

DUAL DOWNSTREAM EXTRUSION LINE

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YOUR FIRST *LINE* OF DEFENCE... ...AGAINST SAGGING PROFITS.

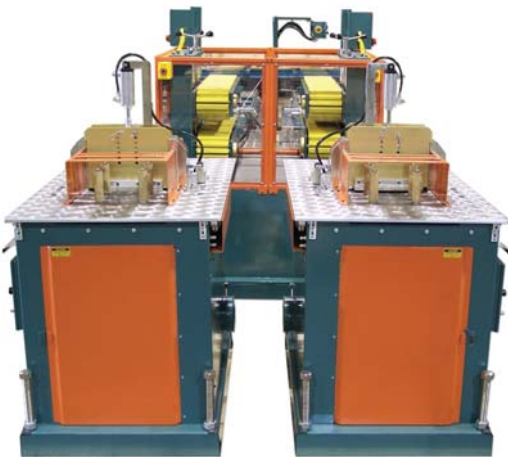
Rising material costs, cheap overseas imports, and an increasingly competitive market are dampening the profits of many plastic extruders. To compensate, some are resorting to lower-cost alternatives in materials and machinery, while others are seeking more efficient and profitable processing techniques. CDS's dual downstream lines enable high-output extruders to maximize the processing efficiency of their applications while still meeting the quality and delivery demands of their customers.

- Run two identical or unique applications on one platform
- Configure each line independently
- Double your extruder throughput
- Economize space on your plant floor
- Maximize your investment return on capital equipment

- ▶ Fence
- ▶ Window
- ▶ Siding
- ▶ Decking

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DUAL DOWNSTREAM EXTRUSION LINE

VACUUM CALIBRATION TABLE

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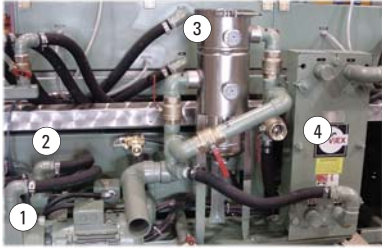
CDS's vacuum calibration tables provide a flexible platform for sizing rigid polymer profiles, such as window frames, fencing panels, and decking boards. CDS's dual vacuum calibration units are available from 4 to 15 meters in length (inclusive).

Standard configurations (per side)

- Vacuum outlets: 32 -128
- Vacuum pumps: 2 - 8
- Horsepower: 15 - 67.5¹ Hp
- Water outlets: 2 - 30
- Tooling rail center: 14 in. {355.6 mm}
- Tooling rail height: 36 in. {914.4 mm}
- Y-block centerline: 17 in. {431.8 mm}
- 3-axis precision movement
- Cyclone air/water separators
- Pendulum or front-mounted operator station
- Integrated remote control for cleat puller
- Full length operator step

1. Quantity of pumps x Horsepower

Water recirculation system (optional)



1. Process pump (5, 7.5, or 10 Hp)
2. Reservoir tank
3. Basket filter
4. Heat exchanger (Plate & frame; shell & tube)

Additional options

- Mushroom switch
- Vacuum pump extraction slides
- Digital display for water temperature and pressure
- 12 in. {304.8 mm} removable extended service pan

Unit length {m}	Model	Vacuum pumps (Qty x Hp)	Vacuum outlets
6 ft. {}	CVC-6D	1 x 5	13
13 ft. {4}	CVC-13D	2 x 7.5	32
16 ft. {5}	CVC-16D	3 x 7.5	48
20 ft. {6}	CVC-20D	3 x 7.5	48
23 ft. {7}	CVC-23D	3 x 7.5	48
26 ft. {8}	CVC-26D	4 x 7.5	64
30 ft. {9}	CVC-30D	4 x 7.5	64
33 ft. {10}	CVC-33D	4 x 7.5	64
36 ft. {11}	CVC-36D	4 x 7.5; 2 x 10	96
50 ft. {15}	CVC-50D	5 x 7.5; 3 x 10	128



The unit's 1/4" thick stainless steel mounting tooling rails are designed with a truss configuration to ensure alignment accuracy and stability of the extruded product.

Vacuum, water, and ball valve outlets



Auxiliary Vacuum Tank (optional)



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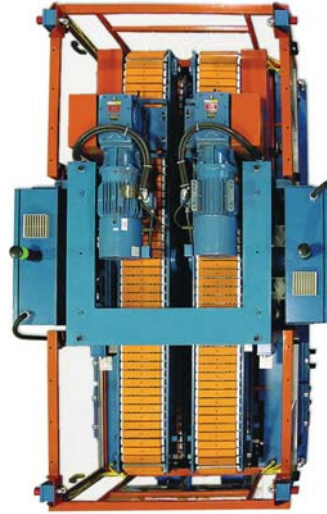
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DUAL DOWNSTREAM EXTRUSION LINE

► CLEAT PULLER

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CDS's cleats are interchangeable and can be machined to match the unique profile and cross section of the extrudate.

Standard configurations (per side)

- Contact width : 10 in. {254}
- Contact length: 60 {1524 mm} to 120 in. {3048 mm}
- Maximum conveyor opening: 6 in. {152.4 mm}
- Pulling load: 8,000 lbs
- Speed range: 0.5 - 22 fpm {0.15 - 6.8 m/min}
- Motors: 4 -10 Hp AC (vector)¹
- Drives: 4 -15 Hp AC (vector)¹
- Pendulum-mounted upper beam with pneumatic clamping
- Acrylic safety enclosure
- Swivel casters and leveling jack screws
- Front-mounted operator station:
 - Pneumatic clamp controls
 - Digital speed indicator and load readout
 - System reset illuminated push-button

1. Quantity x Horsepower

Options

- Digital speed control
- Custom-profiled cleats

Offered in four models, CDS's dual cleat haul-offs are designed to provide accurate, dependable pulling force of large rigid profiles such as decking boards, fencing panels, and window lineals.

Calibration table length {m}	Model	Contact area (w x l)
13 - 16 ft. {4 - 5}	CCH-60QD	10 x 60 in. {254 x 1524 mm}
20 ft. {6}	CCH-72QD	10 x 72 in. {254 x 1828.8 mm}
23 - 36 ft. {7 - 11}	CCH-96QD	10 x 96 in. {254 x 2438.4 mm}
50 ft. {15}	CCH-120QD	10 x 120 in. {254 x 3048 mm}



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DUAL DOWNSTREAM EXTRUSION LINE

▶ TRAVELING CUT-OFF SAW & COLLECTION UNIT

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Standard configurations (per side)

- Table travel: 18 in. {457.2 mm}
- Blade diameter: 12 - 16 in. {304.8 - 406.4 mm}
- Motor: 1.5 - 2 Hp AC (3450 rpm)
- Y-block centerline: 17 in. {431.8 mm}
- Table-to-floor height: 40.5 in. {1028.7 mm}
- Electronic length control
- Vacuum dust/chip collector
- Adjustable pneumatic clamp, table speed, and blade feed rate
- Swivel casters and leveling jack screws
- Safety enclosure
- Adjustable entrance and exit guide rolls

Options

- Various blade types
- Nylon material support
- Anodized table surface
- Multi-angled clamp
- Clamp guard with sight glass

Calibration table length {m}	Model	Profile cross section (w x h)
13 - 20 ft. {4 - 6}	CTS-40D	12 in. {304.8 mm}
23 - 50 ft. {7 - 15}	CTS-55D	16 in. {406.4 mm}

▶ TILT & COLLECTION TABLE

Standard configurations (per side)

- Table width: 6 - 8 in. {152.4 - 203.2 mm}
- Table length: 6 - 18 ft. {5 - 5.486 m}
- Painted collection rack
- Tilt signal from saw
- Height adjustment: 39 - 45 in. {990.6 - 1143 mm}



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DUAL DOWNSTREAM EXTRUSION LINE

▶ WOOD PLASTIC COMPOSITE (WPC) DECKING

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CDS also designs and manufactures dual downstream extrusion lines for processors of wood-plastic composite (WPC) products, which are rapidly gaining acceptance in the marketplace for their material and cosmetic properties. Below is an example of a CDS post-extruder line designed to process WPC decking boards.



The DoubleDecker™



Dual Traveling Cut-Off Saw, CTS 55-D

- 18" table travel, with pneumatic assist
- 16" dia. Carbide tipped saw blade
- 2 HP AC motor (3450 rpm)

Dual Vacuum calibration Table, CVC 6-15D

- Pan size: 6 ft. long x 26" wide
- Stainless steel mounting rails for calibration tooling and/or vacuum tank
- 11 vacuum-outlet manifold with gauges
- 32 water-outlet manifold
- Multiple water drain from pan surface to reservoir
- 3-axis precision table movement
- Leveling jackscrews
- 5 HP vacuum pump
- 8" service-step

Dual Cleat Haul-off, CCH 40-8D

- Contact area: 8" wide x 40" long
- Flat 1" high EPDM cleats
- 6" maximum conveyor opening
- 3 HP DC control and 3 HP DC motor
- Variable speed range
- Right-to-left and left-to-right machine operation
- Remote control, 40-ft.long

ABOUT CDS

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CDS designs, manufactures, and services a complete line of downstream extrusion machinery for processors of polymer-based pipes, profiles, and tubes. CDS is based in Montreal, Canada and has a network of 4 major sales agencies in the United States.

Quick history

CDS originated from former Canadian company Metaplast, which manufactured extrusion equipment for over two decades. Incorporated in 1997, CDS quickly became recognized for its robust, built-to-order machinery and dedicated customer service.

Downstream extrusion products

CDS's extrusion machinery is grouped into the following categories:

COOLING & SIZING

Spray Cooling Tanks
Water Cooling Tanks
Vacuum Sizing Tanks
Profile Air Cooling Tables
Vacuum Calibration Tables

PULLING

Belt Pullers
Cleat Pullers
Pipe Pullers
Slab/Rod Pullers
Roll Pullers

CUT-TO-LENGTH

Traveling Saws
Fly-knife Cutters
Guillotine Cutters
Planetary Saws & Cutters
Cross-cut Saws

AUXILIARY PROCESSING

Embossing Stands
Brush/Scouring Tables
Annealing Tables
Cutter-Punch Units

COLLECTION & PACKAGING

Tilt & Collection Tables
Take-away Conveyors
Coil Winders



CDS, an end-to-end supplier

At CDS, the needs of our customers are accommodated at every stage of our operation cycle, from design all the way to delivery and maintenance of their machinery.



DESIGN



PRODUCTION



TESTING



DELIVERY



MAINTENANCE

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