

RAJOO ENGINEERS LTD. Five Layer Blown Film Line Model:-RECF-2550-40-1800



MACHINE OVERVIEW									
Time Total Set Output Total Act Output Thickness Set (μ) Act (μ) Density L.S. Set L.S. Act GSM Layflat							Layflat		
18:10:22	210.00	210.70	101.00	100.93	0.92	15.83	15.89	92.86	1190.00

IBC Temperature							
Time	Time IBC In Temperature IBC OUT Temperature						
18:10:22	0	0					

Winder							
Time	Name	Totalizer	Roll Length	Roll Dia			
18:10:22	Winder-1						
18:10:23	Winder-1						

			Layers				
Name Name	Speed(Rpm)	Set Thickness	Act Thickness	Yield	Amp. (A)	Melt Temp. (°C)	Melt Pressure(Bar)
Layer-1	88.66	30.30	30.26	0.71			
Layer-2	98.01	12.37	12.30	0.26			
Layer-3	54.89	14.65	14.62	0.56			
Layer-4	87.61	12.37	12.37	0.29		•	
Layer-5	90.81	31.31	31.32	0.72			

	EXTRUDER-A						
Comp. Name	Set (%)	Act (%)	Densit y	Set Weight (Kg.)	Act Weight (Kg.)	Total Weight (Kg.)	
F18010	85.00	85.05	0.92	2.55	2.54	132131.82	
LD	0.00	0.00	0.92	0.00	0.00	14397.31	
F19010	0.00	0.00	0.92	0.00	0.00	12014.69	
PPA705	15.00	14.95	0.92	0.45	0.45	9905.77	
		DATE:2025-06-07					

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			EXTI	RUDER-A T	EMPERAT	URE		
Time			Zone Name		Set Temperature(°C)		Act Temperature(°C)	
18:10:23			Barrel Zone-1		0		0	
18:10:23		Barrel Zone-2				0		0
18:10:23			Barrel Zone-3			0		0
18:10:23			Barrel Zone-4			0		0
18:10:23			Barrel Zone-5			0		0
18:10:23			Screen Chnager			0		0
18:10:23			Adapter			0		0
18:10:23			Adapter-1			0		0
		=		EXTRU	DER-B			
Comp. Name	Set	(%)	Act (%)	Density		Set Weight (Kg.)	Act Weight (Kg.)	Total Weight (Kg.)
F19010	40	.00	39.85 0.9		92	1.20	1.20	31144.18
F18010	20	.00	20.31	0.9	92	0.60	0.61	11338.33
RP	30	.00	30.10	0.9	92	0.90	0.90	17162.38
46003.00	10	.00	9.75	0.9	92	0.30	0.29	7321.17
			FXTI	RUDER-B T	FMPFRAT	URF		
Time			Zone Name		Set Temperature(°C)		Act Temperature(°C)	
18:10:23			Barrel Zone-1			0 0		0
18:10:23			Barrel Zone-2		0		0	
18:10:23		Barrel Zone-3			0		0	
18:10:23		Barrel Zone-4			0		0	
18:10:23		Barrel Zone-5			0		0	
18:10:23	Barrel Zone-6			0		0		
18:10:23			Screen Chnager		0		0	
18:10:23			Adapter			0	0	

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				EXTRU	DER-C			
Comp. Name	Set (%	5)	Act (%)	Density		Set Weight (Kg.)	Act Weight (Kg.)	Total Weight (Kg.)
F19010	65.00)	65.15	0.92		1.95	1.94	44319.87
Metlocine	0.00		0.00	0.9)2	0.00	0.00	17076.62
RP	20.00)	19.94	0.9)2	0.60	0.59	13294.41
F19010	15.00)	14.95	0.9)2	0.45	0.44	8297.65
				RUDER-C T		_	T	
Time			Zone Name		Set '	Temperature(°C)	Act Temp	erature(°C)
18:10:23			Barrel Zone-1			0	0	
18:10:23	18:10:23		Barrel Zone-2	0		0		
18:10:23		Barrel Zone-3			0		0	
18:10:23			Barrel Zone-4		0		0	
18:10:23			Barrel Zone-5		0			0
18:10:23			Screen Chnager		0			0
18:10:23			Adapter			0	0	
			Adapter-1		0		0	
				EXTRU	DER-D			
Comp. Name	Set (%	5)	Act (%)	Den	sity	Set Weight (Kg.)	Act Weight (Kg.)	Total Weight (Kg.)
F19010	80.00)	79.99	0.9)2	2.40	2.40	41700.30
46003.00	0.00		0.00 0.92)2	0.00	0.00	1005.57
Metlocine	10.00)	10.28	0.92		0.30	0.31	14475.39
LD	10.00	10.00 9.73 0.92		0.30	0.29	4699.97		
					_	_	_	
			DATE:2025-06-07					

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excellence in ext	rusion		<u> :-RECF-2550</u>		excelle	nce in extrusion
			RUDER-D TEMPI	_		
Time		Zone Name		Set Temperature(°C)	Act Temperature(°C)	
18:10:23		Barrel Zone-1		0	0	
		Barrel Zone-2		0		0
18:10:23		Barrel Zone-3		0		0
18:10:23		Barrel Zone-4		0		0
18:10:23		Barrel Zone-5		0		0
		Screen Chnager				
		Adapter				
		Adapter-1				
			EXTRUDER-I	E		
Comp. Name	Set (%)	Act (%)	Density	Set Weight (Kg.)	Act Weight (Kg.)	Total Weight (Kg.
F19010	60.00	60.16 0.9		1.80	1.79	74451.26
LD	15.00	15.20	0.92	0.45	0.45	21766.13
Metlocine	15.00	14.67	0.92	0.45	0.44	58367.82
46003.00	10.00	9.97	0.92	0.30	0.30	27480.48
		EXTR	RUDER-E TEMPE	ERATURE		
Time		Zone Name		Set Temperature(°C)	Act Temperature(°C)	
18:10:23		Barrel Zone-1		0	0	
18:10:23		Barrel Zone-2		0	0	
		Barrel Zone-3		0	0	
18:10:23		Barrel Zone-4		0	0	
18:10:23		Barrel Zone-5		0		0
18:10:23		Screen Chnager				
		Adapter				
		Adapter-1		TIME:18:10:22		

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DIE TEMPERATURE							
Time	Time Zone Name Set Temperature(°C) Act Temperature						
18:10:23	Die Zone-1	0	0				
18:10:23	Die Zone-2	0	0				
18:10:23	Die Zone-3	0	0				
18:10:23	Die Zone-4	0	0				
18:10:23	Die Zone-5	0	0				
18:10:23	Die Zone-6	0	0				
18:10:23	Die Zone-7	0	0				
18:10:23	Die Zone-8	0	0				
18:10:23	Die Zone-9	0	0				
18:10:23	Die Zone-10	0	0				
18:10:23	Die Zone-11	0	0				
18:10:23	Die Zone-12	0	0				