

Compound additive process description and flow chart

Composite additive production process, production process, quality assurance measures in production links

The production process is based on the customer's requirements. After mixing various powdery additives evenly, the powdery material is converted into a granular product that meets the user's requirements by granulation, so as to increase the bulk density and facilitate feeding, storage and transportation. At the same time, Due to the uniform composition of various additives in granular products, the product quality in the application of downstream users is guaranteed. The production process is as follows:

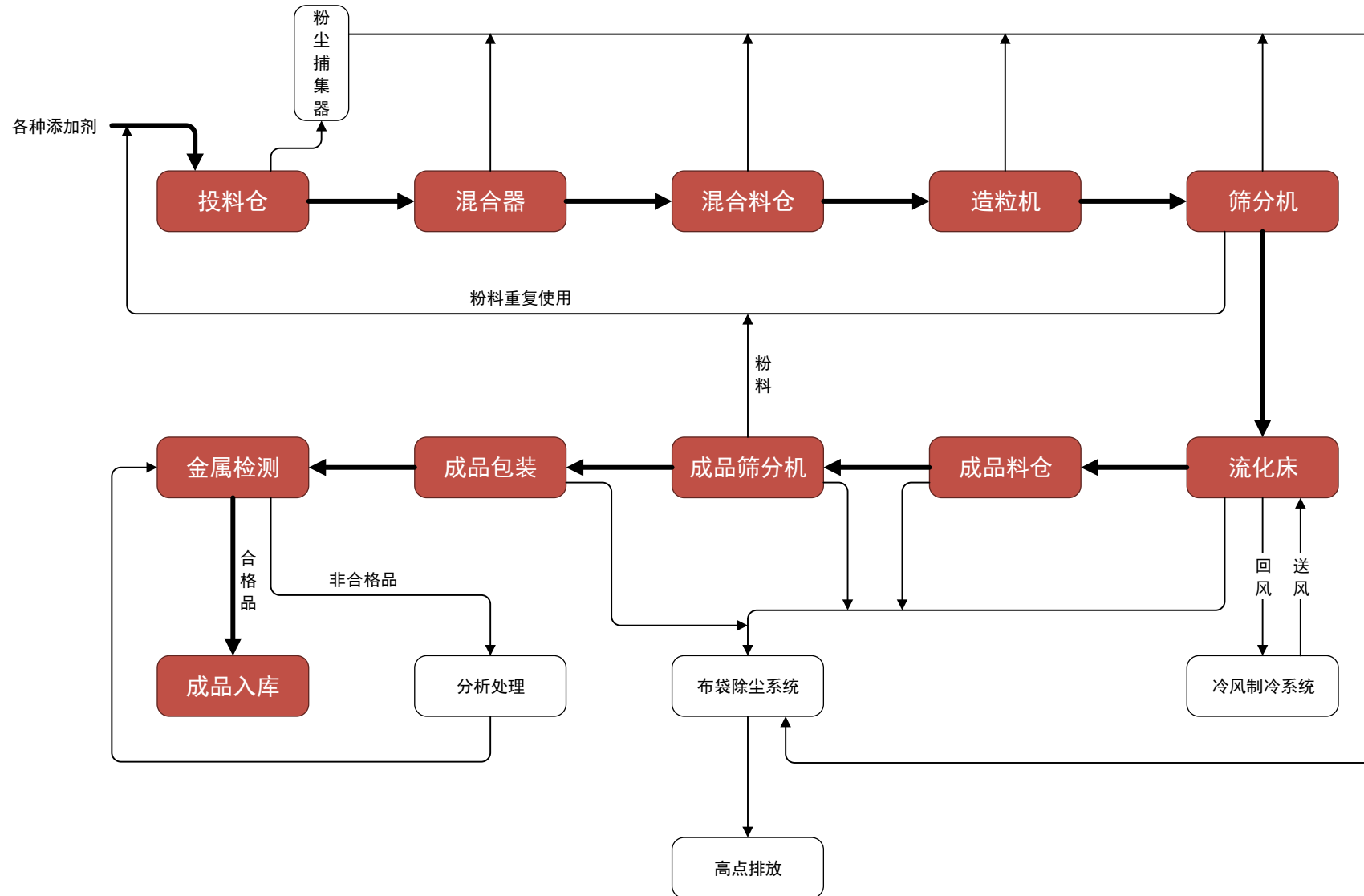
First, measure 2 tons of antioxidants and other additives according to the proportion required by the buyer. The allowable error must be within the allowable error range, and the weighing quantity must be within the allowable error range. Start the exhaust fan motor. Close the feed valve of the twin-screw mixer, open the feed valve of the twin-screw mixer, and turn on the stirring motor of the twin-screw mixer. Add various pre-measured additives into the double-screw mixer through the feeding port of the feeding bin. Stir and mix at room temperature for 2.0 hours (multi-point sampling to control and measure components), continue to mix for 0.5 hours if unqualified, and then take more samples to control and measure components. After the mixture reaches the qualified product, put it into the mixing bin and prepare Granulate.

After the mixing is completed, start the blower and exhaust fan, and adjust the air volume control valve of the blower and exhaust fan, as well as the ventilation valves of the fluidized bed, intermediate silo and each device. Start the screening machine, fluidized bed vibration motor, fluidized bed ventilation and refrigeration system. Turn on the motor of the granulator. When the granulator is running in balance and there is no abnormal phenomenon, open the feeding valve of the mixing bin, and the powder is quantitatively added to the granulator by the frequency conversion feeder to start granulation. The granulation from the granulator is After the material is

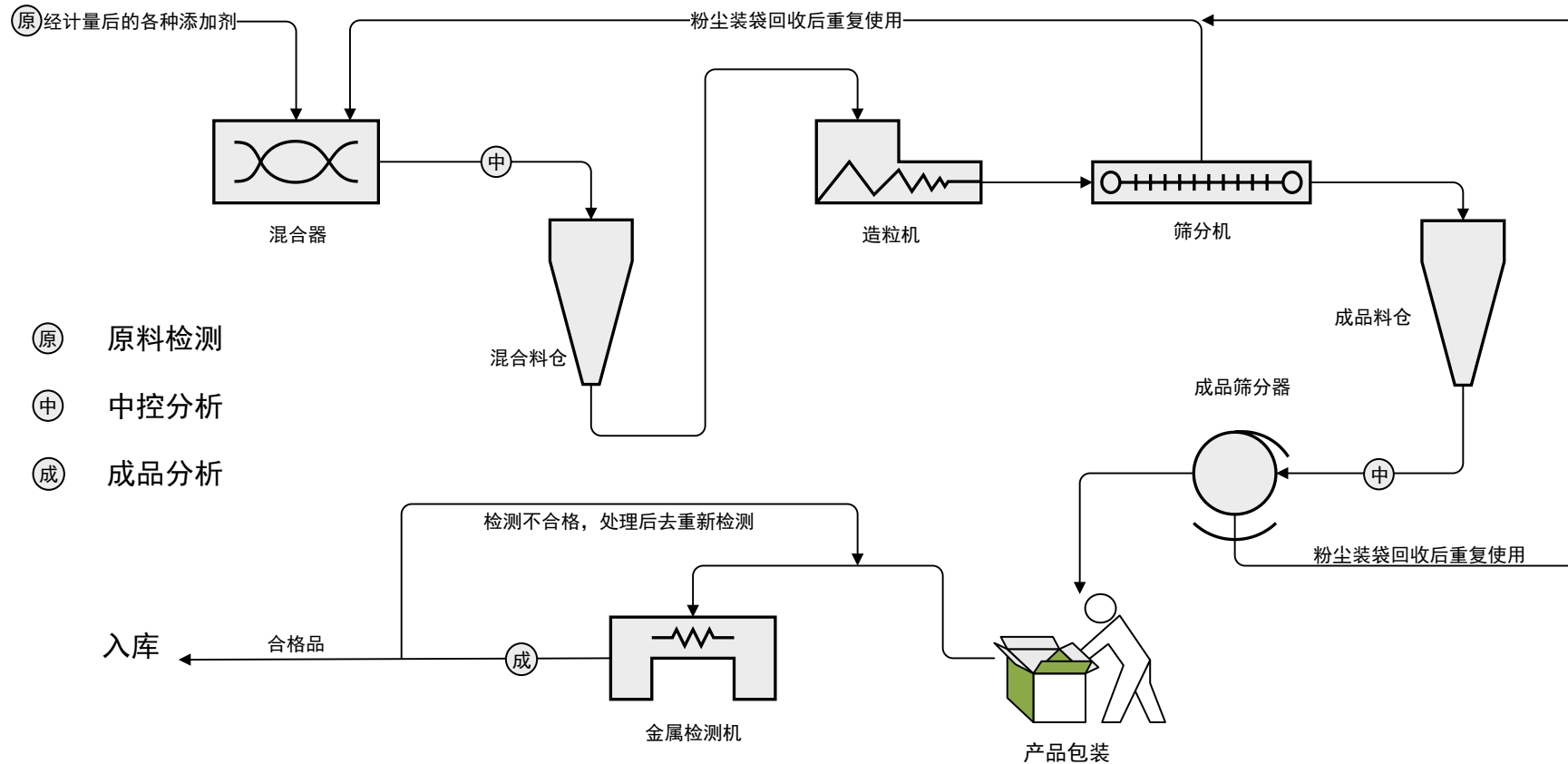
screened by the sieving machine and cooled by the fluidized bed, the granular product is cooled by air blowing, and gradually moves forward under the vibration of the vibrating motor, and finally enters the finished product silo. A small amount of dust enters the cyclone separator and the bag filter with the gas to be captured. When the granulated material in the finished product silo is stored to a certain amount, sampling and analysis (full product analysis) will be carried out, and the screening and packaging process will be carried out after passing the test .

Turn on the motor of the finished product screening machine. When the equipment is operating normally and there is no abnormal phenomenon, open the discharge valve of the finished product bin, and the material enters the screening machine for screening, and the larger particles and block materials flow to the block recovery on the upper bed surface. The qualified size granular material flows to the outlet on the middle bed of the screening machine for finished product packaging, while the lower layer of powdery material flows into the powder recovery bag. Recycled materials from bulk recovery bags and powder recovery bags are sent to the granulator for repeated granulation. After the granulation and packaging are completed, metal detection is carried out, qualified bags are put into storage, unqualified bags are re-opened for inspection and analysis, metal detection is performed after processing, and qualified ones are put into storage. Its process flow diagram is as follows:

复合添加剂工艺流程方框图



复合添加剂质量控制图



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Compound granulation workshop



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Attachment 1 Mixer, nameplate, equipment photos



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Attached 2 horizontal granulator, nameplate, equipment photos



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Attachment 3 Extrusion granulator, nameplate, equipment

photos



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Attachment 4 Vibration fluidized bed, nameplate, equipment photos



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Attached are 5 pulse dust collectors, nameplates, equipment
photos



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Attached are 6 circular vibrating screen dust collectors,
nameplates, equipment photos

