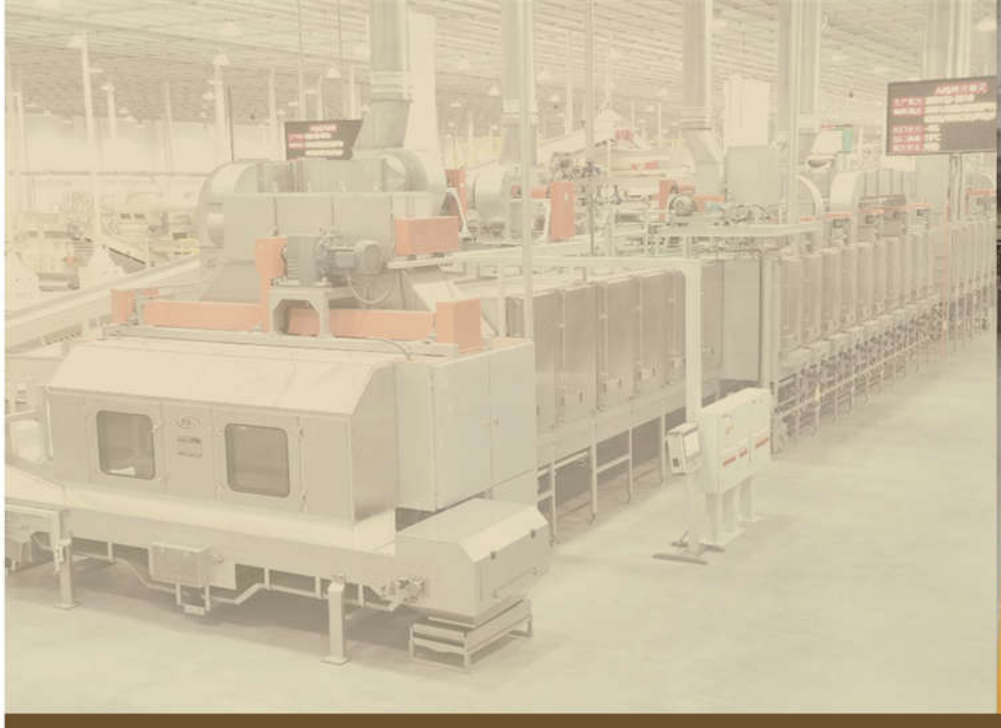




CSSC

THRESHING AND REDRYING LINE

KUNMING SHIPBUILDING EQUIPMENT CO.,LTD.

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COMPANY PROFILE

Kunming Shipbuilding Equipment Co., Ltd. (KSEC) as a subsidiary of China State Shipbuilding Corporation Limited, was established in 1986 committing to the automated machinery development and manufacturing industry. As a state-owned enterprise group in China, KSEC has over 4,000 employees in total and more than 50% are technical and professional staffs. With head office in Kunming city, Yunnan province of P.R. China, KSEC has a manufacturing premise with area of 80 hectares equipped with over 3,000 sets state of art machining equipment. 4 branches in China and 1 representative office in Thailand, KSEC is expanding the ability to provide instant service to customer.

With over 4 decades of expertise, know-how and application experience accumulated, KSEC has successfully implemented over 1,000 projects (for PMD and GLT) and delivered various tobacco machineries to 300+ customers globally. From a sketch of green land or existing line, KSEC works closely with clients to find out the best solution to guarantee the investment through careful system plan, premium quality equipment and after sale service at the most reasonable price.

The automatic logistics system effectively connects all critical production sections through just in time material handling, high-density storage, optimized scheduling, data driven management so as to achieve much higher efficiency and significantly less human error. Since 1995, KSEC introduced the automated logistics technology to tobacco industry in China and has revolutionarily changed the production organization mode of tobacco industry.

As a leading company for providing total solution on primary processing line, green leaf threshing & redrying, automatic logistics system for tobacco industry, KSEC always takes client's need as its core, commits to providing the most advanced and cutting edge technology to the industry and is going to be a global player and willing to provide all the best service to client's best benefit. Together with client for a bright future through intelligent technology.



JET-TYPE VACUUM CONDITIONING PLANT

Application

The jet-type vacuum conditioning plant is used in the primary processing line or threshing and redrying line for vacuum conditioning process of tobacco leaves. It can increase the moisture and temperature of tobacco leaves to a suitable extent, so as to improve the endurance and toughness, change the physical characteristics to meet the requirements of subsequent process. Besides, it can remove the greenish odor and kill insect eggs in tobacco to some extent.

Features and specifications

- Rated capacity: 1500~6000 kg/h
- Maximum vacuum degree: ≤266 Pa (Macleod gauge)
- Working vacuum degree: ≤666 Pa (Macleod gauge)
- Moisture content increased: ≥2%
- Temperature after conditioning: 55~75℃ (Allowance±5)
- Conditioning sufficiency: ≥98%



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MECHANIC VACUUM CONDITIONING PLANT

Application

The mechanic vacuum conditioning plant is used in primary processing line or threshing & redrying line for conditioning tobacco leaves in a vacuum chamber. It can increase the moisture content and temperature of tobacco leaves to a desirable degree, which improves the tenacity and anti-breakage property through changing the physical characteristics of tobacco leaves, so as to meet the downstream process requirements. Besides, it can remove the greenish odor and kill the insect eggs mixed in tobacco leaves.

Features and specifications

- Full mechanical vacuum pump for generating vacuum without steam consuming.
- Temperature control or pressure control for continuously condensate discharge with less noise level and free of condensate back flow risk.
- Rated capacity: 1500kg/h~6000kg/h
- Maximum vacuum degree: ≤ 266Pa
- Working vacuum degree: ≤666Pa
- Moisture content increased: ≥2%
- Temperature of lamina after conditioning: 55-75℃ (Allowance: ±5℃)
- Conditioning sufficiency: ≥98%



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BLENDING TABLE WITH TIPPING DEVICE & TIED LEAF CUTTER

Application

The blending table with tipping device & tied leaf cutter is used in the pretreatment section of threshing and redrying line for tobacco leaf cutting and untying.

Features and specifications

- Cutting length of tobacco leaves can be adjusted on line through changing the relevant position of fixed and movable blades on the machine frame.
- Maximum 6 cutting blades can be configured to achieve multiple stage cutting as per different process recipe requirement on cutting of leave base, medium and tips.
- Three row chain structure for firmly pressing on tobacco leave to ensure zero tobacco shift during cutting.
- Material blocking mechanism set to avoid material return.
- High tied leaf untying rate.
- Rated capacity: 3000~6000 kg/h (Calculation based on MC at 12%)
- Cut-off rate: 98%
- Positioning accuracy: 0.5 mm



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LIVE ROLLER DESANDER

Application

The live roller desander is used in the pretreatment section of tobacco threshing and redrying line for sieving out sand, scraps and dust, thus to improve the purity of tobacco leaves.

Features and specifications

- Evenly paving the material fed in and reducing the thickness of material to increasing the sieving efficiency.
- Three stage roller sieving with good sieving result and less degradation.
- Multiple layer sieving to effectively screen out the scraps and sands from tobaccos.
- Quick dismantle structure design on sieving rollers and meshes.
- Full enclosed machine with dust removing port on top hood to avoid pollution from over flow dust.
- Rated capacity: 3000-12000 kg/h (Calculation based on MC at 12%)
- Sieving efficiency: ≥85%



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SAND SIEVING CYLINDER

Application

The sand sieving cylinder is used in the threshing and redrying line for sieving out sand, soil, short stems and scraps with size less than 1/2' from tobacco leaves, making the leaves clean and reducing the degradation loss during threshing.

Features and specifications

- Multiple size meshes available for option.
- Transparent plexiglass window set at both side of machine for easily observation of machine running status.
- The window can be opened to outside for easy cleaning and maintenance.
- Cylinder jacking-up device available for protecting support roller in idle time.
- Rated capacity: 3000-12000 kg/h



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PNEUMATIC CLASSIFYING SYSTEM

Application

The pneumatic classifying system is mainly used in the tobacco leaf pre-treatment section or stem processing section of tobacco threshing & redrying line, which can effectively reject various light or heavy foreign matters mixed in tobaccos such as jute strings, feathers, grasses, plastic films, metals, stones, etc.

Features and specifications

- High speed conveyor ensures whole material throwing procedure consecutive and gently for better classifying effect and less degradation.
- Optimized air distributing field design to improve the classifying correctness.
- Circulating air lift structure to simplify the system structure and reduce energy consumption, helpful for keeping the moisture and temperature of materials.
- Significantly increased the classifying capability through the new classifying device.
- Variable frequency drive on high speed conveyor, air lift volume and velocity.
- Rated capacity: 3000 ~12000 kg/h (for lamina classifying), 1000~4500kg/h (for stem classifying)
- Rejecting rate: ≥80%



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HOT AIR CONDITIONING CYLINDER

Application

The hot air conditioning cylinder is used in the primary or secondary lamina conditioning stage of tobacco threshing and redrying line to process tobaccos with conditioning and temperature increasing, so as to meet subsequent process of lamina separating from stems.



CSSC Threshing & Redrying Line

Features and specifications

- Closed loop and fine tune control on temperature increasing and conditioning.
- Separated proportionally water spraying at both the feeding and discharge ends to process tobaccos with less over wet tobaccos.
- Efficient heat and humidity exchange through steam injecting in the circulating hot air to evenly increase the temperature of conditioned lamina without overheating.
- Vapor exhausting bypass set on the top of circulating air ducts to remove excessive vapor and keep the balance of heat and humidity.
- Cylinder jacking-up device available for protecting support roller in idle time.
- Observation window set at the discharge end.
- Rated capacity: 6000 ~18000 kg/h
- Discharge moisture content: 17~21% (Allowance: ±1)
- Discharge temperature: 50 ~ 70℃

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VERTICAL THRESHER

Application

The vertical thresher is mainly used to rip down the lamina from the tobacco leaf so as to separate laminas from stems automatically and continuously.

Features and specifications

- Vertically mounted threshing roller with combination of pneumatic classifying and threshing.
- Less occupied area and lower energy consumption.
- Convenient operation, safe and reliable control.
- Good tobacco leaf threshing performance.
- Rated capacity: 2500 kg/h
- Stem in lamina rate: ≤4%
- Lamina in stem rate: ≤ 1.5%
- Large-sized lamina rate(≥25.4mm): ≥32%
- Large and medium lamina rate (≥12.5mm): ≥70%
- Breakage rate (< 3mm): ≤ 5%
- Noise level of main body: ≤85 dB(A)

CSSC Threshing & Redrying Line



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HORIZONTAL THRESHING UNIT

Application

The horizontal threshing unit is used in the tobacco threshing and redrying line for separating lamina from stem of tobacco leaf by means of multi-stage mechanical threshing and multi-stage classifying, ensuring all indexes of separated lamina and stem meet certain technological requirements and the need for subsequent processing. The whole process is continuous and automatic.



CSSC Threshing & Redrying Line

Features and specifications

- Storage feeder with reversed doffer makes tobaccos feed in more evenly.
- Tobacco splitter with doffer and conveying belt (or doffer only) divides tobacco leaves into equal parts.
- Soft threshing technology applied on the array of horizontal threshing knives, size and structure of basket and rpm of threshing roller.
- Significant less in the weight of the thresher rollers with optimized array of threshing knives.
- Different shapes and sizes of baskets configured for each stage of threshers to get higher large and medium lamina rate and threshing efficiency.
- Recycle air flow for material classifying and air lift.
- Rated capacity: 3000-12000 kg/h (Calculation based on MC at 12%)
- Large lamina rate (>25.4mm): ≥56% (for premium Virginia tobaccos)
- Large and medium lamina rate (>12.7mm): ≥87% (for premium Virginia tobaccos)
- Stem in lamina rate (stem diameter > Φ1.5mm): ≤2.5%
- Lamina in stem rate: ≤1.5%
- Long stem rate (stem length > 20mm): ≥75% (for premium or medium Virginia tobaccos)
- Breakage rate (lamina <1/8"): ≤2%

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ENERGY-SAVING TYPE HORIZONTAL THRESHING UNIT

Application

The energy-saving horizontal threshing unit is used in the tobacco threshing and redrying line for separating lamina from stem of tobacco leaf by means of multi-stage mechanical threshing and multi-stage classifying, ensuring all indexes of separated lamina and stem meet certain technological requirements and the need for subsequent processing. The whole process is continuous and automatic.



CSSC Threshing & Redrying Line

Features and specifications

- Significant less in total length and occupied area comparing to the traditional threshing unit.
- Total energy consumption is 30% less than that of the traditional threshing unit.
- Applicable to both the Virginia and Burley tobaccos.
- Significant less in the weight of the thresher rollers with optimized array of threshing knives.
- Different shapes and sizes of baskets configured for each stage of threshers to get higher large and medium lamina rate and threshing efficiency.
- Classifier with a large classifying chamber and adjustable material throwing angle to achieve efficiently and precisely classifying under inertia and gravity force.
- Draw type installation of apron for convenient maintenance.
- All material transferring by belt convey among pneumatic classifiers reduces the breakage rate of tobacco leaves.
- Variable frequency control on motors of thresher roller and fan.
- Rated capacity: 3000-12000 kg/h (Calculation based on MC at 12%)
- Large lamina rate (>25.4mm): ≥56% (for premium Virginia tobaccos)
- Large and medium lamina rate (>12.7mm): ≥87% (for premium Virginia tobaccos)
- Stem in lamina rate (stem diameter > Φ1.5mm): ≤2.5%
- Lamina in stem rate: ≤1.5%
- Long stem rate (stem length > 20mm): ≥75% (for premium or medium Virginia tobaccos)
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LAMINA REDRIER

Application

The lamina redrier is used to dry the lamina after being separated with stems in the threshing and redrying line.



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Features and specifications

- Alternative air entrance from both sides of the drying zone to achieve even sectional drying strength, so as to reduce the moisture deviation of lamina paved on the left, middle and right part of apron during the drying process.
- Alternative air entrance from both sides of reordering zone to achieve even sectional eordering effect, so as to reduce the moisture deviation of lamina paved on the left, middle and right part of apron during the reordering process.
- Slowly drying at low temperature technology to reduce the shrinkage degree of lamina.
- Automatic lubrication system for apron chain.
- Rated capacity: 4800-9600 kg/h
- Discharge MC: 11.0~13.5%
- Standard MC deviation of discharge: ≤0.33%
- Pole MC deviation of discharge at left, middle and right part of apron: ≤0.8%
- Discharge temperature: 40~60℃



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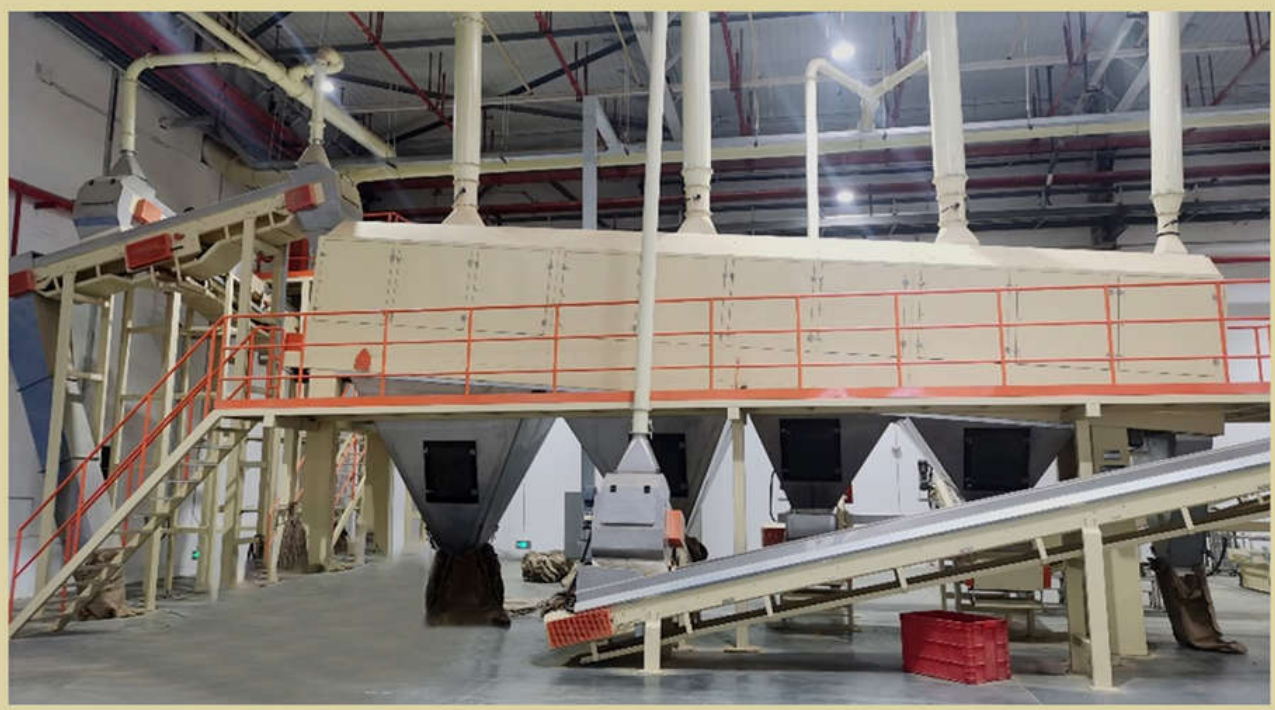
SIEVING CYLINDER FOR STEM GRADING

Application

The sieving cylinder for stem grading is used in the threshing and redrying line to automatically screen out the scraps, shorts, longs and butts as per specified process required size.

Features and specifications

- Combination of round and hexagonal sieve mesh structure for unique sieving performance.
- Single roller friction driven by the front or rear support roller.
- High sieving efficiency, low energy consumption, less occupied area.
- Seal rings set at both feeding and discharge end. Exhaust duct interface set on the hood to connect with dust removing system.
- Cylinder jacking-up device available for protecting support roller in idle time.
- Rated capacity: 800-5000 kg/h
- Cylinder rotating speed: 6-19 r/min (adjustable)
- Long stem qualified rate: ≥85%



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STEM REDIER

Application

The stem redrier is used in threshing & redrying line for removing excessive moisture in stem.

Features and specifications

- New material feeding and paving mode ensure materials being evenly paved on apron.
- Cooling zone is set to reduce the stem discharge temperature.
- Improved drive structure for better performance at higher productivity.
- Wide scope intelligent control system with networking and parameterization integrated.
- Protection device added to steam pipeline for improved reliability and longer service life of heater.
- Good and stable drying effect with wide adjustable discharge temperature scope.
- Less energy consumption and less flying dust generated.
- Rated capacity: 1700~3400 kg/h
- Discharge moisture content: 10~13%



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SCRAP DRYING CYLINDER

Application

The scrap drying cylinder is used in the threshing & redrying line for quick drying and removing moisture of scraps.

Features and specifications

- Cylinder with heat exchange thermal plate structure.
- Advanced combined drying technology with three heating modes: heat conduction, thermal radiation and compulsory hot air circulating, for quickly drying scraps and even discharge moisture content.
- Multiple parameters (cylinder RPM, hot-air temperature, hot-air volume and thermal exchange plate temperature) adjustable.
- Less area occupied and low energy consumption.
- Safe and reliable control, good drying performance.
- Rated capacity: 300~600 kg/h



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PRESS

Application

The press is used in the pre-press and packing section of threshing & redrying processing line to fill and pre-press redried lamina into a carton box.



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Features and specifications

- The main press ram is driven by gear motor. Totally free of hydraulic oil contamination risk on tobaccos.
- Less area occupied without hydraulic pump station required.
- Speed and hold on press for different process requirement can be achieved under enough press force condition.
- Optimized press head structure with special coating contact head surface for less adhesive material at return.
- Three stage material even-distributing technology, first stage distributing mode adjustable in real time as per online density detected result.
- Laminated pre-press and combined box filling technology makes total height of press lower than 11 meters.
- Digital weighing system set at four corners of press bottom to precisely control the filling weight of each box.
- Optimized design on structure and positioning mode of carton box positioning device to avoid box damage and achieve precisely positioning.
- Box sealing mechanism set at the lower part of discharge hood to reduce tobacco leakage.
- Dust exhaust port set on the top of discharge hood to avoid dust over flow.
- Compact structure design with less maintenance required.
- User friendly HMI with processing parameters settable.
- Rated capacity: 24 boxes/h (Single press ram)
  50 boxes/h (Twin press rams)
  60 boxes/h (Triple press rams)
- Inside box density variation rate (DVR): ≤8%
- Static weighing accuracy: ≤1.2kg

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LAMINA BALE PRESSING SYSTEM

Application

The lamina bale pressing system is used in the tobacco threshing & redrying line to pack, strip and stack lamina bale with low energy consumption and high automation.








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Features and specifications

- The system consists of a carton sleeve forming system, a press, a hold-down press, an automatic bagging machine, an automatic filling and spreading device, an automatic bag sealing and folding machine, an automatic lid flipping and pressing machine, an automatic strapping machine, an automatic labelling machine, a gantry clamping and stacking machine and some auxiliary equipment.
- Electric drive instead of hydraulic drive avoids contamination on tobaccos.
- Less energy consumption and convenient maintenance.
- Laminated pre-press and merged packing to achieve even bale density, which is helpful for tobacco aging and reducing the hard tobacco block volume.
- Can be seamlessly connected with the finished product warehouse.

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SILO

Application

The silo is used in primary processing line or tobacco threshing and redrying line for storing and blending of various tobacco materials.





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Features and specifications

- Silos with multiple working modes such as single in single out, single in double out, double in double out as well as silos with different structures such as single or double deck, tail to tail, nose to nose, big span are available for different process applications. Ultra wide silos (width of silo can be up to 6000mm) are designed for big volume tobacco blending recipe applications.
- A movable door with safety switch at front end of silo for equipment maintenance and cleaning.
- The access door on the rear end of silo convenient to observe the material inside.
- Push and pull design on the protective cover of the doffer drive chain for convenient maintenance.
- Silos with automatic seal structure available to effectively keep the temperature and moisture content of tobaccos in case of long time storage required.
- Lubrication free bottom belt drive chain available.
- Individual drive on doffer achievable.
- Stable structure, full safety precaution and convenient to maintenance.
- Bulking width: 800～6000 mm
- Bulking height: 800~2000 mm

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FEEDER

Application

The feeder is used in tobacco processing line for feeding tobaccos to downstream equipment in stable mode. It can work with the weighing conveyor or metering chute to control the material conveying at an even and constant flow rate.



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Features and specifications

- Steep conveyor chain with side nylon guide roller to reduce running noise level.
- Frame of tobacco box is wholly welding structure, which features nice appearance and high stability.
- Fan shaped glass window for setting material level detect photocells with large adjustable range.
- Direct-coupling main drive gear motor with compact structure.
- On-ground drawer type dust collect pan convenient for cleaning.
- Horizontal conveying sections set on both the top and bottom part of steep conveyor to reduce the return adhesive material and leakage.
- Width of conveying belt: 600～3500 mm.
- Rated capacity: 300～18000 kg/h (Calculation based on MC at 12%).

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WEIGHING CONVEYOR

Application

The weighing conveyor is widely used in primary processing line and threshing & redrying line to acquire material weight in real time or to precisely control the material flow with high accuracy, good stability and convenient maintenance.



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Features and specifications

- Direct weighing with 4 load cells and dual support rollers to replace the lever converting mechanism for getting direct and reliable load signal.
- Cantilever belt support structure enables the belt be rapidly replaced within 15 minutes.
- An unique tension device to keep the belt tension force constant.
- Integrated monitoring on multiple weighing conveyors.
- Conveyor belt width can be up to 3,600mm for massive material flow scenario.
- Window set on the side wall for convenient dismantle and cleaning roller.
- Load cells set on both sides of machine frame for convenient sensor adjusting and replacing.
- Rated capacity, kg/h: 300 ~ 18000
- Accuracy: ≤0.5% (For control type weighing conveyor)
  ≤1% (For proportioning type weighing conveyor)

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VIBRATORY (SIEVING) CONVEYOR

Application

The vibratory (sieving) conveyor is widely used in primary processing line and threshing and redrying line for conveying (or sieving) various tobacco materials.

Features and specifications

- Multiple structures like rocking arm, spring board and self-oscillation available.
- Full safety precaution, stable running and lower noise level.
- Cone sleeve expansion connection for quick dismantle of the drive and passive pulley when necessary.
- Hang mounted drive unit convenient for maintenance and lubrication.
- Cleaning door set at the tail of vibratory trough for cleaning convenience.
- Shock absorbing spring set between the support leg and frame of bigger vibratory conveyor.
- Rated capacity: 100 ~ 12000 kg/h





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BELT CONVEYOR

Application

The belt conveyor is widely used in primary processing line and threshing and redrying line for conveying various materials. It can realize multiple types of conveying such as horizontal conveying, inclined conveying, curve conveying and reversible conveying.



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Features and specifications

- Optimized structure of edge band and baffle for less material leak.
- Quick-disassembling structure design on drive roller, passive roller, support roller and brush roller for less maintenance work required.
- Dust collect tray set at the bottom of conveyor.
- Exhaust duct interface set on the hood of discharge end to contain dust.
- Belting materials contacting tobaccos are of food grade.
- Multiple structure conveyors are available for options such as DPH, DUC, DUL, DPM.
- Less material leak, convenient maintenance and elegant appearance.
- Rated throughput capacity: Up to 16000 kg/h
- Incline angle of belt conveyor: 0°~25°
- Central distance between the drive roller and passive roller: 2~40 m
- Width of belt: 400～1600 mm

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LIFTER

Application

The lifter is used to lift the material up or down to a desired position for transferring the material to the upstream or downstream equipment.

Features and specifications

- Travel switches are set on the vertical mast to ensure the lifting carrier run in working range.
- The lifter drive motor with brake.
- Bumpers are set both at the top frame and bottom ground to catch the lifting carrier accidently running out of limit range.
- Lifting chain break detection device and over-speed brake function set for safety precaution.
- With a maintenance platform at the top.
- Maximum pay load: 500 kg
- Lifting speed: 24/30 m/min (full load/without load)

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