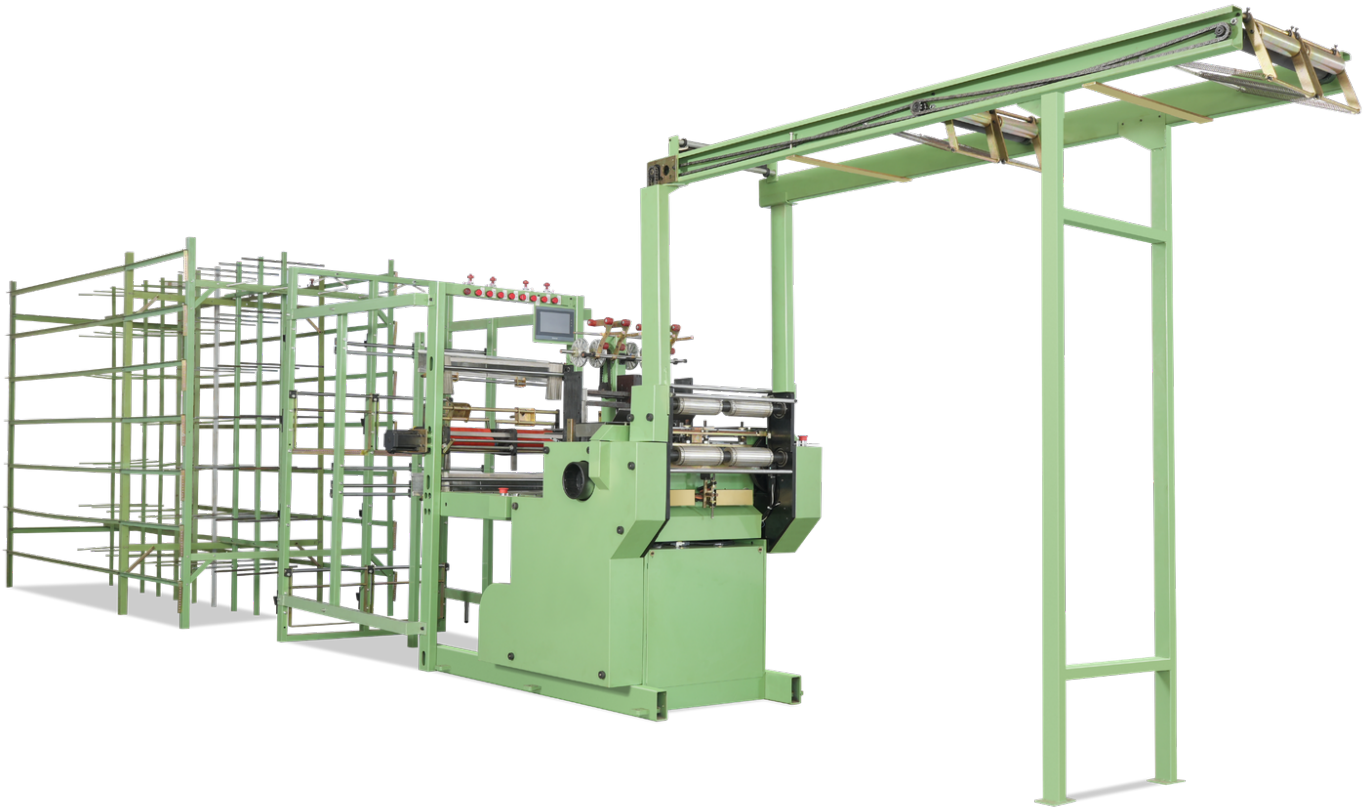
PILE WEATHERSTRIP PRODUCTION EQUIPMENT

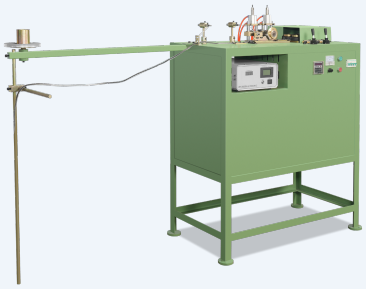
Warping. Weaving. Coating. Fin sealing. Rewinding.



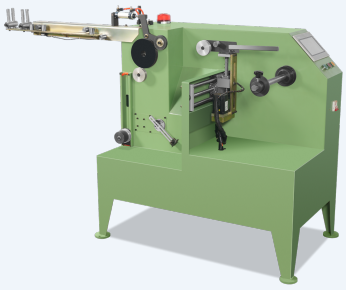
Pile weatherstrip weaving machine and yarn creel



Coating & slitting



Ultrasonic fin sealing



Automatic rewinding

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EQUIPMENT GUIDE

From yarn to finished rolls

Equipment for pile weatherstrip production and finishing.

01 **Warping** — Yarn preparation and beam winding — 03

02 **Pile weaving** — Weaving system and product specifications — 04-05

03 **Coating & slitting** — Extrusion, cooling, slitting and separation — 06-07

04 **Fin sealing** — Ultrasonic insertion of PP film or non-woven fins — 08

05 **Automatic rewinding** — Length-controlled roll packaging — 09

06 **Rewinding & measuring** — Semi-automatic rewinding and length counting — 10

07 **Adhesive backing** — Application of double-sided adhesive backing — 11

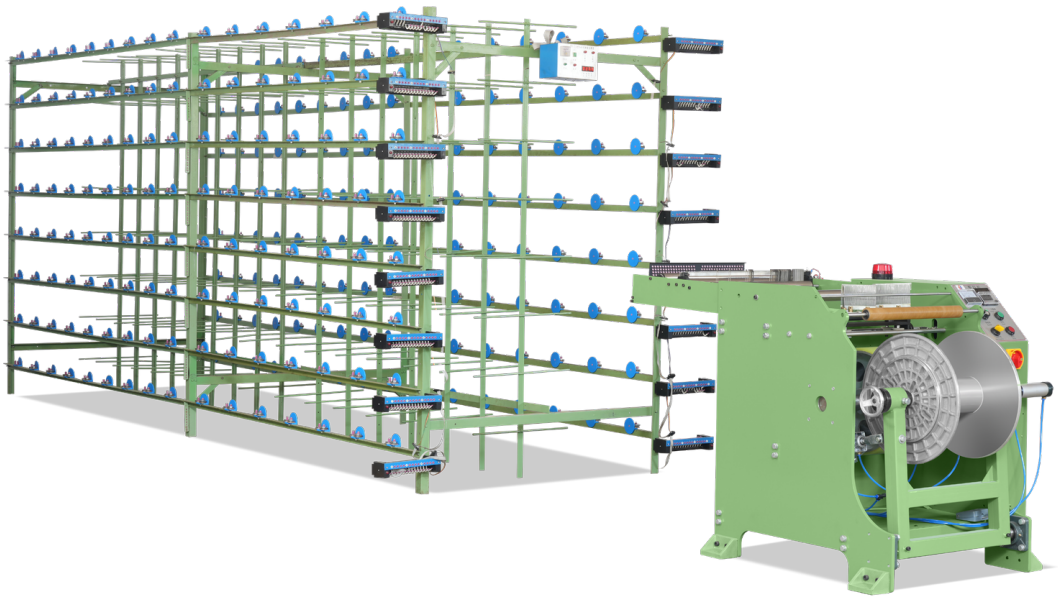
Choose the equipment sequence to suit the required pile height, strip width, backing, fin construction and roll format.

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01 / YARN PREPARATION

Warping machine

Winds cotton, synthetic filament, twisted and textured yarns onto weaving beams.



Warping unit and yarn creel

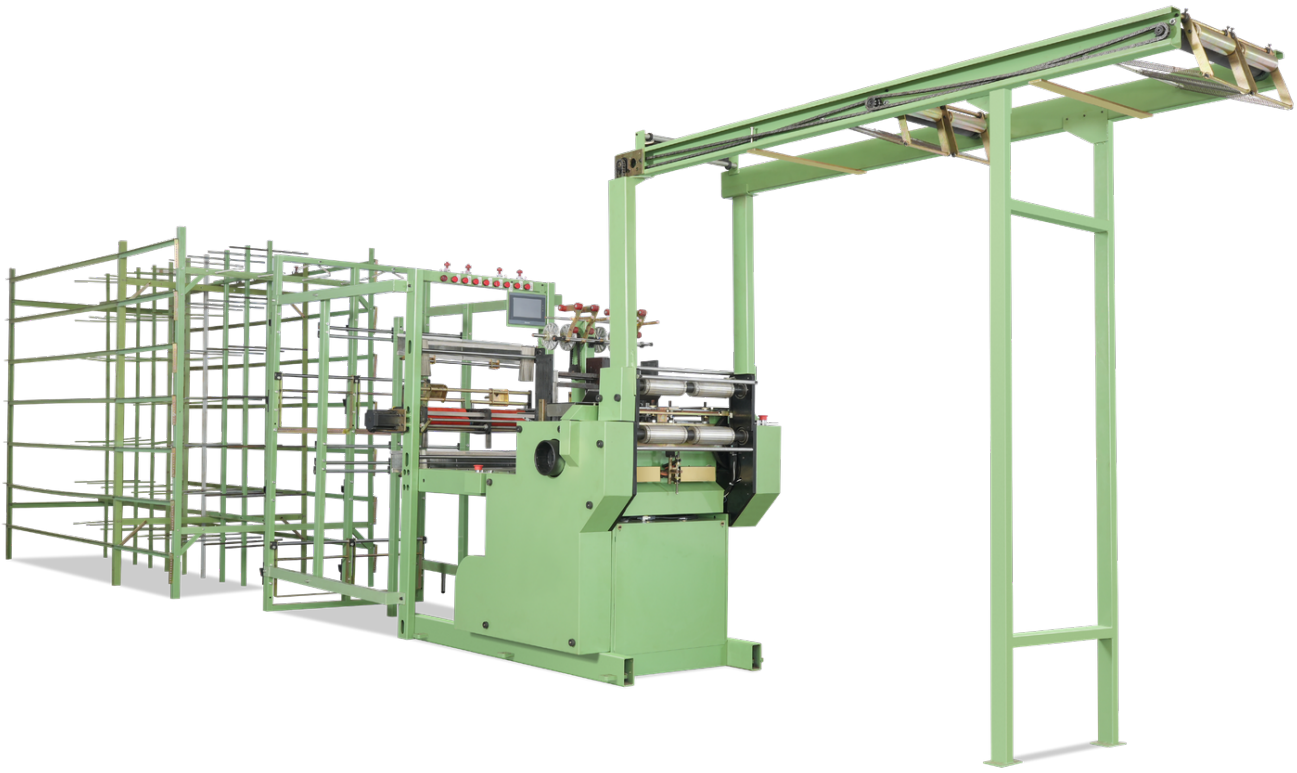
Inverter speed control, adjustable yarn tension and reed spacing, yarn-break stop with warning lamp, and automatic meter counting.

PARAMETER	SPECIFICATION
Motor power	**1.5 kW**
Supply	**380 V, 3-phase**
Supply frequency	**50 Hz**
Motor speed	**1,430 rpm**
Main unit dimensions	**1,450 x 1,000 x 900 mm**
Overall installation layout	**7,500 x 1,500 x 2,000 mm**
Machine weight	**400 kg**

02 / PILE WEAVING

Pile weatherstrip weaving

CNC version for PP pile weatherstrips used in windows, doors and related products.



3.8-145 mm	3-15 mm	Up to 88
Finished strip width	Pile height	Strips per machine

Touchscreen operation, electronic adjustment of weft density and pile height, inverter drive and automatic yarn-break stop.



BCF yarn example



Pile weatherstrip examples



Brush product examples

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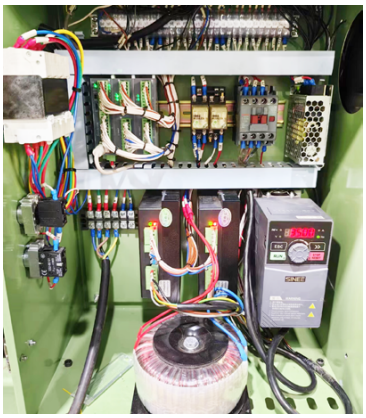
02 / PILE WEAVING

Weaving specifications

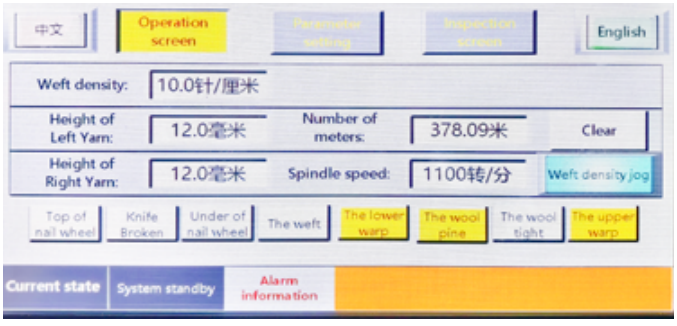
Product dimensions, machine data and operating features.

PARAMETER	SPECIFICATION
Finished strip width	**3.8-145 mm**
Pile height	**3-15 mm**
Height before cutting	**6-30 mm**
Strips per machine	**Up to 88**
Listed weaving speed	**45-55 cm/min**
Motor power	**1.5 + 1 kW**
Supply	**380 V, 3-phase, 50 Hz**
Machine dimensions	**1,700 x 1,000 x 1,800 mm**
Overall installation layout	**9,300 x 2,050 x 2,100 mm**
Machine weight	**760 kg**
Yarn-break stop	**Automatic**
Operator interface	**Touchscreen**

The number of strips depends on the selected strip width and machine configuration.



Drive and control cabinet



Touchscreen settings

03 / COATING & SLITTING

Extrusion coating system

A four-part system for coating, cooling, slitting and guiding pile weatherstrips.



Coating system configuration

01	02	03	04
Extrusion	**Coating & cooling**	**Slitting**	**Separation rack**

10,000 x 2,700 mm

Listed line layout footprint (L x W)

Five extruder heating zones, inverter speed control and a 600 mm cooling wheel.

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03 / COATING & SLITTING

System components

Individual equipment specifications. All dimensions below are in mm.

01

Extruder

Power: 7.5 + 12 kW

Supply: 380 V

Motor speed: 1,440 rpm

Inverter: Included

Heating zones: 5

Screw diameter: 65 mm

Dimensions: 2,700 x 750 x 1,350

Weight: 550 kg

02

Coating & cooling unit

Power: 1.5 kW

Supply: 380 V

Motor speed: 1,390 rpm

Inverter: Included

Cooling wheel: 600 mm

Dimensions: 2,300 x 700 x 1,900

Weight: 450 kg

03

Slitting unit

Power: 1.5 kW

Supply: 380 V

Motor speed: 1,440 rpm

Inverter: Included

Cutting system: Replaceable knife blades

Dimensions: 1,600 x 650 x 1,350

Weight: 270 kg

04

Separation rack

Function: Strip guidance and separation

Dimensions: 6,000 x 600 x 950

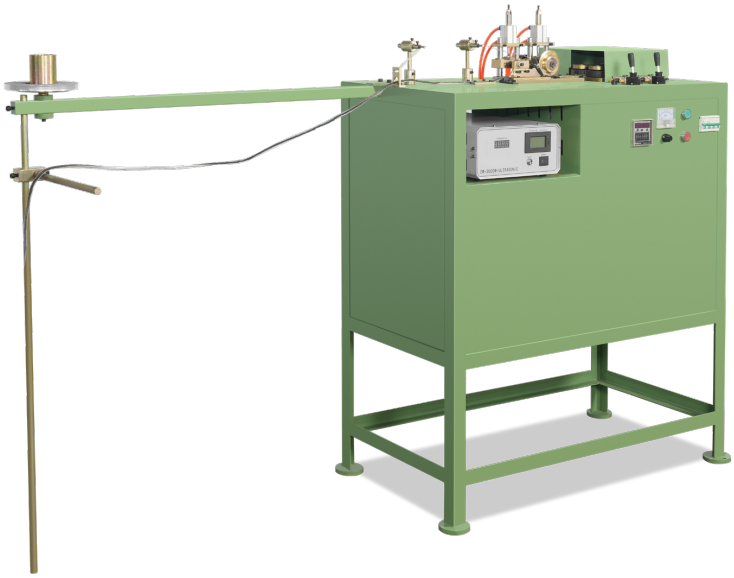
Weight: 350 kg

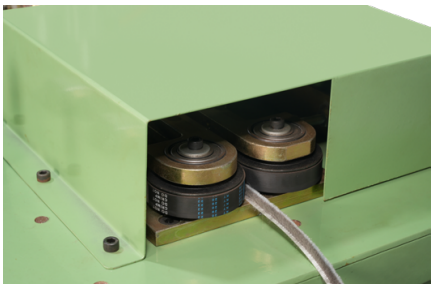
Supports strip handling after coating and slitting.

04 / FIN SEALING

Ultrasonic fin sealing

Inserts and bonds PP film or non-woven fins into pile weatherstrips.







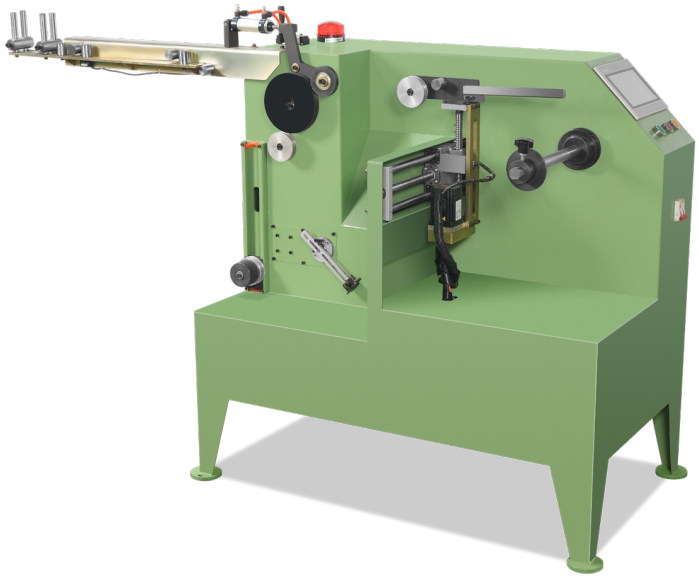
Ultrasonic bonding with geared take-up drive and inverter speed adjustment.

PARAMETER	SPECIFICATION
Fin materials	**PP film / non-woven fabric**
Drive motor power	**0.4 kW**
Listed line speed	**18 m/min**
Speed control	**Inverter**
Ultrasonic frequency	**20 kHz**
Ultrasonic input voltage	**220 V**
Supply frequency	**50 Hz**
Machine dimensions	**1,000 x 570 x 1,000 mm**
Machine weight	**190 kg**

05 / AUTOMATIC REWINDING

Automatic roll winder

Arranges and winds finished pile weatherstrips into rolls.



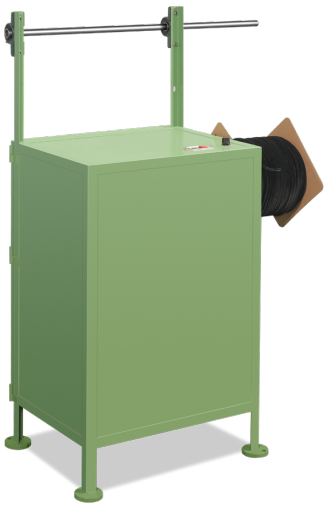
Stops at the preset length and when strips are too tight, tangled or unavailable. Touchscreen and computer controller with servo control.

PARAMETER	SPECIFICATION
Supply voltage	**220 V**
Supply frequency	**50 Hz**
Power	**2.3 kW**
Operator interface	**Touchscreen**
Controller	**Computer controller**
Machine dimensions	**1,000 x 700 x 1,150 mm**
Machine weight	**170 kg**

06 / REWINDING & MEASURING

Rewinding & length measuring

Length counting and semi-automatic roll winding for finished strips.



Semi-automatic roll winder

PARAMETER	SPECIFICATION
Power	**0.37 kW**
Supply	**380 V, 3-phase**
Frequency	**50 Hz**
Motor speed	**1,400 rpm**
Dimensions	**700 x 500 x 950 mm**
Weight	**50 kg**



Length measuring unit

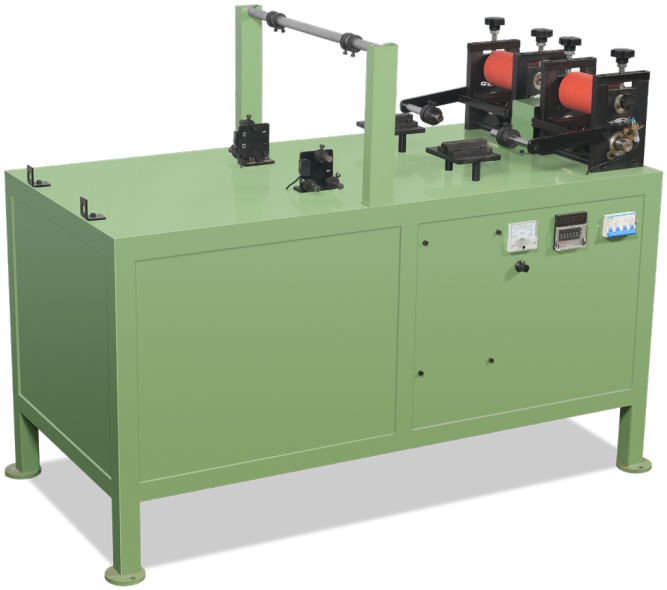
PARAMETER	SPECIFICATION
Power	**0.37 kW**
Supply	**380 V, 3-phase**
Frequency	**50 Hz**
Dimensions	**1,000 x 400 x 750 mm**
Weight	**70 kg**
Use	**With semi-auto rewinder**

The measuring unit supports length counting when used with the semi-automatic roll winder.

07 / ADHESIVE BACKING

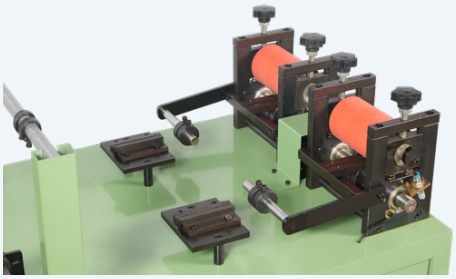
Adhesive backing machine

Applies double-sided adhesive to the back of pile weatherstrips.



For surface-mount applications on profiles without an open groove, including furniture, sliding doors and wardrobe doors.

PARAMETER	SPECIFICATION
Power	**0.37 kW**
Supply	**380 V, 3-phase**
Frequency	**50 Hz**
Dimensions	**1,000 x 700 x 750 mm**
Weight	**90 kg**



Adhesive application section

PLAN YOUR WEATHERSTRIP LINE

Share a product sample and your production requirements with YISHUO.

INFORMATION FOR EQUIPMENT SELECTION

01 Strip dimensions

Finished width, pile height and backing dimensions

02 Material & fin

Yarn specification, PP film or non-woven fin requirements

03 Finishing & rolls

Coating, adhesive backing, roll length and roll format

04 Production site

Required output, power supply and available installation space

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lloyd.jiang@nbyishuo.com