



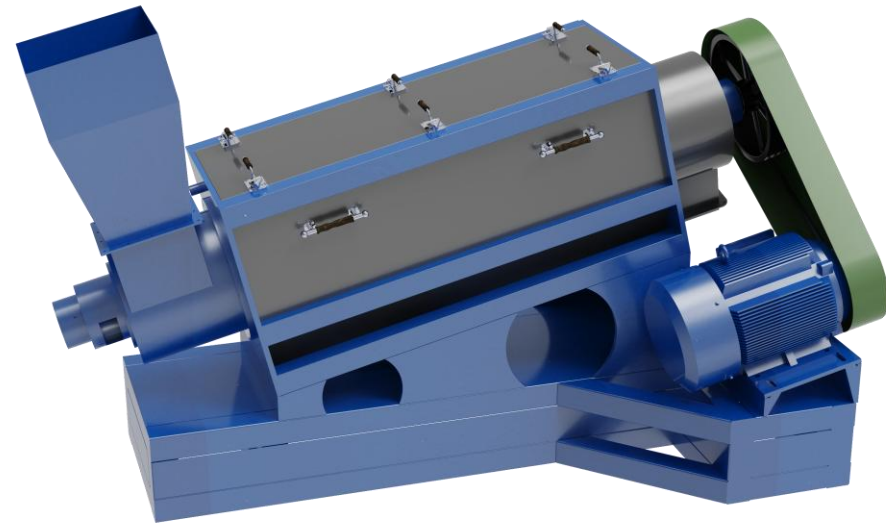
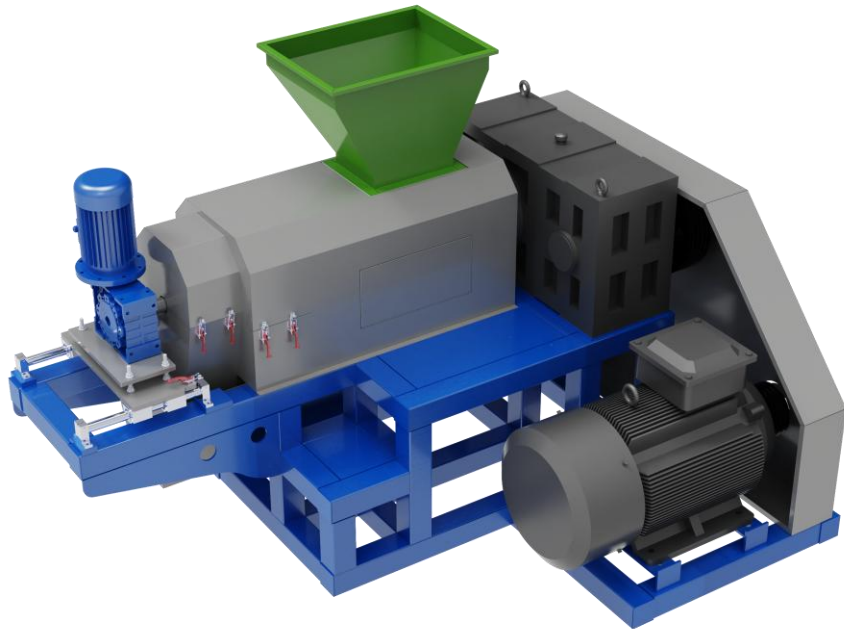
Process Parameter Reference

Zhangjiagang Retech Machinery Co.,Ltd



General Description

- For all plastic recycling washing & pelletizing lines, unified process parameter reference table for proposal, quotation and technical discussion. Matches all your previous recycling solutions.



Single-Shaft Shredder

Parameter	Reference Value	Remark
Feed bulk size	≤1200mm	For bulky rigid plastic, big rolls, blocks
Shredded output size	20–80 mm	Adjustable by screen mesh; film / woven bag usually 40–60mm
Rotor speed	50–83 rpm	Low speed, high torque
Capacity	150–2500 kg/h	Depends on raw material & model

Granulator

Parameter	Reference Value	Remark
Feed size	20–80 mm	From shredder
Flake / regrind output size	8–16 mm	Standard for washing line; 3–6mm for pelletizing feeding
Rotor speed (Granulator)	400–800 rpm	High speed cutting
Screen hole	6–18 mm	Customizable
Noise	≤85 dB(A)	With soundproof cover optional

Washing & Float-Sink Separation

Parameter	Reference Value	Remark
Hot washing temperature	60–95 °C	For heavy oil, glue, paint removal; optional cold wash at ambient temp
Hot wash chemical dosage	0.3–1.5 %	Caustic soda / detergent, based on contamination
Rotor speed (Granulator)	400–800 rpm	High speed cutting
Float-sink tank medium	Water	Customizable
Tank residence time	3–8 mins	Adjust for separation effect

Dewatering Machine

Parameter	Reference Value	Remark
Centrifugal dewaterer speed	1800–2800 rpm	For flakes / rigid regrind
Flake moisture after centrifugal dewatering	$\leq 1\%$	PET / rigid PP/PE
Screen mesh diameter	3mm	SUS stainless steel 304
Cleaning way	Self-cleaning	Brushers
Rotor material	45# steel	With balance treatment

Film Squeezer

Parameter	Reference Value	Remark
Screw diameter	300-380mm	Depend on capacity demand
Material of screw	38CrMoA1A	With nitriding treatment
Moving speed	120rpm	Speed control
Heating temperature	120-150 C	Customizable
Moisture	3%	Directly pelletizing