm	1350 mm	1400 mm
- Top (w & l)	750 mm	850 mm	1350 mm	1400mm
Maximum press opening	670 mm	1800 mm	3000 mm	3800 mm
Electric Power (KW)	8 KW	8 KW	80 KW	80 KW
Approx weight press and pump (Kgs)	7000	10500	35000	50000
Approx closing speed H. P. / L.P. (mm/ min)	100/1000	66/1000	36 - 336/1400 - 1700	60-400 / 1700-2000

Internal & external curing	upto 16 atm. steam
Electric Power	220/415 V 50 cycles
Accessories	Bladder Moulding

SEC

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