

FEED AND BIOFUEL

# ADVANCED FEED PRODUCTION TECHNOLOGY

EXTRUDERS

**ANDRITZ**

ENGINEERED SUCCESS

# The advanced single-screw and twin-screw extrusion concept

ANDRITZ extruders provide the latest technology for production of the most demanding extrudates in the aquatic feed and pet food industries.

## ANDRITZ SINGLE-SCREW EXTRUDERS

The ANDRITZ single-screw extruder represents state-of-the-art technology, ensuring unique quality feed at minimum operating costs. The optimized extrusion concept for unmatched performance consists of controlled feeding of dry ingredients, optimum conditioning with steam and liquid addition, an even flow rate to the extruder, and high extrusion flexibility and controllability.

## ANDRITZ TWIN-SCREW EXTRUDER

The twin screw extruder, ExTS 616 & 718, is the ideal solution for the extrusion of pet food with high inclusion rates of meat slurries or fresh meat. The twin screw extruder ensures complete utilization of starch; allowing for higher flexibility in the formulation and enabling a higher feed conversion ratio.

The high-shear, co-rotating, twin screws ensure complete material discharge, and there is no residue in the barrel after production. These factors allow for rapid change over to the next recipe.

## EXTRUSION FEATURES

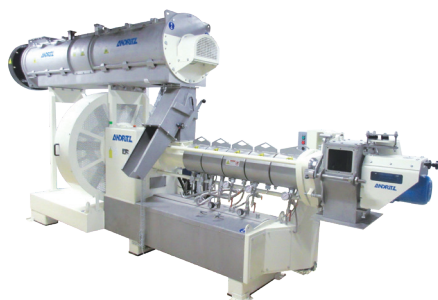
- Starch cooking control
- Bulk density control
- Raw material flexibility
- Nutrient advantages
- Optimal product uniformity
- Unique visual appearance

## EXTRUDER RANGE

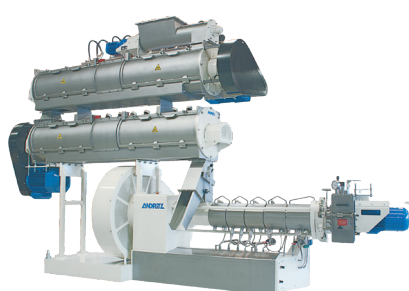
Type	EX0618	EX0621	EX1021	EX1250	EXTS616	EXTS718
Screw diameter mm	177	210	210	250	2x158	2x176
Length mm	1670	1670	2670	3070	3210	3520
Motor kW	200	315	315	710	500	710
Capacity tph	1-4	3-7	4-11	10-20	8-12	10-18



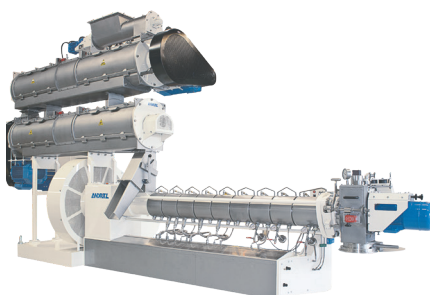
Extruder EX0618



Extruder EX0621



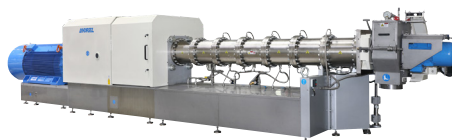
Extruder EX1021



Extruder EX1250



Extruder EXTS616 & EXTS718



## FEATURES

Type	EX0618	EX0621	EX1021	EX1250	EXTS616	EXTS718
Transmission	belt	belt	belt	gear	gear	gear
Bolt barrels	-	-	-	x	x	x
Screws	pinned	pinned	pinned	pinned	spline	spline
Water cooling or heating jackets	x	x	x	x	x	x
Liquid injection points	x	x	x	x	x	x
Screw pushout	-	-	-	-	x	x
Dual and single conditioner	x	x	x	x	x	x
Flextex © Starch cooking control	x	x	x	x	x	x
ECS © Density control	x	x	x	x	x	x
Microfeed system	-	-	x	x	x	x
ECMS Extrusion control management system	x	x	x	x	x	x
High moisture of meat slurries	-	-	-	-	x	x
Complete discharge	-	-	-	-	x	x



# Options and accessories available to meet specific requirements

## 1 LOSS IN WEIGHT SYSTEM

- Accurate feeding regardless of changes in raw material density
- Accurate metering of additives

## 2 PRE-CONDITIONING

- Single or dual conditioners
- Up to 400 seconds retention time
- Flexible retention time depending on product requirement
- Constant high mixing efficiency whatever the retention time
- Optimal starch cooking through high mixing efficiency

## 3 FORCED FEEDER

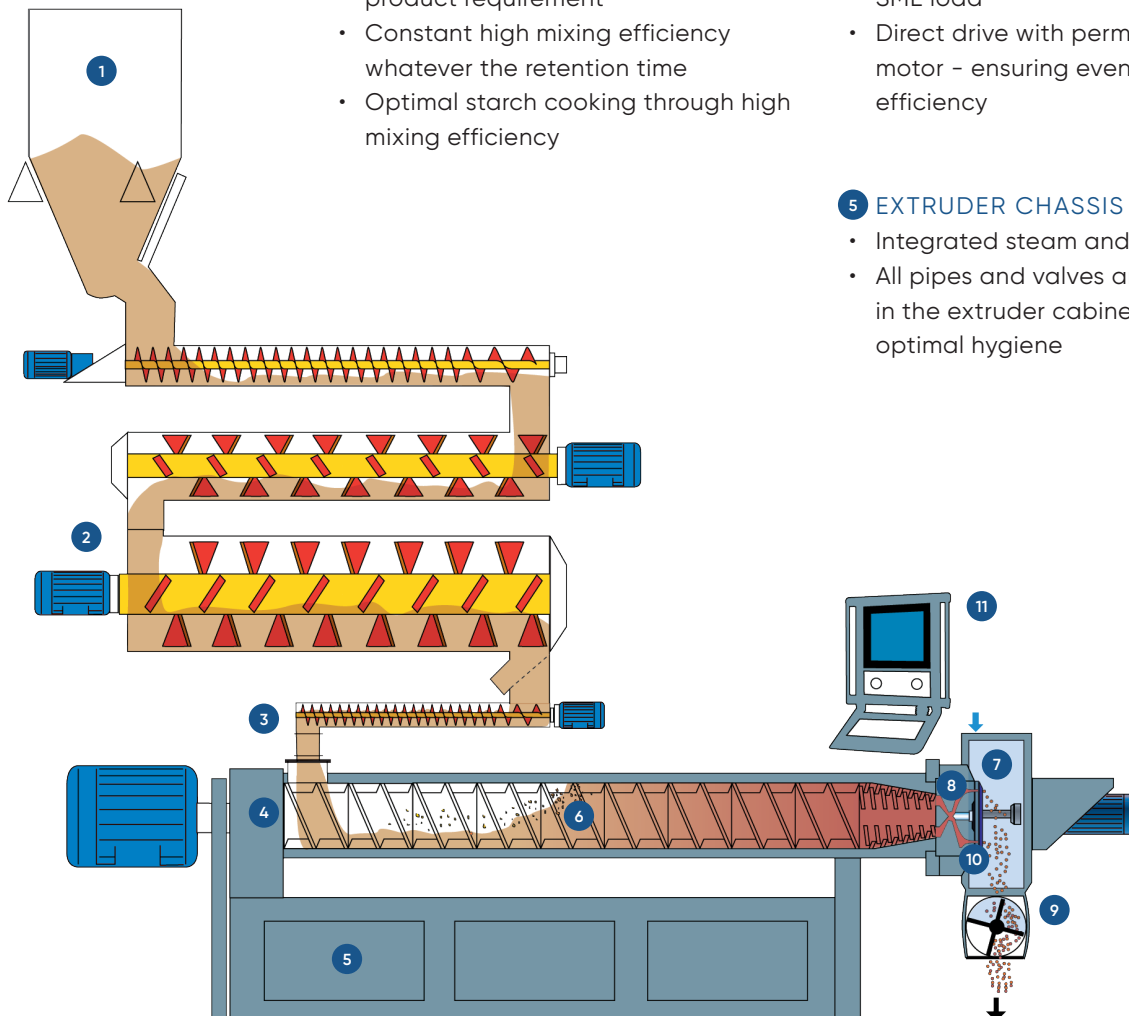
- Avoids blockage in downspout between conditioner and extruder
- Ensures even flow rate through the extruder

## 4 DRIVE

- Gear or belt drive
- High torque design suitable for high SME load
- Direct drive with permanent magnet motor - ensuring even higher efficiency

## 5 EXTRUDER CHASSIS

- Integrated steam and liquid system
- All pipes and valves are located in the extruder cabinet to ensure optimal hygiene



## EXTRUDED FEED

The demand for high-quality feed, with a pleasing visual appearance as well as the right nutritional benefits, require advanced, multifunctional equipment.

### 6 SEGMENTED SCREW AND BARREL

- Modular screw and barrel configuration, which can be tailor-made for each application
- The state-of-the-art screw assembly design allows reconfiguration and maintenance with minimum down time
- Tapped screw and barrel design

### 7 KNIFE HOUSING

- Replacing die plates and knives only takes a few minutes
- Standard stanley knife blades are used

### 8 FLEXTEx SYSTEM FEATURES

- On-line control of starch cooking
- On-line control of product expansion
- Reduced formulation costs, optimum starch cooking

### 9 ECS FEATURES

- On-line control of product density
- 100% sinking feeds made possible
- Increased extruder output 15 to 50%

### 10 MICROFEED SYSTEM

- State-of-the-art knife housing and die plate design allows increased capacity up to 40% producing microfeed (up to 2 mm)

### 11 EXTRUDER CONTROLS

- Full automation
- Traceability
- Product and process repeatability



# Advanced extrusion technologies for superior feed characteristics

Back pressure valve (FLEXTEX™), Expansion Control System (ECS™) and Microfeed system combining these unique process technologies for full feed controllability.

## SCREW CONFIGURATION FOR OPTIMUM STARCH ACTIVATION

Extruding feed is primarily a matter of cooking the starch. The better the starch is cooked, the better the quality of the feed. However, it is equally important to control the expansion of the feed, thus influencing density which determines both sinking and floating properties.

By controlling the specific mechanical energy (SME) of the screw configuration on the extruder, it is possible to reach optimum gelatinization, thus achieving a product with improved digestibility and increasing growth rate.

On most new extruder designs, screw configuration can be optimized with the SME necessary to match specific product requirements such as those with high fat/oil content, internal oil or similar products with high nutritional value. Screw configuration can be optimized to apply more SME by implementing the following components:

- Screw design and geometry
- Shear locks
- Kneading blocks
- Reverse elements

An optimum screw configuration is not always capable of applying sufficient SME to produce a given product. Often it is also necessary to optimize other parameters that can be used to increase the SME supply in the extruder:

- Screw speed
- Open area of venturi die
- Open area of die plate
- Extruder capacity

## THE PHYSICAL QUALITY OF FISH FEED PRODUCTS IS DEFINED BY:

- Density
- Shape and size
- Uniformity
- Durability
- Water stability
- Fast sinking / slow sinking / floating
- Low or high oil content
- Size Ø 0,6 - 40 mm
- High FCR (Feed Conversion Rate)
- Optimal cost efficiency

## THE NUTRITIONAL QUALITY OF FISH FEED CAN BE DEFINED AS:

- Recovery of essential amino acids and specific vitamins
- Digestibility

## THE PHYSICAL QUALITY OF PET FOOD PRODUCTS IS DEFINED BY:

- Density
- Variety of shapes and sizes
- Optimal crispness and texture
- Even uniformity

## THE NUTRITIONAL QUALITY OF PET FOOD CAN BE DEFINED AS:

- Recovery of essential amino acids and specific vitamins
- Unique digestibility and palatability



**THE ANDRITZ FLEXTEX SYSTEM REDUCES DOWNTIME AND OPTIMUM PRODUCTION FLEXIBILITY**

Changes in screw configuration and other measures that contribute to either higher or lower SME values are all operations that can result in down time and increased production costs. These changeover procedures can easily take as much as two to five hours to adjust. Therefore, technological advances focusing on both cost savings in the form of reduced down time as well as optimal flexibility in terms of capacity and quality are in high demand by the feed culture industry.

**THE FLEXTEX WORKING PRINCIPLE**

The FLEXTEX system is able to continuously control the SME applied in the extruder during operation without changing the extruder configuration or other parameters. By changing only this one parameter, it will have the following advantages in the production of feed:

- The starch cook (up to 100%) is completely controlled during operation
- The bulk density of the product can be reduced by up to 30% and can be controlled with an accuracy of  $\pm 5 \text{ g/l}$  ( $0.3 \text{ lbs/ft}^3$ )
- Higher addition of oil and less starch in the formula without significant influence to bulk density and product quality

The FLEXTEX system, located between the screw and the die plate allows the outlet opening to be adjusted from 3000mm to 100 mm 2 ( $4.65 - 0.15 \text{ in}^2$ ) depending on throughput.

This provides more precise control over the pressure in the kneading zone and the SME applied, cutting down on the amount of energy consumed.

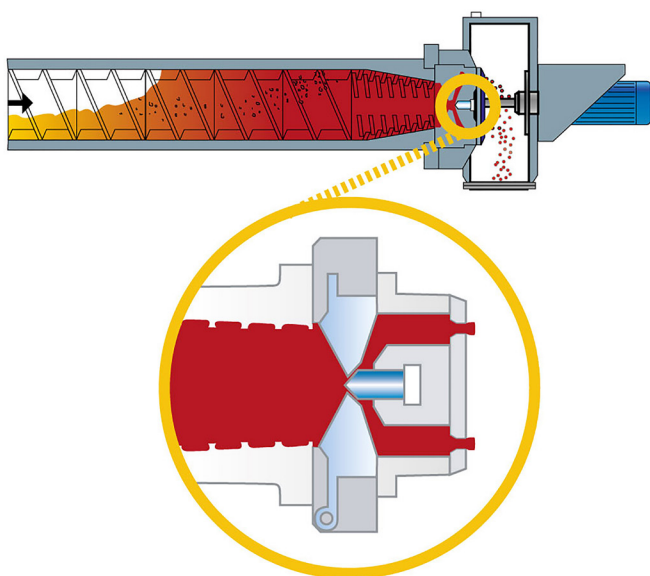
With the FLEXTEX system, the extruder operator can determine exactly how much specific mechanical energy (SME) the product needs. The operator then determines the set-point from the control system, either from a separate control or an integrated control; for example, kW/ton (HP/ton) dry matter. The FLEXTEX system automatically adjusts using a hydraulically controlled piston to increases or decreases flow through the outlet.

**THE MECHANICAL DESIGN**

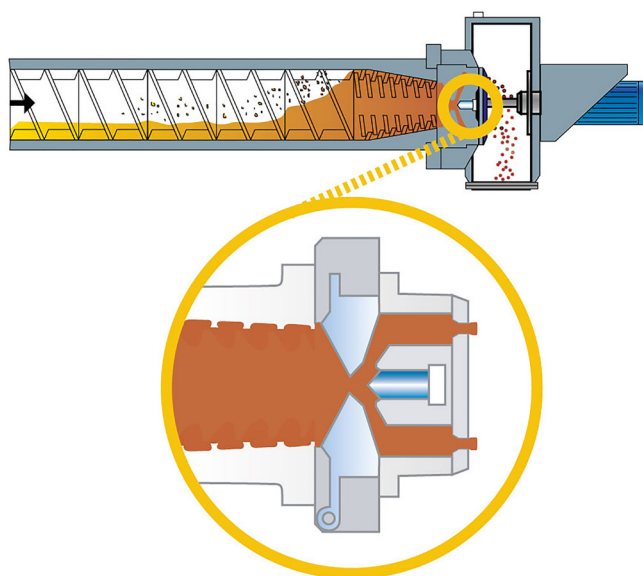
The FLEXTEX system consists of 3 parts:

1. The PLC control system
2. The venturi die and the piston system
3. The hydraulic station

ANDRITZ designed the FLEXTEX system with a focus on simplicity. Fewer parts mean less upkeep and thereby reduces your cost to maintain. The primary component of the FLEXTEX system is the piston, which is used to restrict the meal flow as well as distribute meal to the die plate. It is essential that these actions take place synchronically so that movement is unhindered. Changes in the meal flow due to uneven pressure at the die plate can ultimately influence the visual quality of the product. The FLEXTEX system solves any possible inconsistencies by moving axially and, at the same time, conical so that the meal flow remains even.

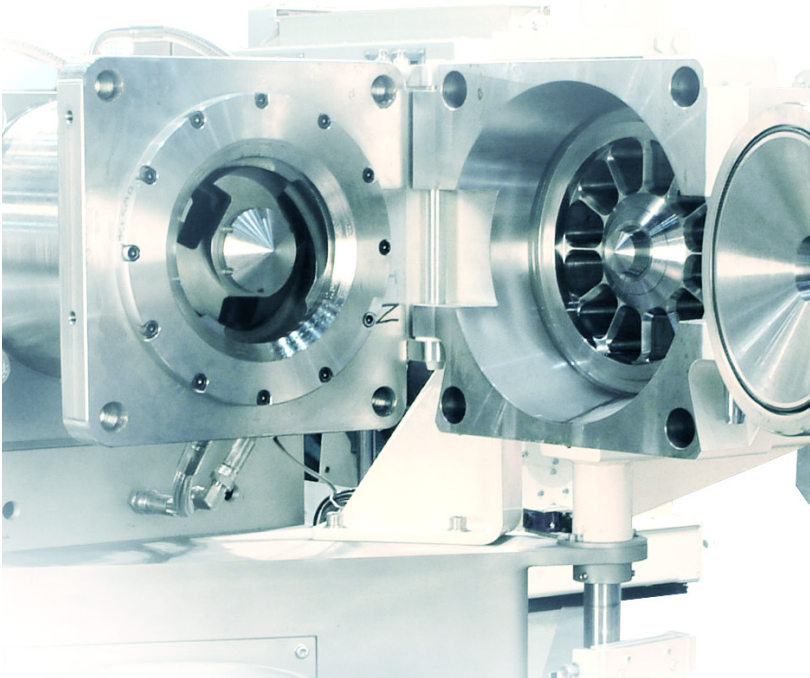


FLEXTEX in closed position – additional SME applied



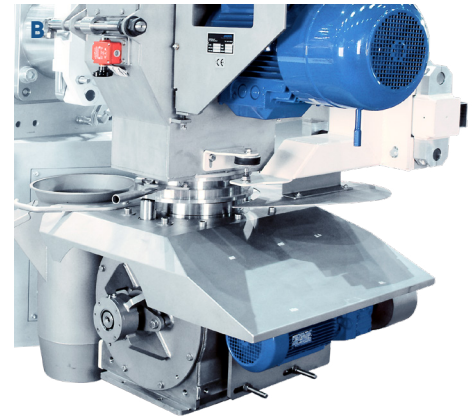
FLEXTEX in neutral position – no additional SME applied

A



A Extruder with FLEXTEX installed

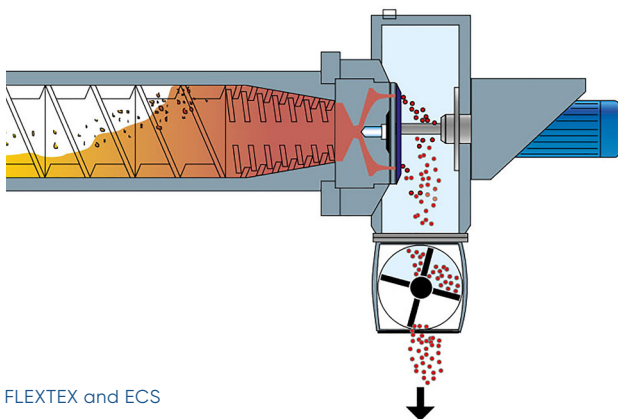
B Extruder with ECS installed



### THE ANDRITZ EXPANSION CONTROL SYSTEM (ECS) – FOR INCREASED BULK DENSITY

The Andritz Expansion Control System (ECS) is unique in its ability to control the bulk density of a wide range of products while also optimizing product quality. The ECS concept is based on controlling the expansion in the extruder knife house without influencing the product quality. Thus all desirable parameters can be used in the extruder without regard to expansion. The main focus here is product quality.

By adding compressed air in the knife house, it is possible to control and adjust the pressure. This is made possible by mounting an airlock under the knife house (see figure below). Increased pressure in the knife house results in a reduction of flash-off and thus, increases the bulk density.



FLEXTEX and ECS

### DOCUMENTED RESULTS FROM THE FLEXTEX AND ECS SYSTEMS

The FLEXTEX and the ECS systems can be installed individually or as a combined concept. This is simply a question of each producer's requirements. The results of documented tests from full scale operations demonstrate significant advantages when using the Extruder with ECS installed FLEXTEX and ECS ANDRITZ FLEXTEX and ECS system. The figure below shows the results of tests that were conducted on a shrimp feed formula containing 70% protein.

#### SUMMARY

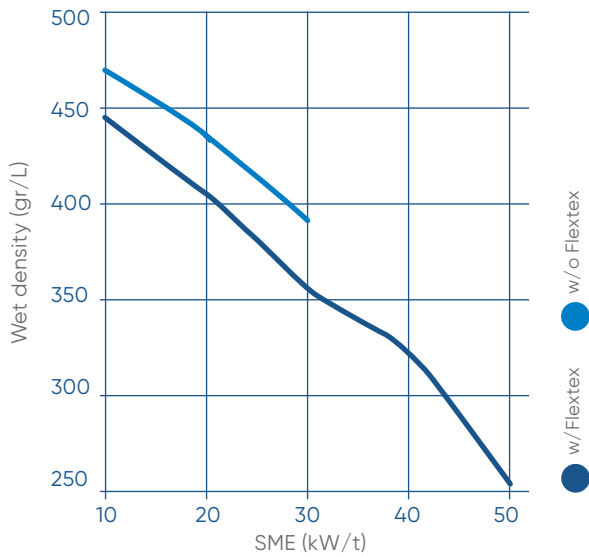
The FLEXTEX and ECS systems provide significant flexibility in the production of feed for all fish species. By continuously controlling the SME and the ECS during operation, it is possible to control both the physical quality and the product density. Two unique tools for controlling finish product characteristics are present. The advantages of the systems can be summarized into:

- Increase starch cook by 10-15%
- Decrease bulk density by 20-30%
- Increase bulk density by 0-25%
- No change of screw configuration which means reduced down time
- Only two parameters needed for controlling starch cook, reduced and increased bulk density.





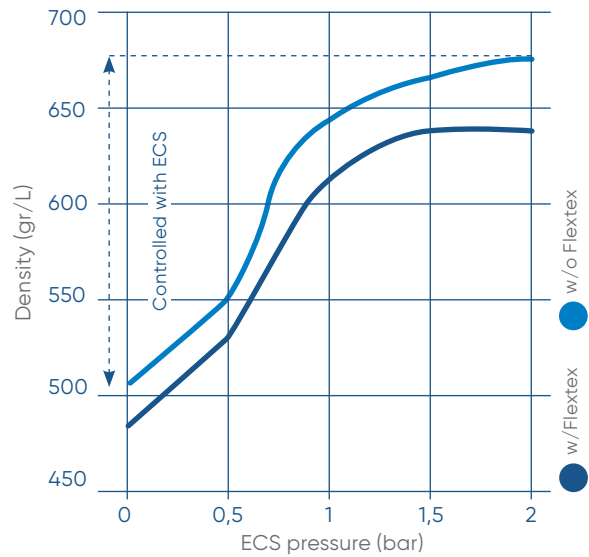
### SME FLEXIBILITY



#### TEST A: FLEXTEx EFFECT ON STARCH COOK

By increasing the SME in the extrusion process by approximately 12%, the cook rate was increased by 11.8%.

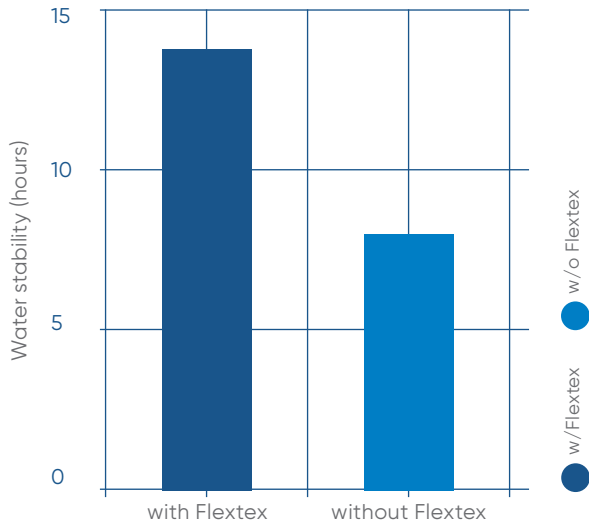
### EFFECT OF ECS ON BULK DENSITY



#### TEST B: ECS EFFECT ON BULK DENSITY

The ECS can increase the bulk density by 25% by adjusting the pressure in the knife house only.

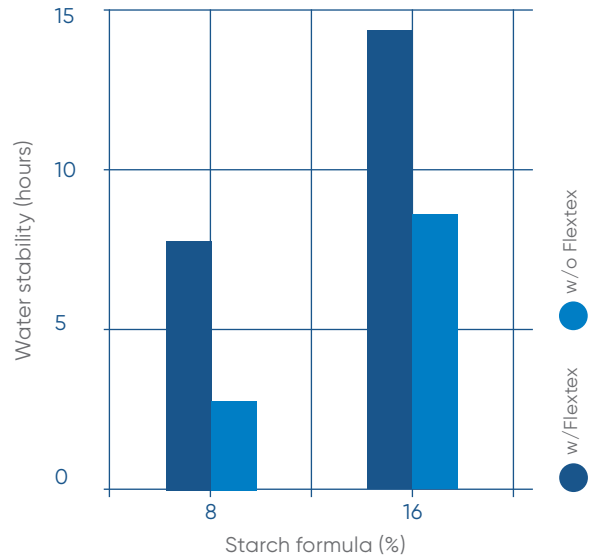
### FLEXTEx EFFECT ON WATER STABILITY



#### TEST C: FLEXTEx EFFECT ON WATER STABILITY

By increasing the SME it was possible to increase the water stability by an additional 6 hours.

### STARCH CONTENT VS. WATER STABILITY



#### TEST D: REDUCED STARCH CONTENTS IN FORMULA BY MEANS OF FLEXTEx

By reducing the starch contents by approximately 50%, equal water stability (8 hours) could be obtained as with the original high starch formula, but without FLEXTEx (8 hours).

# Microfeed system

The Microfeed system from ANDRITZ is an easy upgrade of the extruder die surface area and offers many advantages, such as higher capacity, longer operational uptime, and decreased pellet agglomeration.

## LARGER OPERATIONAL DIE AREA

The operational die surface area is increased up to approximately 36%. This is possible by increasing the outer die diameter while impacting few other components.

## HIGHER DISTANCE BETWEEN HOLES

The large die area is utilized to increase the distance between extrusion channels. This is beneficial when pellets accumulate in the knife house due to pellet expansion.

## HIGHER CAPACITY

Having a higher number of extrusion channels means a longer operational uptime is obtained. This enables higher capacities to be achieved, especially with less expanding feed like sinking and shrimp feed.

## HIGHER UPTIME

When producing pellets  $\varnothing 2\text{mm}$  and smaller, extruder capacity may slowly decrease as extrusion holes become clogged, eventually shutting down operations. By having a higher number of extrusion channels a longer operational uptime is obtained.

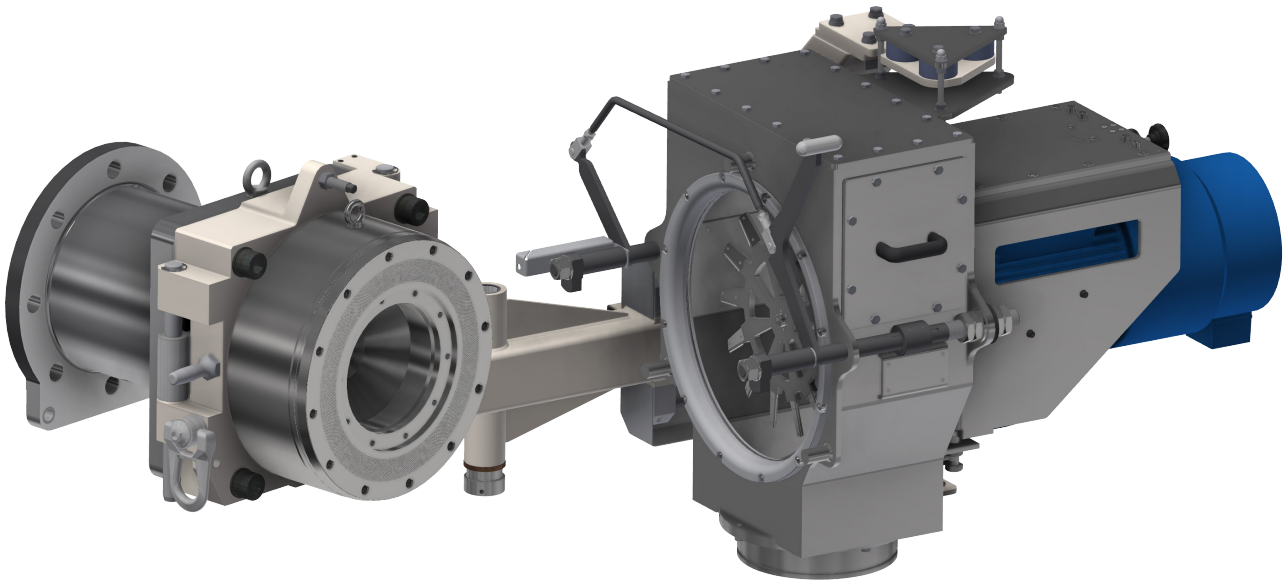
## READY TO UPGRADE?

Before ordering the upgrade kit, ensure that the increased capacity can be accommodated. Ensure sufficient upstream capacity in the batching, grinding and mixing processes.

The extrusion microfeed upgrade kit includes all the necessary parts such as the die, larger die base, and knife assembly. Once received, the existing knife house is easily reworked on-site by an expert service engineer to accommodate the larger die.

**Contact us to order your upgrade kit today!**





The operational die surface area is increased up to approximately 36%.

This is possible by increasing the outer die diameter, while impacting few other components.

**Ø210mm barrel (EX20, EX21, EX621, EX1021)**

	Normal	Microfeed system
Inner Ø	142mm	142mm
Outer Ø	310mm	368mm
Open area	8.130 mm <sup>2</sup>	10.300 mm <sup>2</sup>
27% increase		

**Ø250mm barrel (EX1250)**

	Normal	Microfeed system
Inner Ø	150mm	220mm
Outer Ø	420mm	528mm
Open area	11.240 mm <sup>2</sup>	15.300 mm <sup>2</sup>
36% increase		

# Control systems for each stage of the processing line

ANDRITZ is one of the world's leading suppliers of technologies, systems, and services for the feed and biofuel industries. We have devoted our efforts to unique processes in the feed and biofuel industries and have dedicated our work to optimizing everything about the machinery and components.

Concurrently, we have also focused on improving the control systems that bring it all together. In a market with a continuous demand for new and improved products as well as low operating costs, perfect harmony between machinery and staff is necessity. With our ASCADA systems, we can achieve this synchronization.

ANDRITZ ASCADA integrates our state-of-the-art machinery and process complexity, streamlining operations and planning so your staff can make informed decisions upfront.

ANDRITZ ASCADA improves on virtually every aspect of the SM32/AS32. This new control system features individual device pop-ups and more detailed diagnostic information, as well as increased resolution for a better operational overview. Additionally, ANDRITZ ASCADA now includes improved service support options.

The ASCADA solution comes in a range of editions. Ask your local ANDRITZ Feed and Biofuel sales office for more information and which edition is right for you.



## ECPS/ECMS

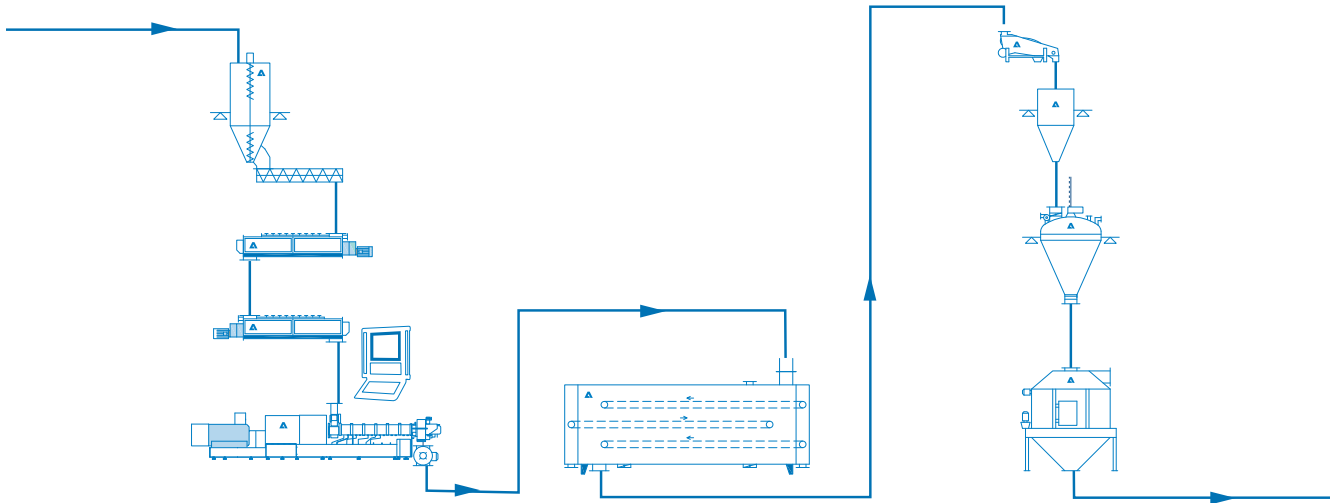
Extrusion control

## DCPS/DCMS

Drying control

## VCPS/VCMS

Coater control



## PROCESS CONTROL SYSTEMS

Type	Extruder	Dryer	Coater	Touch control panel system	PC remote management system
Basic	ECPS	DCPS	VCPS	x	
Extended	ECMS	DCMS	VCMS	x	x

### BASIC FUNCTION CONTROL

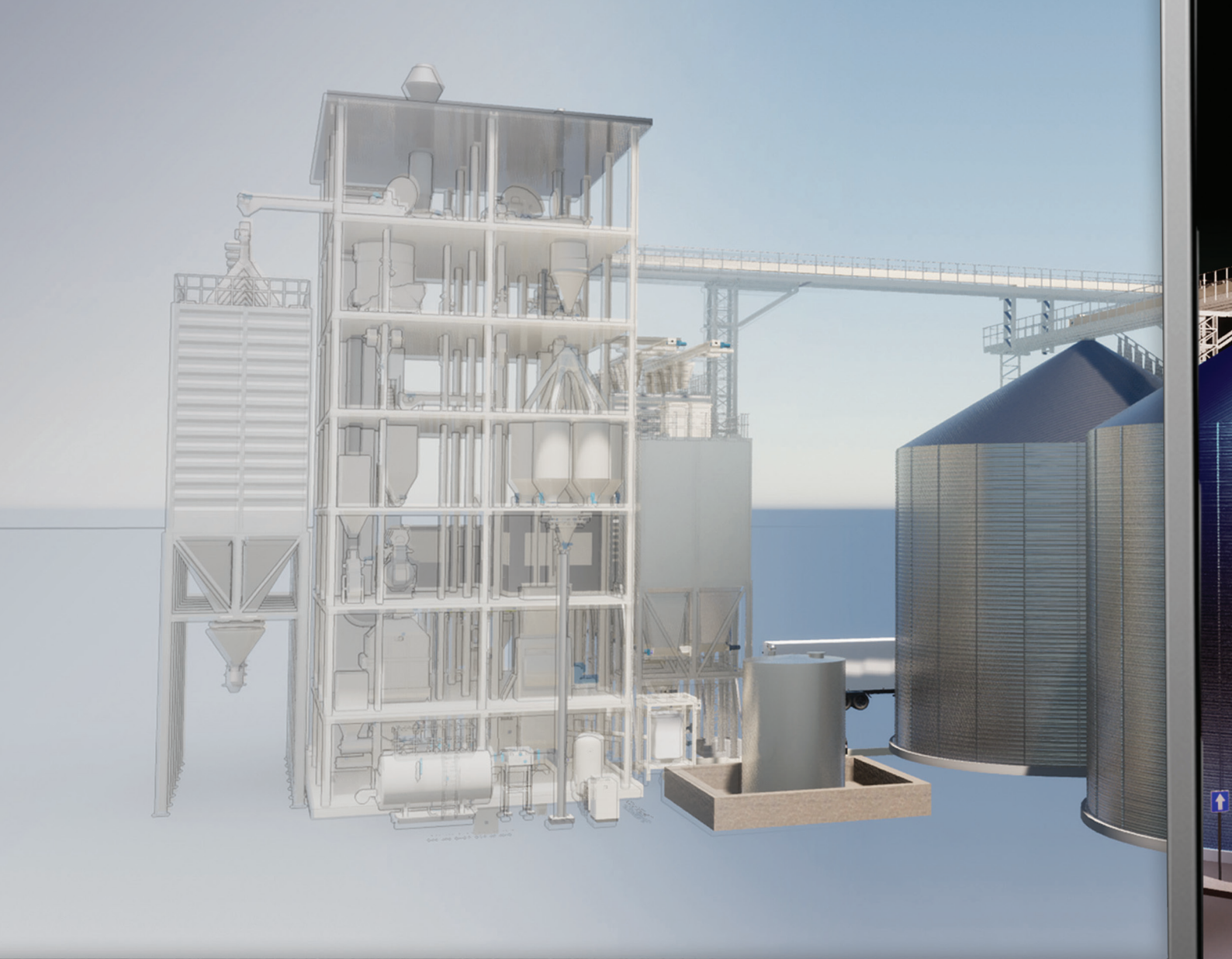
- Basic functions
- Basic operation of equipment
- Manual settings/readings

### EXTENDED FUNCTION CONTROL

- Extended remote control
- Fully automatic control
- Total traceability
- Auto start/stop feature
- Production management
- Database
- Recipe logging
- Remote online support



- A** Touch control panel system
- B** Server installation for control room
- C** Touch client for field installation



**Plant Solutions.  
Understanding you.  
Standing by you.**





**IF YOU CAN DREAM IT,  
WE'LL STAND IT UP.  
AND STAND BY IT.**

We provide complete plant solutions for feed, pet food and biomass industries to your exact specifications at the lowest possible total cost of ownership by leveraging our extensive processing expertise and experience. AND with the industry's most trusted services, we are always there for you.

**ENGINEERED SUCCESS**





## GLOBAL SUPPLIER – LOCAL PRESENCE

With sales, service, engineering, manufacturing and production sites located all around the world, ANDRITZ Feed and Biofuel is truly a global organization with a local presence. ANDRITZ is vital to ensuring a reliable global supply of aqua feed, animal feed, pet food, and biofuel. With full process lines accounting for half the world's production of aqua feed and biomass alone, we continuously support leading producers in achieving the highest levels in safety, quality, and control from feedstock to final product.

How can we help grow your business?

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