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ALGERIA

Couscous Pasta Line with the Production Capacity of 1000 kg/h

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A – COUSCOUS PASTA PRODUCTION LINE with PRODUCTION CAPACITY of **1000 KG/H**

A.1 – AUTOMATIC SEMOLINA MIXING SYSTEM

Unit Consists;

- Semolina cyclone mounted on press
- Pre-mixer / fastmixer
- Water dosing system
- Main kneading trough with double paddle
- Press platform

A.1.1 – VOLUMETRIC SEMOLINA FEEDING UNIT

Consisting of a sensed cyclone which has alarm system if the level of semolina decreases. System of the unit is specially equipped with openable covers for casual maintenance/cleaning operations.

A.1.2 – VOLUMETRIC SEMOLINA DOSING

Semolina is the main raw material of pasta production.

- Can be adjusted to the desired capacity by spiral operated with an inverter (Yaskawa Control Techniques)
- Made of stainless steel material, AISI 304 quality
- All controls are provided by means of local control panel which connected to the main control panel located on the press unit
- Reducers supplied from Turkish brand “YILMAZ / IMAK”
- Electric motors supplied from Turkish brand “GAMAK / VOLT”

A.1.3 – WATER DOSING UNIT

- 1-way pneumatic water circuit.
- Plastic pipes
- Thermometer and manometer.
- Sensitive water dosing by diaphragmatic dosing pump.

A.1.4 – FAST MIXER-TLA – P

Made of AISI 304 stainless steel material and has following characteristics;

- Front covers –easy-to-open
- Mixer with paddles
- Side-opening covers specially designed for mechanic safety.
- Electric motors supplied from Turkish brand “GAMAK / VOLT”
- Liquid inlet with double-entry
- Semolina inlet from the Semolina dosing unit

A.1.5 – MAIN TROUGH

- Adjustable kneading paddles, made of AISI 304 stainless steel material.
- Stainless steel shaft.
- Dough residues occurred on the inner surface of the trough always can be cleaned by stripping pallets located on the edge of the main shaft.
- Chrome made covers for kneading trough and safety switches.
- Special designed thrust-bearing lubrication system.
- Dough touching surfaces are coated with AISI 304 stainless steel material.
- Reducers supplied from Turkish brand “YILMAZ / IMAK”
- Electric motors supplied from Turkish brand “GAMAK / VOLT”

A.2 –STEAM COOKER

Unit consists;

- 1 layer steam cooker with stainless steel band
- The production of couscous-contact surfaces made of AISI 304 material.
- 40 mm thick side and top panel consisting poliester cabinet.
- Side panels can be opened completely.
- The skeleton made of AISI 304 material.
- The steam System Control 4-20 mA is proportional control system (Siemens, Germany).
- Necessary fresh and clean air is obtained with the help of aspirator (exhaust fan)
- Hot air is produced by shaker with the help of serpantines
- Heat control is provided by probe
- The heat coils are flanged and equipped with steel pipes.
- Steam aspirator
- Steam cooker is mounted with height-adjustable feet.

A.3 – DRYING UNIT – HM-R 12/20

Rotante width: 3500 mm

Length: 12 meters

20 sections

Unit consists;

- Rotante movement motors controlled by inverters (Yaskawa Control Techniques)
- Product inlet equipped with vibrating system
- Stainless steel structure on adjustable legs
- Appropriate internal climate (temperature and humidity)
- Polyester cabin combined with lateral and top panels with 40 mm thickness

- Lateral panels can be fully opened
- Whole structure made of AISI 403 steel
- Operated by aluminium fans and axial fans with electric motors
- Hot water controlled by proportional 4-20 mA control system and 3-way valve (Siemens/Germany)
- Hot water the machine needs provided by a hot water pump
- Clean air provided by an aspirator
- Controlled by proportional servo-motor air clap (Siemens/Germany)
- Hot air the machine needs provided by means of serpentines
- Product moves with special design AISI 304 quality spirals
- Electric motors with IP 55 protection level and F class insulation
- Temperature control and measurement of humidity of drying section provided by a probe located on the dryer
- Electric panel boards are designed and manufactured in accordance with IEC norms
- Monitoring by a PC and PLC top-class automaton system to operate and control all functions
- 1 row flanges heating serpentines – PN 16 mounted in front of the clean air inlet claps
- Flanged heating batteries and equipped with steel pipes
- Control and safety devices
- Steel pipes and joints

A.4 – COOLING UNIT

The couscous in the hot state is cooled by helps of fan on the cooling unit section and the praticles are sent to the control sieving to seperated.

- Single layer vibratingsystem
- Product touching surfaces made of AISI 304 steel
- Polyester cabin combined with lateral and top panels with 40 mm thickness

- Lateral panels can be fully opened
- Whole structure made of AISI 37 steel
- Operated by aluminium fans and axial fans with electric motors
- Hot water controlled by proportional 4-20 mA control system and 3-way valve (Siemens/Germany)
- Circulation provided by means of a circulation pump
- Flanged cold water batteries equipped with steel pipes
- Temperature control provided by means of a probe

A.5 – Square Plansifter

The part to be subjected to the desired particle separation of the couscous

Through the body and different size Frames in each passage in body is shaking by free action to provide the clean and arranged shape that classifying the grinded product.

- After sieve and homogeneous separate the product various rates automatically goes to outlet channel through the channels in frame, channels between frame and channel in main chassis and unload product with control pipes to the out of outlet pipes.

Frames surface are covered by formica. Passage external covers are insulated thereby prevent the semolina particles missing

- Put the spacer between frame spaces of main spaces to expand the product outlet capacity prevent the blockage and provide the enough level product flowing

- Plansifter external body fitted on factory chassis with hanging (flexy) bars. Product inlet provide from plansifter top part. Product outlet provide from bottom part of plansifter.

A.6 – WALTZ

The control system we used to bring the desired particle size back into large pieces of particulate matter

Specifications:

- All controls are made by pneumatic valves and no need to use electricity.
- The valves are warned according to coming product and pistons are shut and feedrolls start to move.
- Through the aluminium sheet feedrolls amount of product can be set up, among rolls comes flow as curtain.
- Cleaning of milling rolls is with brushes below and block the accreting of product.
- when product flow finish, warner valve moves again and gives movement to piston and provide to separate the rolls and stop of feedrolls.
- Gears which forward movement are helical and work with less voice and forward high power with vibrating.
- Parallelism set of rolls are made with set valves which are front
- Amper which machinery get when operate can be seen at ampermeter on panel.

A.7 – RESTING SILOS

Number of silos: 3 x 15 m³ =36 m³ silo.

Total capacity approximately: 18 tons

Additionally:

- 1 piece aspiratör for transportation couscous
- 1 piece 1 portable double acting valve
- Vibrating bottom covers

A.8 – THERMAL CONTROL CENTER

450.00 kcal/s heat energy obtained by boiler as the system needs.

Unit consists;

- Necessary materials and insulation
- Hot water pipes and pumps
- Expansion tank
- Water boiling system with boiler

- ❖ **HEATING INFRASTRUCTURE of the LINE WILL BE DESIGNED in ACCORDANCE WITH the CUSTOMER PREFERENCE of FUEL USAGE**

A.8.1 – Spiral Piped Steam Generators

This unit meets the steam necessity of the couscous line.

The Steam Generators are vertical type compact products. The generator is able produce high quality steam at the desirable level of pressure in a few minutes. The generator is produced with water pipes with a special design. There is not a blockage risk for this patented design because of the body part is made up of many water pipes.

In the process when the steam is ready to use it is transmitted through another special dryer pipe system in order to remove all the water from the device. One of the most significant feature of the Steam Generator is its design that allows energy saving from the chimney gas with high quality steam output. The generator can be mounted any place. There are no restrictions for using it in a building because of its lowered water volume.

The device is offered as a package on a whole chassis including the body, burner, condensation tank, level indicator, electricity panel and water decalcifying unit. Assembling, disassembling and maintenance are extremely practical. System inside the hatchway is covered with 50 mm. rock wool for isolation and hatchway is painted 1 mm thick with static dust paint. In case of need the hatchway (cover) can be removed easily. The isolation helps to conserve and gain maximum effort from the heat inside the body.

You can choose a liquid fuel or a gas fuel burner according to the fuel type that you are planning to use.

With its compact electric panel the device can be used fully automated and highly secured.

A.8.2 – SET of INTERNAL FITTING MATERIALS

Set of material to apply the following connections (pipes and accessories)

- Thermal station, cooling system and internal connections of vacuum system
- Superheated water distribution

B – GENERAL CONDITIONS for MAIN CONTROL PANEL, ELECTRIC SWITCH BOARD and AUTOMATION SYSTEM

All functions controlled by a PLC computer assembled inside the control panel and an operator interface to manage the electric panel and the whole production of the line by a desktop computer which has the graphic software.

Button console mounted on press platform controls dosage/measurement system of raw material by means of its alpha-numeric interface, beside provides to control product extrusion and forming.

B.1 – INSPECTION and CONTROL

Can be conducted by graphic control system beside automation equipment.

Items of control system:

- High-performance PC
- 22' colour wide screen
- Scada system
- Operating system: WINDOWS 7 Sp1.

B.2 – ELECTRIC PANEL

Components of the panel:

- Electrostatic painted special made electric cabins from “EAE” brand
- Cabin and terminal box, local paint of the cabin “RAL 7032” and protection class IP 55. External terminal box and other junction boxes. All internal panels are galvanised
- Schneider and/or Siemens brands are used in the whole electric system
- Brands used in electro-mechanical equipment of command/control system (magneto-thermic, circuit breakers, etc.) chosen from the worldwide brands like Vipa, Schneider, Siemens, Pheneix, etc.
- Inverters for motor speed management from Schneider brand or equivalent brand
- Semolina dosing motor; Press helix motors, electro-pump motors
- Schneider or Siemens brands used in PLC for automation management
- Alpha-numeric colour operator interface mounted on the shutter

B.3 – AUTO-CONTROL SYSTEM/RAW MATERIAL DOSAGE MANAGEMENT

- Dosage system works automatically depending on planned recipe. Liquid entries managed by an appropriate PID with auto regulation, another PID algorithm measures the semolina dose. Semolina and water rates memorized by the system automatically.
- System sets the appropriate capacity of semolina automatically. Thus, adjusted mixture rate can be stabilized.
- Except the automatic adjustment of dosing rates between water and semolina, system also stabilise pressure of the extrusion spiral on the adjusted level.
- Values of operating variables can be monitored on the screen of operator panel. Every functioning above mentioned can be dosed by manually.

B.4 – MANAGEMENT of PRESS

B.4.1 – PRESS

Automatic cycle of the press which can be adjusted by the operator consists of 2 phases;

Filling: Start of all kneaders with screws at a standstill until max level set is reached in the vacuum kneader.

Discharge: Discharging of the dough comes from kneading trough while kneaders are working actively.

- In the event of drier standstill, the press will come to a stop during the cutting stage and re-starting of the machine will go into phase automatically.

Press completely controlled automatically by PLC. Some of functions controlled by PLC;

- Tank fillings
- Initial dough discharging

B.4.2 – DOSING

- Volumetric semolina doser operated automatically and controlled by inverters (Yaskawa Control Techniques)
- Flow-meter system for water dosing

B.5 – MANAGEMENT of DRYING UNIT

B.5.1 – DRYING

- System provides to control drying process by making temperature and delta adjustments in some transition areas within the whole line.
- System controlled by a control programme installed in PLC. There is also an operator interface with functions can be used by personnel in inception and/or alarm case.
- Temperature levels in variable water batteries and heating radiators monitored by PT 100 probes while variable temperature and humidity values in different climatic zones transmitted to the PLC by GENTEK brand probes.

- Delta T values are calculated depending on temperature and humidity values which gained by the probes.

Activities in production and drying sections managed automatically. Particularly;

- Required settings, fan motors, driving motor and automatic start of the line by activation of all functions related to presence of the product in different control areas
- Maintenance management in case of stopping the production
- Automatic adjustment of parameters in case of format changing during operation.
- Automatic management of the uses stop (Motor, fans, regulators) in emptying line phase for end production.

All functions and mechanic drivers of components related to automatic management of operation parameters of drying unit controlled by means of PLC.

- Start of the line by activation of the aeration fan motors and climatic control system
- Management of the line in alarm mode
- Management of discharge operation for ending production

System automatically makes adjustment of parameter settings for above mentioned functions to provide the maximum product quality.

B.5.2 – CLIMATIC CONTROL

All climatic zones controlled by PID in accordance with parameters set by operator.

The following functions are restricted;

- Modifications on transfer stages are restricted to protect the product quality
- Maximum mA value of hot water valve
- Settings and regulations of PID parameters of regulators

B.6 – AUTOMATIC MANAGEMENT of the PRODUCTION PROCESS

B.6.1 – FUNCTIONING

All the following functions managed by the PC located in the control room. Besides mentioned above, the automation system functionalizes following features;

- Generating, pre-setting and modifying operations for each recipe
- Format change function allows the operator to make adjustments on PID and limit values depending on the position of the product inside the line
- Management of product lots
- Automatic start of the line
- Visualization of the geographical position of the product in the line.
- Shutting down of the line
- Modifying and setting the processing parameters of the line manually. Data recording of the shapes produced
- File management of the dies with automatic calculation of the hours of use for every die
- Recordings all values of production process (temperature, humidity, amount of production, etc.) to a special database which displays instantaneous and past trends
- Recording of the processing value histograms
- Possibility of analysing all processing data from a PC
- Password protection to the changes of data
- Major parameters can be protected by setting password to the access page of those parameters.
- Time of alarm
- Number of alarm
- Efficiency of the line

B.6.2 – DISPLAY and MONITORING

- Whole line and ancillary equipment can be displayed on colour screen pages
- The top-quality graphics utilized are of easy intuition by any user
- Several climatic zone pages are also displayed which show the current status of the valves and trend charts

B.6.3 – HISTORICAL ARCHIVE MEMORY

Thanks to this system, process records can be stored, all main variables can be displayed and printed, and necessity interventions to the historical archive can be done.

- If you set the period you interest in, you can retrieve a list of all alarms or a list of alarms per category.
- If you click on the graphic archives, you can visualise saved trends and you can zoom in on the different areas of the graphs in order to identify the slightest of variations.

B.7 – FUNCTIONALITY of PRODUCT QUALITY MANAGEMENT

- System of the supervision programme provides support for product quality control
- The present product in the line is divided in lotteries identified by their position inside the same line
- With reference to determined events is possible to effect automatically a selection of that product that, having suffered a different process drying from the standard, could result not conforming
- Each preselected pasta shape inside the line has its own unique colour
- When the selected product reaches the packing unit, is possible to produce a signalling to recall the attention of the operators employed to the control of the quality for the opportune device to be adopted
- Preselected products might be affected by operator interventions

B.8 – REMOTE ASSISTANCE

- Thanks to the automation system which includes telephone, modem and a PC, remote assistance can be made urgently
- Internet connection must be provided by the buyer
- The connection must always to be activated by the present operators on the plant
- The service is free furnished (excluded the cost of the telephone connection) during the guarantee period (2 years)

C – POWER CONSUMPTION DETAILS of the PRODUCTION LINE

REQUIRED THERMAL POWER	400000	kcal/h
CHILLER	40000	
HOT WATER INLET TEMPERATURE	110	°C
REQUIRED ELECTRIC POWER	100	kw
WATER for DOUGH	300	l/h
REQUIRED STEAM POWER	70	kg/h

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D – PRICELIST

Quantity	COUCOUS PASTA PRODUCTION LINE with PRODUCTION CAPACITY of 1000 kg/h	EXW (Exwork) GAZIANTEP PRICE (EURO)
1	Automatic Press <i>HMP</i>	
2	Cooker	
1	Drying Unit – <i>HM-R 12/20</i>	
1	Cooler	
1	Waltz	
1	Resting Silo	
1	Thermal Control Centre(Boiler)	
1	Spiral Piped Steam Generators	
1	Set of Internal Fitting Materials	
1	Main Control Panel (PLC – Automation System)	
1	Installation and Inspection Services	

TOTAL: 1.260.600.00€

E – MANUFACTURE and INSTALLATION

E.1 – MANUFACTURE and INSTALLATION PERIOD

- Period of manufacture is 210 working days after receiving the advance payment.
- Installation and start up period is 90 working days.
- The electrical connections of systems' equipment must be covered at the inside of the building only.
- Except the outer lightning of the equipment, all converters, low tension transformers, underground cables must be inside of the building (inner plant and outer lightning are excluded).
- The potable water installation which is required for the plant is at the responsibility on customer.
- CONDIN'SUPPLIER Makina will not have responsibility for delay which might affect negatively the installation period because of the delay of supply of the necessities and equipment which must be provided by the customer.
- Lifts, forklifts etc. and other necessary equipment for unloading off the trucks and transfer to the site will be provided by the customer.
- The necessary workmanship support to the CONDIN'SUPPLIER Makina's technicians will be held by the customer.
- Main control panel is controlled by touch screen automation system.
- Air conditioned control panel is controlled by touch screen PID automation system.
- The offer is valid for 60 days

E.2 – TRAINING of LOCAL STAFF

All mentioned equipment, devices, tools, etc. included in this proposal will be installed by our technicians.

Mechanical Installation;

Mechanical installation of the line will be conducted by our technicians with the help of following numbers of local staff who must be provided by the buyer;

- 5 local staff

Electronic installation;

Electronic installation of the line will be conducted by our technicians with the help of following numbers of local staff who must be provided by the buyer;

- 2 electricians (with their own tools and equipment)

Hydraulic Installation;

Hydraulic installation of the line will be conducted by our technicians with the help of following numbers of local staff who must be provided by the buyer;

- 3 local plumber (with their own tools and equipment)

Functioning test;

This test is not a production but only to see that the mechanical, electronical and hydraulic components of the line works perfectly as planned, and this will be conducted by our technicians.

Test of Technological Components;

This test will be conducted by our technicians to see that all the technological components of the line work perfectly as planned.

- ❖ **Our technicians will test the line during 10 days only with one pasta die (one of the dies given within the line) .**

F – WARRANTY

F.1 – TERMS of WARRANTY

Semolina is obtained from durum wheat to produce Couscous Pasta Product,

- The guarantee of machines and equipment is 24 months from the beginning till start-up of the system.
 - Customer should conform instructions and obligations to operate the line within warranty. Seller will not be responsible for any material wear that cause defects, negligence and professional faults within maintenance and operation in case of improper use.
 - The necessary maintenance and lubrication instructions during the warranty will be given by a chart and customer has to strictly comply these instructions.
 - The warranty will be invalid in case of any modifications which might be made without confirmation of CONDIN'SUPPLIER Makina.
 - The couscous line works as continuous system.
 - The control panel and electrical motors will be chosen from CE certificated brands and suppliers.
- ❖ **The offer is valid for 60 days.**
- ❖ **Without explicit applications, how much described in offer will be built according to the Normative of European Union.**

F.2 – PAYMENT TERMS

Payment cash or 100% confirmed irrevocable "L/C" with a first-class bank account and must be confirmed by letter which covers the whole period of manufacture, partial shipments, etc.

- 50 % in advance beginning with the sign of the contract
- 40 % before shipment
- 10 % in when the installations start, before test production
- Delivery is based on EXW(Exwork) Gaziantep / TURKEY

EXCEPTIONS (BELONG to the BUYER);

- The flight tickets and in-country transfers from/to airport, hotel, industry zone, etc.
- Accommodation (hotel and food) and telephone calls.

F.3 – USE Of raw material

Producti

- 100% durum wheat semolina

DURUM WHEAT SEMOLINA
Humidity 14,5% max.
Ash content 0,9 % max.
Proteins 11-14 % the rate of quality protein

GRANULOMETRY	MIXING RATE
< 500 µm	8%
< 425 µm	22%
< 355 µm	33%
< 300 µm	23%
< 250 µm	7%
< 150 µm	2%

The production capacity of the line is to be conventionally referred to;

- Dry product, with final humidity not superior to 12,5%.
- Continuous and uninterrupted production of the guaranteed shape for 24 hours.

The guaranteed production capacity depends also on the following conditions;

- Semolina

Furthermore;

- Minimum protein (dry substance) content: 11.5 %
- High protein rate
- Absence of grains with size above 600 microns
- Product humidity 14,5%
- Free from suspended solid substances having dimensions bigger than 5 microns.
- Presence of chlorides: less than 30 p.p.m.
- Potable, colourless.
- Minimum pressure 1,5 bar, maximum 2 bar.

Water to be used, having chemical and physical characteristics conforming to the norms of the World Health Organization

Hot water; no lower than 110°C, for feeding of all technologic heating control systems present in the line.

- The line is able to produce different pasta formats, also when additives are added during kneading.
- The line nominal productive capacity could undergo some changes in operation depending of additive type and quantity.
- Any equipment of additives is not included in the offer

Environmental conditions in the pasta factory;

- ❖ **Temperature must not be lower than 28°C and a relative humidity must be at a value between 50 and 65%. The buyer must provide this environment inside the factory.**

G-BRAND DETAILS of MECHANIC/ELECTRONIC COMPONENTS

G.1 – MECHANICS

1 st BRAND	2 nd BRAND	AREA of USE	ORIGIN of MANUFACTURER
ERANSAN	ÖZMAKSAN	Boiler and the other equipment for the boiler room	TURKEY
UNIGAS	BALTUR	Burner	ITALY
MALKAN		Steam systems (steam generator, steam injectors etc.)	TURKEY
YILMAZ REDÜKTÖR	İMAK	Reducers for dryer	TURKEY
GAMAK MOTOR	VOLT	Fan motors of dryer	TURKEY
HCH FAN	POLİMAK	Aspirators of dryer	TURKEY
KSB	NORM	Hot water pump	TURKEY
PANKENS	PANKENS	Thermometer of vacuum lock	TURKEY
YILMAZ REDÜKTÖR	İMAK	Main helix of press unit	TURKEY
TALİA	TALİA	Flour/semolina conveying system	TURKEY
SIEMENS	SAMSON	Hot water control valves	GERMANY
SIEMENS	BELIMO	Aeration control valves	GERMANY
STANDART PUMP	NORM	Pump for the boiler room	TURKEY
ELİMKO	GENTEK	Temperature and humidity measuring sensors	
HASER PUMP	DEKO PUMPS	Water mono-pump	TURKEY
GAZİ COOLER		Chiller	TURKEY
TERMO	UNIVAL	Dryer valves	TURKEY
EKOMAK	AYDIN TRFO	Compressor	TURKEY
KROHNE	SMETER	Flow-meter	GERMANY/TURKEY

G.2 – ELECTRONICS

1 st BRAND	2 nd BRAND	AREA of USE	ORIGIN of MANUFACTURER
VIPA	SIEMENS	PLC and SCADA systems	FRANCE/GERMANY
YASKAWA	CONTROL TECHNIQUES	Inverters	FRANCE/JAPAN
SICK	OMRON	Sensors	GERMANY/JAPAN
SICK	OMRON	Pressure transmitters	GERMANY/JAPAN
SCHNEIDER	WEIDMULLER	Ethernet switch	FRANCE/GERMANY
FIYAMA		Relays and probes for water level	ITALY
SIEMENS	SCHNEIDER	Control transformers	FRANCE/GERMANY
SIEMENS	SCHNEIDER	Circuit breakers	FRANCE/GERMANY
SIEMENS	SCHNEIDER	Contactors and termic	FRANCE/GERMANY
SIEMENS	SCHNEIDER	Selector switch	FRANCE/GERMANY
SIEMENS	SCHNEIDER	Motor protection relays	FRANCE/GERMANY
SIEMENS	SCHNEIDER	Timers	GERMANY
SIEMENS	SCHNEIDER	Keyboard	FRANCE
WEIDMULLER		Relay plates and lugs	GERMANY
EAE	PAMAKS	Cabins	TURKEY / TURKEY
WEIDMULLER		Power sockets	GERMANY
SCHNEIDER	SIEMENS	Main switch	FRANCE/GERMANY
PHANNENBERG		Aeration fans of electric panel	GERMANY
WEIDMULLER	ENTES	Terminal connectors	GERMANY/TURKEY
HES	SEVAL	Electric cables	TURKEY/ TURKEY