

**JINHU** 金湖集团  
JINHU GROUP

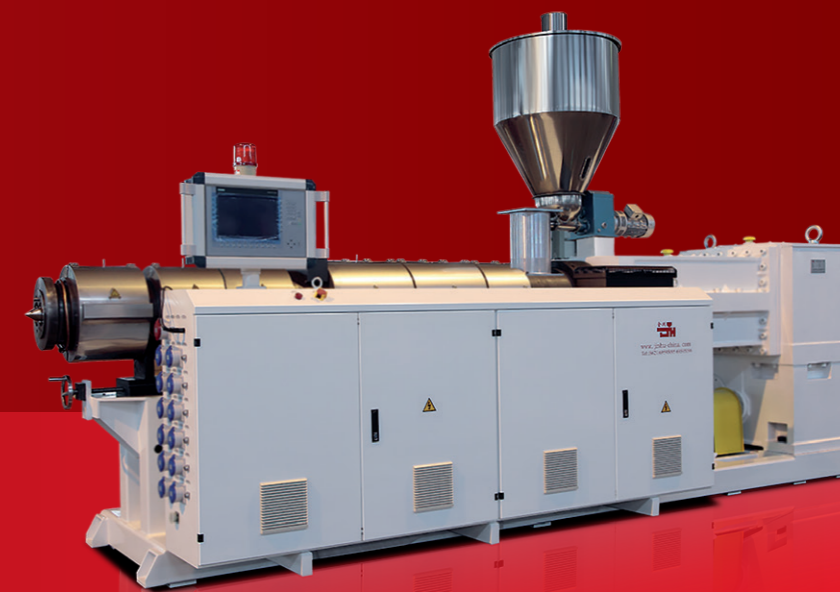
**JINHU**  
金湖集团  
JINHU GROUP  
金湖  
JH®

唯有好的机器，才有好的未来  
GOOD MACHINE  
RESULT IN HIGH QUALITY PRODUCT

# PIPE PROFILE Extrusion Equipments

管材·型材挤出设备

地址：上海市曹安路 4246 号（20 号桥西）  
Add: 4246 Caoan Road, Shanghai, 201804 P. R. CHINA  
销售部 (Sales Tel) : 0086-21-69595095 69595096 69595070  
外贸部 (Trade Department Tel) : 0086-21-69591860 69595138  
售后热线 / 传真 (Service Hotline/Fax) : 0086-21-69595223 69592961  
传真 (Fax) : 021-69595125 69593603  
E-mail: jinhush@jinhu-china.com  
http: //www. jinhu-china.com



JINHU 2019.04 ZHONGMENG media

**上海金湖挤出设备有限公司**  
SHANGHAI JINHU EXTRUSION EQUIPMENT CO.,LTD.

**上海金湖机械有限公司**  
SHANGHAI JINHU MACHINERY CO., LTD.

**上海金湖塑料机械有限公司**  
SHANGHAI JINHU PLASTIC MACHINERY CO.,LTD.



质量管理体系符合  
GB/T19001-2000 idt ISO9001:2000标准

## 金湖人的意识

CONSCIOUSNESS OF JINHU PEOPLE

金湖人在销售上需要主动热情地了解市场的波动、新产品的开发、同行的信息、市场的信息、服务的信息和需求的信息。加强自我的形象、信息的反馈、产品的更新、合作的意识、客户意识、公司的保密意识。

金湖人在生产上需要加强自我的成本意识、质量意识、生产意识、效率意识、规范意识、管理意识、安全意识。质量是生产出来的，不是检查出来的。

金湖人在服务上需要主动、热情、定期、不定期的服务。加强自我形象、不断加强自我的服务意识、销售意识、客户意识、市场意识、成本意识、沟通意识和朋友意识。站在主人翁的角度来要求自我的工作。

金湖人在技术上需要快、简单、实用、更经济的精神，也需要一丝不苟、十全十美的精神。不断加强企业的竞争意识、市场意识、成本意识、客户意识、品牌意识。提高自我的专业技术、不断学习新的知识和设计理念。

金湖人在管理上需要以成为公司制度的楷模为目标，从我做起互相监督、站在企业的角度来考核自我的一切工作。从工作安排、计划、监督、检查、反馈、考核、服务等等。以高标准、严要求、制度化来开展自我的工作，一切以效率为主、以质量为核心、团结为后盾，发挥金湖的真诚合作、求实拼搏的精神。

金湖人有了目标、有了责任、有了方法，我们才会不断地去要求自我认真，一位不苟、持之以恒地提高自我的工作质量，提高自我的生活质量，加强自我的社会责任感，为社会文明而努力奋斗。

Initiative and enthusiasm in the market, and understand the volatility of the market, new product development as well as information of opponent market, service and demand. Strengthening ego image, information feedback, product updates, sense of cooperation, customer awareness, and the company's confidential consciousness.

Jinhu people have to strengthen the self production cost awareness, quality consciousness, production consciousness, efficiency consciousness, standard consciousness, managing consciousness and safety consciousness. Quality is in the production, not in the examine.

Jinhu people are always active and warm in services, periodically and periodically to service customers. Strengthening Jinhu people's self-image and self service consciousness, sales consciousness, customer awareness, market consciousness, cost awareness, communication and friends consciousness continuously. Standing in the angle of self to request the masters.

Jinhu people always have the perfect spirit of fast, simple, and practical, more economical and more meticulous in technical; strengthening the competitive enterprise consciousness, market consciousness, cost consciousness, customer awareness and the brand awareness constantly. Improving the self professional technology and learning new knowledge and design concept constantly.

People always form ourself as model base on a formula system in management. We begin from ourself and supervise each other, all our work will standing in the point of view of our enterprise to assessment ourself from working arrangement, plan, supervise and inspect, feedback, assessment and service, etc. With high-standard requirements and institutionalized to develop our work, with priority work to the efficiency and take the core work to the quality, we Jinhu people unite and cooperate each other to develop the sprit of Jinhu people's sincerity cooperation and fact attitude.

Only Jinhu people have the target the responsibility and the methods, then we can improve our workmanship, the quality of life and the sense of social responsibility to strive for our social civilization continuously and fastidiously.

**中国民营 500 强**  
**上海民营企业 100 强**  
**浙江省民营企业 50 强**

## 企业宗旨

真诚合作 求实拼搏 不断创新 永争第一

## Enterprise Tenet

Sincere Cooperation Practicality and Striving  
Continuous Innovation Being the First Forever



董事长：何春雷  
President: ChunLei He

**中国优秀民营科技企业家、浙江省政协委员、  
浙江省工商联会常委、舟山市政协常委、舟山市工商联会副会长、  
舟山市企业家协会副会长、舟山市海外联谊会副会长**

China Excellent entrepreneur for Private Hi-tech Business

Member of Zhejiang Committee of CPPCC

Member of Standing Committee of Zhejiang Industrial & Commercial Association

Member of Standing Committee of Zhoushan Municipal Committee of CPPCC

Vice-chairman of Zhoushan Industrial & Commercial Association

Vice-chairman of Zhoushan Enterprise Directors Association Vice-chairman of

Zhoushan Overseas Friendship Association

金湖集团凭着其多年酝酿的独特企业文化，以及企业对全球经济发展的热切关注，以磅礴的气势和迅捷的反应不断壮大，使自己在本行业中深具规模，倍受瞩目。集团从事塑料机械制造长达 33 年之久，在上海、浙江设立了五个生产基地，拥有舟山金海机械有限公司、舟山金湖化纤机械有限公司、浙江金湖塑料机械有限公司、上海金湖挤出设备有限公司、上海金湖机械有限公司、上海金湖塑料机械有限公司等十多家公司。总占地面积达 1200 多亩，员工人数千余名，其中包括各类技术人员 400 多名。公司产品使用“金湖”注册商标。在公司

员工的不断努力下，公司先后获得“中国民营企业 500 强”、“上海市百强民营企业”、“浙江省百强民营科技企业”、“浙江省诚信企业”、中国轻工优秀民营百强企业”、“中国机械优质产品”、“中国十佳塑料机械企业”等荣誉称号。此外，公司还拥有独立的质检中心，并取得中国质量协会质量管理体系认证，其质检水平具有较高的权威性、公正性及可靠性。



位于舟山经济开发区 B 区的生产基地 (金湖集团)  
Jinhu Group in Section B of Zhoushan Economic and Technological Development Zone (ETDZ)



位于舟山经济开发区 A 区的生产基地 (金海机械)  
Jinhai Machinery, Located in Section A of Zhoushan Economic and Technological Development Zone (ETDZ)



位于上海黄渡工业园区的生产基地 (一分公司)  
Production Base (HUANGDU INDUSTRIAL PARK OF SHANGHAI)



上海曹安公路 4246 号 (上海金湖挤出设备有限公司)  
The manufacturing base at Shanghai Huangdu Industrial Park Shanghai Jinhu Extrusion Equipment Co., Ltd.

JINHU treats people as the base and seeks development by innovation. With its distinct enterprise culture and rapid reaction, it has owned certain scale. This group has been in the line of plastic machinery for more than 33 years, so far it has established five production bases in Shanghai, Zhejiang. It owns ten specialized companies such as Zhou Shan Jinhai Machinery Co., Ltd., Zhou Shan Jinhu Chemical Fiber Machinery Co., Ltd., Zhejiang Jinhu Plastics Machinery Co., Ltd., Shanghai Jinhu Extrusion equipment Co., Ltd., Shanghai Jinhu Machinery Co., Ltd...etc. Its total area exceeds 1200 Mu; it has more than one thousand staff including more than 400 technicians. JINHU is one registered trade marks of this Group Co.. With common efforts of all staff, this group Co. has got a lot of honors, such as "Top 500 China's Private Enterprise"; "Top 100 Shanghai's Private Enterprise", "Excellent Top 100 Private Scientific & Technological Enterprise in Zhejiang Province", "Honest & trustworthy Enterprise in Zhejiang Province", "Excellent Top 100 Private Enterprise in China's Light Industry", "Excellent Quality Product of China's Machinery", ...etc. In addition, this Group Co. has independent quality inspection center, and has obtained certain certificate from China Quality Association with rather high authority, justness and reliability.

**质量是企业的生命、技术是企业的源泉、管理是企业的核心、人才是企业的根本、服务是企业的宗旨。**

The quality is the life of enterprise, the technology is the mine of enterprise, the management is the core of enterprise, the talents is the foundation of enterprise, and the service is the purpose of enterprise.

**金湖塑机、塑机金湖、金湖为人人、人为金湖、金湖努力为社会服务、金湖以品质、科技、节能、高效、创新的社会化的责任感而努力奋斗。**

金湖集团的主要产品有：各类塑料管道生产线；各类塑料异型材生产线；各类塑料板材、发泡板、片材、流涎膜生产线；各种用途的单螺杆、双螺杆挤出机；平行双螺杆挤出机；各类塑料机械用螺杆、机筒；化纤卷绕头及化纤成套生产设备；各类优质水环式真空泵，高可靠性水泵，热油泵及液压系统，热恒温系统；电工电缆机械；化工成套设备；齿轮减速机箱等。产品远销东南亚、中东、南美、欧共体等国家。在产品质量上精益求精，在技术上不断完善，在售后服务上建立了全国完善的网点服务体系，成为全国塑机行业中发展最快的、技术最强的优秀企业，深得用户的好评。我们的优势在于不断为用户提供优质、可靠、价格合理的新产品，帮助用户创造最大的利润和商机是我们最终的目标。

In 2002, this Group Co. has imported HVOF alloy powder spray equipment and 2 sets CNC milling machine for screw & barrel to insure products processing precision, thereby the screw & barrel get a good stiffness and toughness property, prolong service life. JINHU GROUP mainly provides all sorts of plastic pipe production line, all sorts of profiled production line all sorts of plastic Board, Sheet, Film production line, all sorts of single and twin screw extruder, all sorts of screw & barrel for plastic machinery, winding head for chemical fibers and chemical fiber complete set

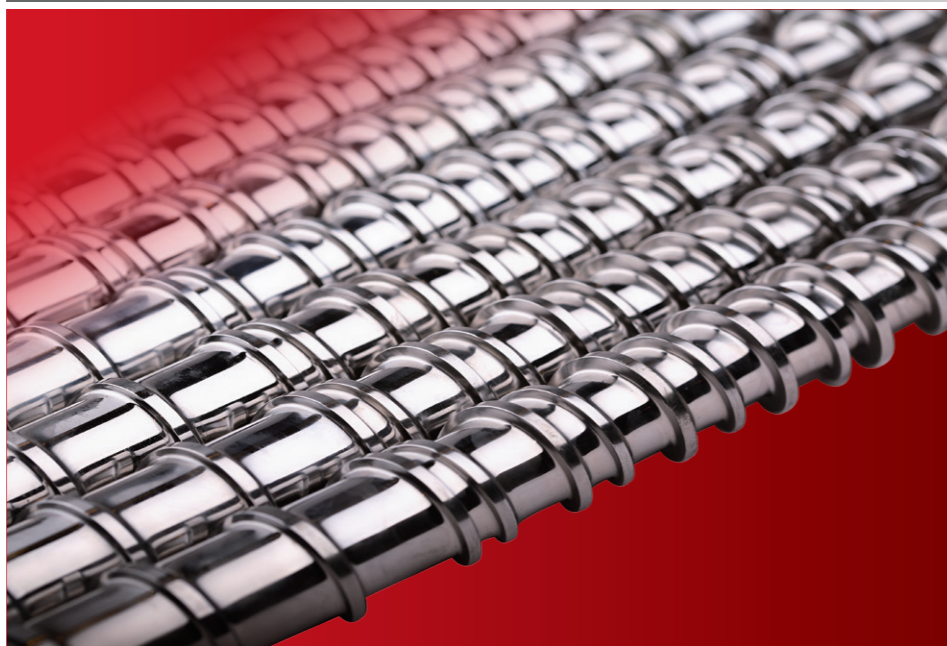
of production equipment, all sorts of excellent water cycled type vacuum pump, high reliability water pump, hot oil pump and pneumatic system, thermal constant temperature system, electrical cable machinery, chemical complete set of equipment gear box...etc. Products are exported to such countries and regions as Southeastern Asia, mid-east, South American, EU...etc. Always improving and developing the quality of products and have established complete nation-wide service network. It has developed into the strongest enterprise in national plastic machinery industry. Our advantages lie in that we continuously provide new items with excellent quality and reasonable price. It is our ultimate target to help our customers to create best profit and business opportunity.

JINHU for plastic machinery, plastic machinery by JINHU; JINHU for All, All for JINHU. JINHU performs its responsibility do it best to serve society with a high quality & technology, high-efficient energy saving and innovative products.

# Screw & Barrel

## Of Single Screw Extruder

### 单螺杆挤出机螺杆机筒



#### 材料 Material

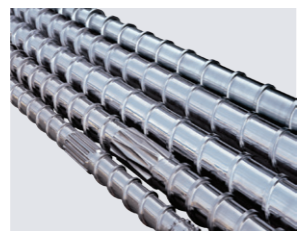
优质合金钢 High quality alloy  
1) 38 CrMoAlA(JIS SACM645)  
2) 42 CrMo(JIS SCM440)  
3) 9 Cr18MoV  
4) CW6Mo5Cr4V2  
5) SKD61

#### 热处理

渗氮处理  
电镀硬铬层  
高频淬火  
喷涂耐腐蚀、耐磨双金属层  
真空淬火

#### Heat treatment

Nitride treatment  
Hard chrome plating  
High frequency quenching  
Spraying bimetallic alloy for corrosion resistance & abrasive resistance  
Vacuum quenching



# Conical (Parallel)

## Twin Screw & Barrel

### 锥 (平) 双螺杆机筒

#### 材料

优质合金钢  
1) 38 CrMoAlA(JIS SACM645)  
2) 42 CrMo(JIS SCM440)  
3) 9 Gr18MoV  
4) CW6Mo5Cr4V2

#### Material

High quality alloy  
1) 38 CrMoAlA(JIS SACM645)  
2) 42 CrMo(JIS SCM440)  
3) 9 Gr 18MoV  
4) CW6Mo5Cr4V2

#### 热处理

渗氮处理  
电镀硬铬层  
喷涂耐腐蚀、耐磨双金属层

#### Heat treatment

Nitride treatment  
Hard chrome plating  
Spraying bimetallic alloy for corrosion resistance & abrasive resistance

#### 技术指标

氮化层深度 :0.50-0.80mm  
氮化硬度 :900- 1000HV  
氮化脆性 : ≤一级  
表面粗糙度 :Ra0.4  
螺杆直线度 :0.01 5mm  
氮化后表面镀铬硬度 : ≥ 950Hv  
镀铬层厚度 :0.025-0.085mm

#### Technical index

Nitride thickness 0.50m-0.80mm  
Nitride hardness. 900 000HV  
Nitride fragility First class  
Surface roughness: Ra0.4  
Screw staightness 0015mm  
Chrome layer hardness ater nitride: z950HV  
chrome layer thickness. 0.025-0.085mm

#### 表面处理

渗氮处理  
喷涂耐腐蚀、耐磨双金属层

#### Surface treatment

Nitride treatment  
Spraying bimetallic alloy for corrosion resistance & abrasive resistance



# High Efficient Single Screw Extruder 高效单螺杆挤出机

挤出机系列 Series Extruder

## 设备特点:

我公司开发的 JHE 系列新型高效单螺杆塑料挤出机引进德国最新技术，螺杆采用分离型螺杆与混炼元件的优化组成，机筒采用沟槽机筒与加长喂料段的优化设计。通过分离型螺杆和沟槽机筒的结合使用，可以获得以下优势：

- 物料的熔融过程得到优化，从而提高挤出产量。实现了物料熔体在较低温度的挤出。
- 通过隔离间隙内确定的剪切作用，使物料达到了良好的均化。
- 熔融塑化过程受到了控制，也就是说，只有比隔离间隙小的粒子才能进入熔体通道。
- 对不同的物料提供了广泛的加工范围，适用于各种聚烯烃原料，
- 特别适用于 HDPE、PP、ABS 管材原料。



## Characteristics of the equipment

JHE series high efficient single screw extruder is developed by our company adopting German latest advanced technology. Screw optimizes composing separate type screw and mixing parts. Barrel optimizes composing groove barrel and lengthened feeding segment. There is advantage as following by using separate type screw and groove barrel together:

- It's optimized during material melting process. Thus get more extrusion throughput. it is realized extruding melt material in low temperature.
- Cutting function is caused through separate clearance and it makes material equal well.
- It's controlled during melt plasticization process. Therefore only granules that smaller than separate clearance can enter melt channel.
- Wide manufacture range for different materials. It's suitable for all kind of polyolefin materials and especially for material for HDPE, PP, and ABS pipe.

## 用于型材、片材挤出 Use for profile, sheet extrusion

挤出机型号 Model	螺杆直径 Screw diameter (mm)	长径比 L/D Ratio	传动功率 Driver power (kw)	中心高 Center height (mm)	产量 Output(kg/h) HDPE\PP	
JHE45/42	45	42:1	110	1000	450	300
JHE60/42	60	42:1	220	1000	800	550
JHE75/42	75	42:1	315	1000	1200	800
JHE90/42	90	42:1	450	1000	1600	1100
JHE105/42	105	42:1	500	1300	1800	1200
JHE120 /42	120	42:1	630	1500	2250	1500

## 用于管材等挤出 Use for pipe extrusion

挤出机型号 Model	螺杆直径 Screw diameter (mm)	长径比 L/D Ratio	传动功率 Driver power (kw)	中心高 Center height (mm)	产量 Output(kg/h) HDPE\PP	
JHE45/38	45	38:1	55	1000	220	150
JHE60/38	60	38:1	110	1000	450	300
JHE75/38	75	38:1	160	1100	600	450
JHE90/38	90	38:1	220	1100	800	550
JHE105/38	105	38:1	315	1100	1150	800
JHE120 /38	120	38:1	450	1300	1600	1100
JHE150 /38	150	38:1	630	1500	2250	1500

## 用于管材挤出 Use for pipe extrusion

挤出机型号 Model	螺杆直径 Screw diameter (mm)	长径比 L/D Ratio	传动功率 Driver power (kw)	中心高 Center Height (mm)	产量 Output(kg/h) HDPE\PP
JHE45/33	45	33:1	37	1000	150
JHE60/33	60	33:1	75	1000	300
JHE75/33	75	33:1	110	1100	450
JHE90/33	90	33:1	160	1100	600
JHE120/33	120	33:1	280	1100/1300	950
JHE150 /33	150	33:1	400	1300	1350

规格及标准设备若有变动，恕不另行通知  
Specifications and standard equipment are subject to change without notification

# Twin Conical Screws Extruder

## 锥形双螺杆挤出机

挤出机系列 Series Extruder

### 设备特点:

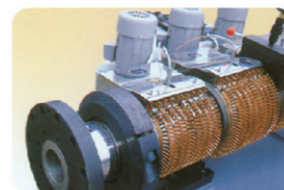
SJZ 型系列锥形双螺杆挤出机是一种适合于各类 PVC 粉料挤出成形的专用设备。配备不同模具及辅机可以生产各类 PVC 塑料管材、异型材、板材、片材、棒材及造粒。

螺杆采用油冷却系统冷却。机筒采用特殊风冷却系统冷却。系统采用专用电脑控制。根据用户不同配方要求，配制结构最合理螺杆，以达到最佳塑化状态及物流质量。螺杆全部采用高精度专用数控螺杆铣床加工，可确保每台同类挤出设备挤出性能高度 - 致性。率先引入国际最先进变螺距，变深度螺杆设计技术，使物流在螺杆中剪切、压缩更柔和，更接近实际需要。分配箱特殊设计，推力轴承格外加大，轴承采用原装进口，传动寿命高，可承受更大挤出压力。电器系统最大限度采用进口原件，并具有多项故障报警功能，故障少，排除方便。冷却系统设计特殊，散热面积格外加大，冷却迅速，温控精度可达  $\pm 1^{\circ}\text{C}$ 。

### Characteristics of the equipment

Model SJZ series twin conical screw extruder is a kind of special equipment for extruding PVC powder. With different sorts of molds and auxiliary machines, it can produce all sorts of PVC plastic pipe material, profiled material, board material, sheet material, bar material and granulation.

The screw has applied oil cooling system. Barrel is cooled by special wind cooling system. The system has applied special computer control. According to customer's requirements, most reasonable screw can be made so as to achieve best plasticity state and material quality. The screw is made by high precision special digital screw miller; extruding property can be highly harmonized. It has firstly introduced advanced technique of producing screw with variable pitch and depth, so that the material can be more softly sheared and cut. The distribution box is specially designed, pull force bearing is fully imported, and the drive life span can be prolonged. It can bear larger extruding pressure. The electrical system has mainly applied imported parts, it has multiple alarm system, and there are few problems which can be easily eliminated. The cooling system has applied special design, heat emission area is enlarged, the cooling is rapid, temperature control tolerance can be  $\pm 1^{\circ}\text{C}$ .



### 用于管材挤出 Use for pipe extrusion

型号 Model	SJZ-45	SJZ-51	SJZ-55	SJZ-65	SJZ-80	SJZ-92	SJZ-110
螺杆直径 Screw diameter (mm)	45/90	51/105	55/110	65/132	80/156	92/188	110/220
主电机 Main motor(kw)	15	18.5	22	30/37	55	110	160
生产能力 Capacity(Kgs/h)	120	150	180	300	450	900	1400
中心高 Center height(mm)	1000	1000	1000	1000	1000	1150	1200
净重 Net weight(kg)	3000	3000	3500	4000	5500	8000	12000
长 × 宽 × 高 Dimensions(m)	3.3×1.2×2.1	3.6×1.1×2.1	3.6×1.1×2.1	4.2×1.5×2.4	4.7×1.5×2.4	6×1.6×2.5	5.4×1.8×3.0

### 用于型材挤出 Use for profile extrusion

型号 Model	SJZ-45	SJZ-51	SJZ-55	SJZ-65	SJZ-80	SJZ-92	SJZ-110
螺杆直径 Screw diameter (mm)	45/90	51/105	55/110	65/132	80/156	92/188	110/220
主电机 Main motor(kw)	15	18.5	22	30/37	55	110	160
生产能力 Capacity(Kgs/h)	80	110	130	220	350	650	950
中心高 Center height(mm)	1000	1000	1000	1000	1000	1150	1200
净重 Net weight(kg)	3000	3000	3500	4000	5500	8000	12000
长 × 宽 × 高 Dimensions(m)	3.3×1.2×2.1	3.6×1.1×2.1	3.6×1.1×2.1	4.2×1.5×2.4	4.7×1.5×2.4	6×1.6×2.5	5.4×1.8×3.0

规格及标准设备若有变动，恕不另行通知

Specifications and standard equipment are subject to change without notification

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# Twin Parallel

## Different Direction Double Screws Extruder

## 平行异向双螺杆挤出机

### 设备特点:

SJP 型系列平行双螺杆挤出机是一种适合于各类 PVC 粉料挤出成形的专用设备。配备不同模具及辅机可以生产各类 PVC 塑料管材、异型材、板材、片材、棒材及造粒。

螺杆采用油冷却系统冷却。机筒采用特殊风冷却系统冷却。控制系统采用专用电脑控制。根据用户不同配方要求，配备结构最合理螺杆，以达到最佳塑化；状态及物料质量。螺杆全部采用高精度专用数控螺杆铣床加工，可确保每台同类挤出设备挤出性能高度一致性。率先引入国际最先进变螺距，变深度螺杆设计技术，使物料在螺杆中剪切、压缩更柔和，更接近实际需要。分配箱特殊设计，推力轴承格外加大。轴承采用原装进口，传动寿命长，可承受更大挤出压力。电器系统最大限度采用进口原件，并具有多项故障报警功能、故障少、排除方便。冷却系统设计特殊，散热面积格外加大，冷却迅速，温控精度可达  $\pm 1\text{C}$ 。平行双螺杆挤出机具有剪切力小的特点，特别适用于型材高速挤出，及大口径管材挤出。

### Characteristics of the equipment

Model SJP serials twin parallel screw extruder is a kind of special equipment for extruding of PVC powder. With different sorts of molds and auxiliary machines, it can produce all sorts of PVC plastic pipe material, profiled material, board material, sheet material, bar material and granulation.

The screw has applied oil system. Barrel is cooled by special wind cooling system. The control system has applied computer control. According to customer's requirements, most reasonable screw can be made so as to achieve best plasticity state and material quality. The screw is made by high precision special digital screw miller, extruding property can be highly harmonized. It has firstly introduced technique of producing screw with variable pitch and depth, so that the material can be more softly sheared and cut. The distribution box is specially designed, pull force bearing is fully imported, and the drive life span can be prolonged. It can bear larger extruding pressure. The electrical system has mainly applied imported parts, it has multiple alarm system, and there are few problems which can be easily eliminated. The cooling system has applied special design, heat emission area is enlarged, the cooling is rapid, temperature control tolerance can be  $\pm 1\text{C}$ .



### 用于管材挤出 Use for pipe extrusion

型号 Model	SJP75/28	SJP93/28	SJP114/28	SJP135/28
电机功率 Motor power(kw)	37	75	110	160
螺杆直径 Screw diameter (mm)	75	93	114	135
长径比 L/D Ratio	28:1	28:1	28:1	28:1
最大产量 Max.Output(kg/h)	350	460	680	1100
重量 Weight(kg)	4100	4700	6500	8400

### 用于型材挤出 Use for profile extrusion

型号 Model	SJP75/26	SJP93/26	SJP114/26	SJP135/26
电机功率 Motor power(kw)	22	37	55	90
螺杆直径 Screw diameter (mm)	75	93	110	130
长径比 L/D Ratio	26:1	26:1	26:1	26:1
最大产量 Max.Output(kg/h)	220	380	460	680
重量 Weight(kg)	4100	4700	6500	8400

### 用于片材挤出 Use for Board & sheet extrusion

型号 Model	SJP90/23	SJP105/23	SJP113/23	SJP120/23	SJP130/23
电机功率 Motor power(kw)	37	55	75	90	132
螺杆直径 Screw diameter (mm)	90	105	113	120	130
长径比 L/D Ratio	23	23	23	23	23
最大产量 Max.Output(kg/h)	300	400	500	600	800
重量 Weight(kg)	4500	6000	6500	7000	8000

规格及标准设备若有变动，恕不另行通知  
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# PE.PP16-2000

## Pipe Extrusion Line

### PE/PP16-2000 管材生产线

#### 设备特点:

PE 系列塑料管材生产线主要用于生产农用给排水、建筑给排水、线缆敷设等方面。该机组由真空定型台、牵引机、切割机、翻料架等组成。单螺杆挤出机及牵引机采用进口交流变频调速装置，真空泵及牵引电机均采用优质产品。牵引机有二爪、三爪、四爪、六爪、八爪、十爪、十二爪等牵引方式。可选用无屑切割、锯片切割或行星切割，机组性能可靠、生产效率高。本公司可以根据用户的要求，配备专用装置后生产内壁螺旋管、内壁空心管和芯层发泡管机组更换挤出机，可以生产 PP、PE 硅芯管等其它物料管材。生产线采用全自动电脑数控，具有操作方便，性能可靠等优点，达到国际领先水平。



#### Characteristics of the equipment

PE series plastic pipe extrusion line is mainly used in the area of agricultural water supply system, architectural water supply system, pavement of cables etc. This machine group consists mainly of vacuum calibration tank, haul-off unit, cutting unit, tilter etc. Single screw extruder and haul-off unit have applied imported A/C inverter; both vacuum pump and driving motor have applied excellent products. The haul-off unit includes two-claw type, three-claw type, four-claw type, six-claw type, eight-claw type, ten-claw type, twelve claw type...etc.

No-scrap cutting, saw cutting or planetary cutting can be applied, the property of machine group is reliable, the production efficiency is high. With special device, it can produce inner wall spiral pipe, inner wall hollow pipe, and core layer foam pipe etc. it can also produce PP, PE, ABS, PPR, PEX, silicon core pipe and pipe of other material. The planetary cutting machine is fully automatic computer digital control; it has such advantages of simple operation, reliable property, etc. It has reached world advanced level.



外径 De(mm)	壁厚 emin(mm)	11 外径 De(mm)12	壁厚 emin(mm)
110	3	760	11
140	3	800	12
160	3	850	12
200	3.2	900	12.5
225	3.5	1000	14
250	3.9	1150	14
315	4.9	1200	16
400	7.0	1400	18
450	7.0	1600	18
500	7.8	1750	23
560	8.8	1850	25
630	10	1960	27

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#### PE/PP/PPR/PERT 管材生产线技术参数

#### Technical Date of PE/PP/PPR/PERT Pipe Production Line

生产管径 Pipe diameter	16-63	32-125	75-250	110-450	315-630	315-800	450-1000	630-1200	710-1400	1000-1600	1400-2000
主机 main extruder	45/33	75/33	60/33	60/38 75/33	75/38 90/33	90/38 120/33	105/38 150/33	105/38 150/33	120/38 150/33	150/38 150/33	150/38 150/33
模具 Die head	单出 Single outlet	双出 Double outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet
辅机 Down-stream equipment	LG63	SLG63	LG125	LG250	LG450	LG630	LG800	LG1000	LG1200	LG1400	LG1600
总功率 Total power	70	125	150	230	380	550	800	800	1000	1100	1200

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# PE.ABS.PVDF

## Pipe Production Line

### PE.ABS.PVDF 管生产线

#### 设备特点:

该生产线由采用德国最新技术制造, 根据 PP-R、PP-B、PE-RT、PEX 独特的加工性能设计制造的高效挤出机, 配以高扭力减速机、新型开槽机筒、LTM 高效螺杆、挤出量大、物料熔温低, 真正实现低温塑化。

可高速生产 PP-R、PP-B 管材, 所出的产品经国家化学测试达到国标 GB/T-18742.2-2003 PE-RT, PEX 符合国标 GB/T18992.2-2003 标准。该生产线主要由控制系统、挤出机、模头、定径系统、牵引切割装置、打印机、翻料架或收卷机等组成。机头模具为螺旋分流式机头或篮式机头, 可配静态混炼系统, 料层彼此充分叠加, 内部压力分布更均匀。采用特殊的真空定径和喷淋冷却系统: 真空定径箱为两段, 完善的水温、水位以及流量控制确保生产出高质量的管材。生产线稍作变化, 配不同模具、螺杆及附属设备, 可生产 PE、ABS、PE-RT、PEX 管以及两种不同材料的塑料复合管。高档机采用 PLC 与大屏幕彩色显示屏组成的控制系统, 自动化程度高。

#### Characteristics of the equipment

This line is made by the advanced technic from Germany and designed as the high efficient extruder according to the producing characteristics of PP-R, PP-B, PE-RT and PEX, and consists of high torque gearbox, new type slotted barrel with the high output, low melting temperature and realize the low temperature plastification indeed.

The line can produce the PP-R and PP. B pipe with high speed. And its products have been reached the standard of GB/T-18742.2-2003 approved by China State Chemical Test Center. PE-RT and PEX pipe reached the standard of GB/T18992.2-2003. The production line consists of control system, extruder, die head, vacuum calibration unit and haul-off and cutting units, printer and Stacker and pipe collector. The die head adopt lattice or spiral mould and can suit for the static mix system. Special vacuum calibration unit and spraying cooling bath: two section vacuum calibration unit, perfect water temperature, water lever and flow rate contort to guarantee the pipe products with high quality. After simply changing the section of line, e.g. Different dies, screws and other accessories, it can also produce PE,ABS,PE-RT and PEX pipes and over two kinds of materials combining plastic pipes. High lever machine apply the PLC and color screen to be the control system with high automatization.

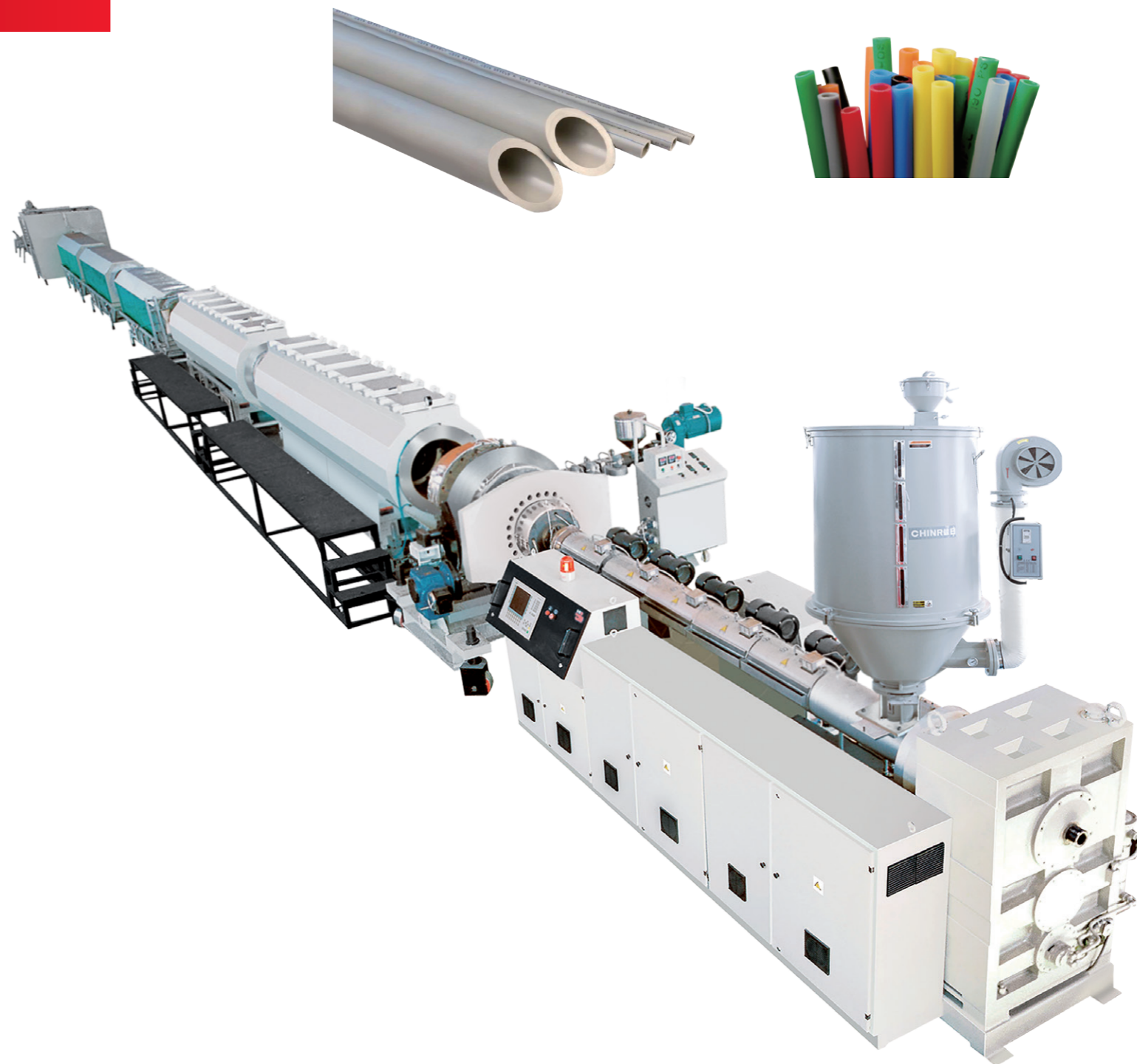
#### PE/PP/PPR/PERT 管材生产线技术参数

#### Technical Date of PE/PP/PPR/PERT Pipe Production Line

生产管径 Pipe diameter	16-63		75-160		110-250
主机 main extruder	45/33	60/33	60/33	75/33	75/33
模具 Die head	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet
辅机 Down-stream equipment	LG63	SLG63	LG160	LG160	LG250
总功率 Total power	70	90	130	150	225

规格及标准设备若有变动, 恕不另行通知

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# PE.EVOH Co-Extrusion

## Pipe Production Line

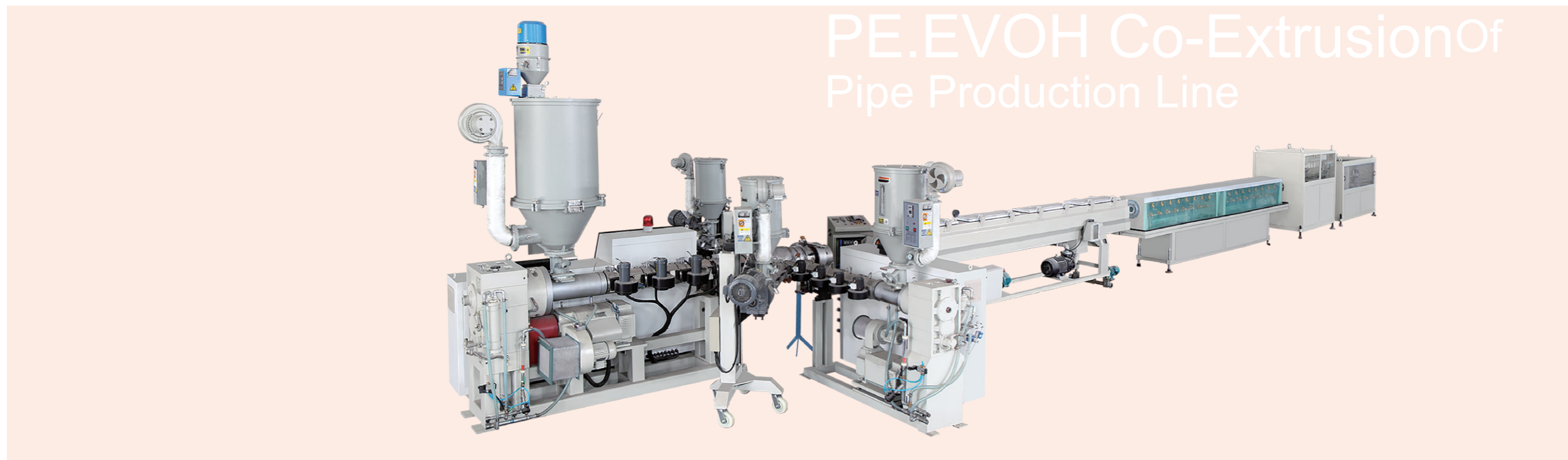
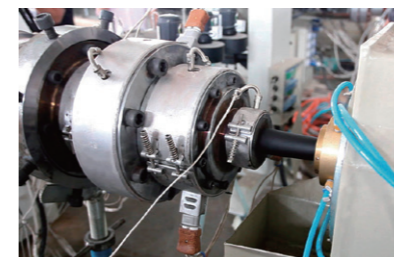
### PE.EVA.EVOH .EVA.PE 五层共挤生产线

#### 设备特点:

该生产线依据多年年的设计生产经验，结合欧洲先进管业设备制造的工艺技术，开发研制成完整的多功能的共挤复合生产线，从挤出机开始包括所有的自动化单元及周边设备，整个生产线实现从进料到成品的全线可实现自动控制。复合共挤标准系列：Φ10-Φ630。螺旋分配型或篮式分流体。大流动空间保证了熔体有足够的停留时间。低熔融温度的最佳设计。管材内的内应力小，内外表面光滑。设计高灵活性，适用于所有 PP、PE、PP-R、EVOH、PA、ABS 等多种聚烯烃材料的二层、三层、四层、五层共挤成型。

#### Characteristics of the equipment

On the basis of many years design and production experience, we absorbed in the European advanced technology of pipe industry, and have developed this integrated multifunctional co-extrusion production line. This complete line from extruder to the down-stream line, from the raw material to the finished product, every steps is automation. The compound co-extrusion standard series from Φ 10 to Φ 630. The spiral distribution type or basket distribution type spindle assure enough flow space and time for the melt material with a low temperature, which will assure the finished pipe with smaller innerstress and smooth surface. The flexible design is suitable for PP ,PE ,PP-R,EVOH,PA. ABS, various kinds of polyolefin material for co- extrusion two layers, three layers, four ayers and five layers.



# PVC $\emptyset$ 16- $\emptyset$ 2000

## Pipe Production Line

### PVC $\emptyset$ 16- $\emptyset$ 2000 管材生产线



#### 设备特点:

GF 系列塑料管材生产线主要用于生产农用给排水、建筑给排水、线缆敷设等方面和各种管径、壁厚的塑料 PVC 管材。该机组由锥形（平行）双螺杆挤出机、真空定型台、牵引机、切割机、翻料架等组成。螺杆挤出机及牵引机采用进口交流变频调速装置，真空泵及牵引电机均采用优质产品。牵引机有二爪、三爪、四爪、六爪、八爪等牵引方式。可选用锯片切割式或行星切割式，另带计长仪及增厚装置，机组性能可靠、生产效率高。本公司可以根据用户的要求，配备专用装置后生产内壁螺旋管、内壁空心管和芯层发泡管机组更换挤出机，可以生产 PP、PE、ABS、及 PPR、PEX、硅芯管等其它物料管材。行星切割机采用全自动电脑数控，具有操作方便，性能可靠等优点，达到国际领先水平。

#### Characteristics of the equipment

GF series plastic pipe extrusion line is mainly used in the area of agricultural water supply system, architectural water supply system, pavement of cables.. etc. as well as PVC pipe material of all sorts of pipe caliber and wall thickness. This machine group consists mainly of twin conical (parallel) Screw extruder, vacuum calibration tank, haul-off unit, cutting unit, tilter.. etc. The Screw extruder and haul-off unit have applied imported A/C inverter; both vacuum pump and driving motor have applied excellent products. The drawing machine includes two-claw type, three-claw type, four-claw type, six-claw type, eight-claw type...etc.. Sawing cutting or planet cutting can be applied, it is additionally applied with length measuring meter and thickness increasing device, the property of machine group is reliable, the production efficiency is high. With special device, it can produce inner wall spiral pipe, inner wall hollow pipe, and core layer foam pipe...etc. it can also produce PP,PE,ABS,PPR,PEX, silicon core pipe and pipe of other material. The planetary cutting machine is fully automatic computer digital control; it has such advantages of simple operation, reliable property, etc. It has reached world advanced level.



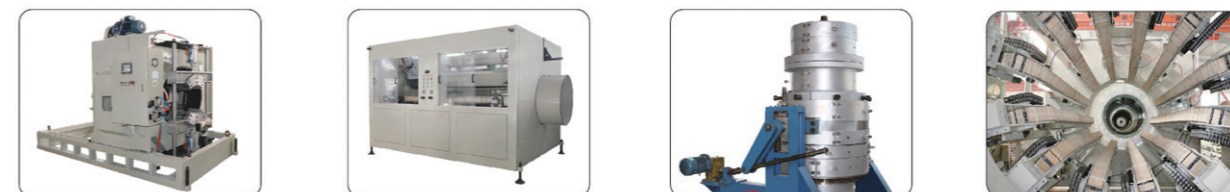
#### PVC 管材生产线技术参数

#### Technical Date of PE/PVC Pipe Extrusion Line

生产管径 Pipe diameter	SJZ65/132						SJZ80/156				SJZ92/188		SJZ110/220		
主机 main extruder	16-63	32-110	63-200	16-32	20-63	63-110	63-110	110-250	200-400	200-400	315-630	315-630	400-1000		
模具 Die head	双出 Double outlet	四出 Four outlet	单出 Single outlet	单出 Single outlet	四出 Four outlet	双出 Double outlet	单出 Single outlet	双出 Double outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet	单出 Single outlet		
辅机 Down-stream equipment	SGF63	FGF63	GF110	GF200	FGF63	SGF63	GF110	SGF110	GF110	GF250	GF400	GF400	GF630	GF630	GF1000
总功率 Total power	91	85	85	86.5	91	85	85	136	103	114	131	212	220	270	500

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# PVC $\varnothing 16$ - $\varnothing 32$

## Four Outlet Pipe Production Line

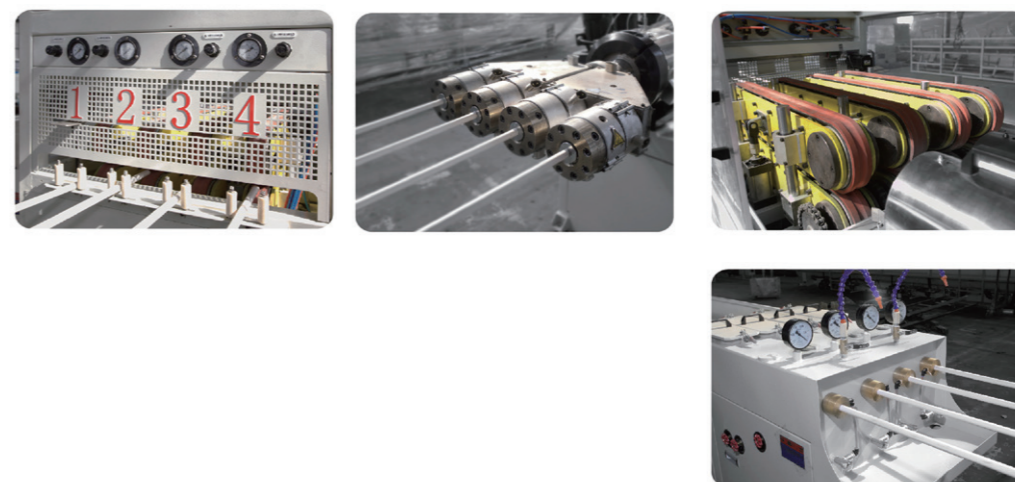
### PVC 管 1 出 4 管材生产线

#### 设备特点:

要用于生产各类给水、排水、电工穿线管等。该机组采用高效节能锥形双螺杆挤出机，通过专用模具一次性挤出四根 PVC 管材，有效的节约能源、提高生产速度，节省占地面积和人力成本。专为一出四设计的无屑切割机，采用变频独立调速，可根据切割需要调整切割速度，使用哈夫式夹紧装置，使夹具使用寿命更长，使制品切割面平整、无毛刺，而且彻底解决了塑料切屑的污染和切屑粉尘问题，专为一出四 PVC 管材设计的自动控制系统，采用 PLC 电脑控制，操作简便，全线联动，故障报警，自动化程度高，生产稳定可靠。

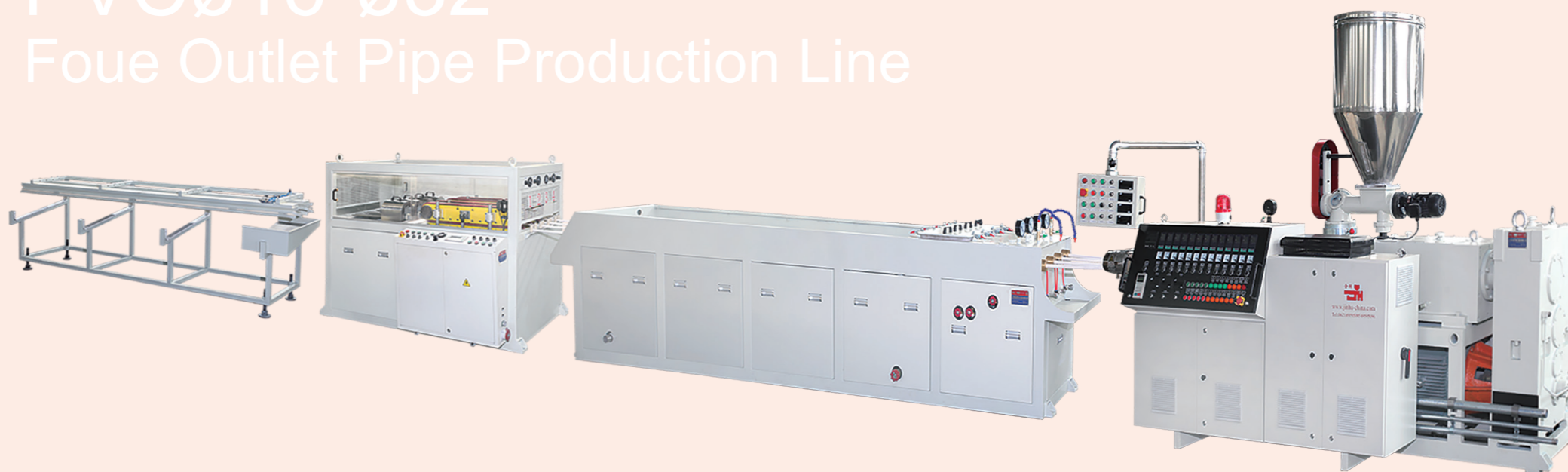
#### Characteristics of the equipment

Mainly applying in water-supply pipe, drainage pipe, electrical threading pipe and other area. This extrusion line, equipped with high-efficient & energy-saving twin conical screws extruder, produces PVC pipes four outlet at once by specially designed die mould. Which means high-efficient energy-saving, increasing extrusion speed, economical occupied saving, and low human cost. The non-scrap cutting unit controlled by inverter independently arrangeable cutting speed, compacted by half to ensure long service life and flat and smooth cutting surface without dust trouble. special designed automatic controlled system with good features of easy operation, the whole line linkage, failure alarms, high-efficient control and stable extrusion.



# PVC $\varnothing 16$ - $\varnothing 32$

## Foue Outlet Pipe Production Line



# PE.ABS.PVDF.MPP

## Pipe Production Line

### PE.ABS.PVDF.MPP 管生产线

#### 设备特点:

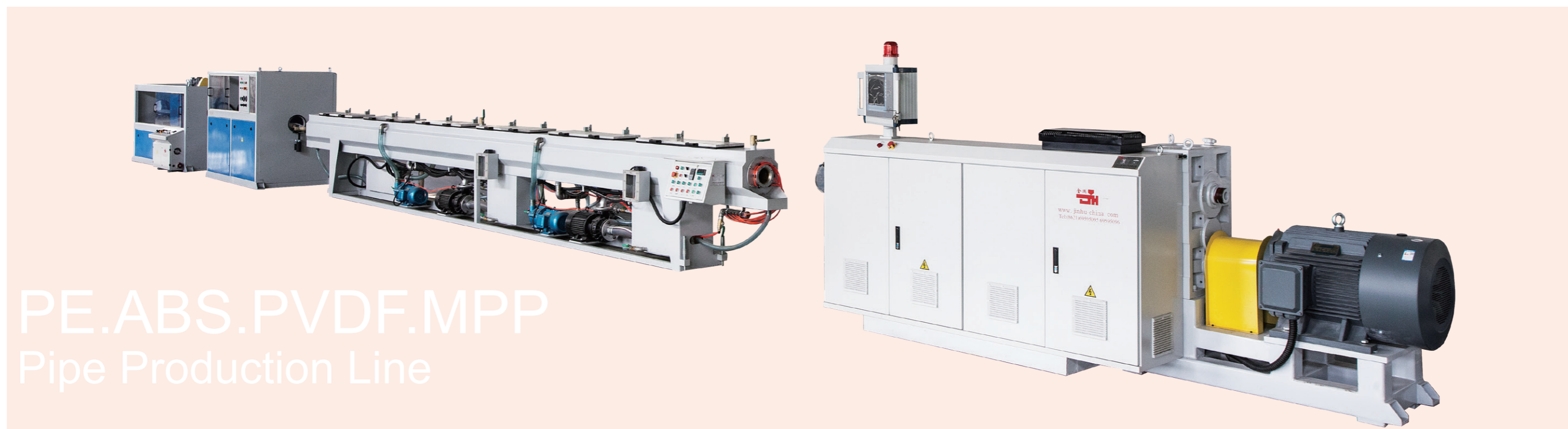
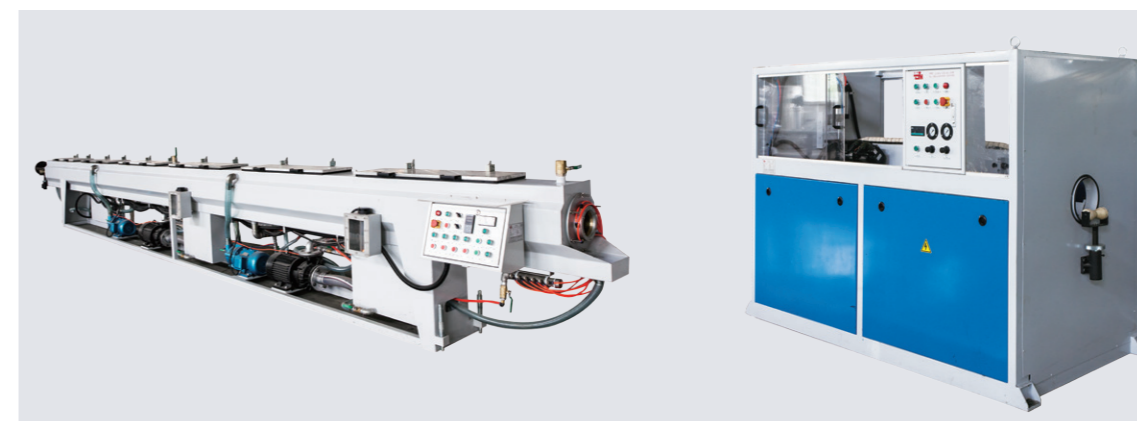
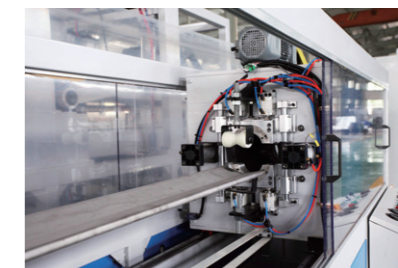
该生产线由采用德国最新技术制造，根据 PP-R、PP-B、PE-RT、PEX 独特的加工性能设计制造的高效挤出机、配以高扭力减速机、新型开槽机筒、LTM 高效螺杆、挤出量大、物料熔温低，真正实现低温塑化。

可高速生产 PP-R、PP-B 管材，所出的产品经国家化学测试达到国标 GB/T-18742.2-2003 PE-RT，PEX 管符合国标 GB/T18992.2-2003 标准。该生产线主要由控制系统、挤出机、模头、定径系统、牵引切割装置、打印机、翻料架或收卷机等组成。机头模具为螺旋分流式机头或篮式机头，可配静态混炼系统，料层彼此充分叠加，内部压力分布更均匀。采用特殊的真空定径和喷淋冷却系统：真空定径箱为两段，完善的水温、水位以及流量控制确保生产出高质量的管材。生产线稍作变化，配不同模具、螺杆及附属设备，可生产 PE、ABS、PE-RT、PEX 管以及两种不同材料的塑料复合管。高档机采用 PLC 与大屏幕彩色显示屏组成的控制系统，自动化程度高。

#### Characteristics of the equipment

This line is made by the advanced technic from Germany and designed as the high efficient extruder according to the producing characteristics of PP-R, PP-B, PE-RT and PEX, and consists of high torque gearbox, new type slotted barrel with the high output, low melting temperature and realize the low temperature plastification indeed.

The line can produce the PP-R and PP. B pipe with high speed. And its products have been reached the standard of GB/T- 18742.2-2003 approved by China State Chemical Test Center. PE-RT and PEX pipe reached the standard of GB/T18992.2-2003. The production line consists of control system, extruder, die head, vacuum calibration unit and haul-off and cutting units, printer and Stacker and pipe collector. The die head adopt lattice or spiral mould and can suit for the static mix system. Special vacuum calibration unit and spraying cooling bath: two section vacuum calibration unit, perfect water temperature, water lever and flow rate contort to guarantee the pipe products with high quality. After simply changing the section of line, e.g. Different dies, screws and other accessories, it can also produce PE,ABS,PE-RT and PEX pipes and over two kinds of materials combining plastic pipes. High lever machine apply the PLC and color screen to be the control system with high automatization.



# PE.ABS.PVDF.MPP

## Pipe Production Line

# PVC

## Vacuum Calibration Tank

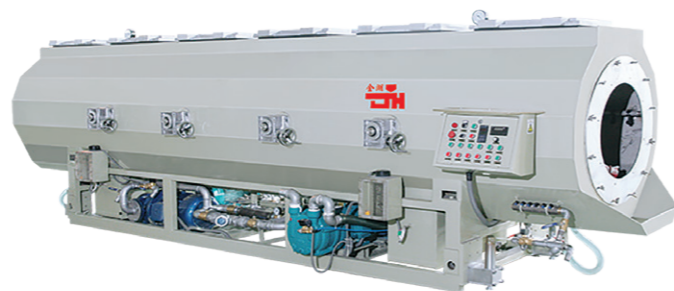
### PVC 真空定径机

#### 设备特点:

1. 优化设计的真空定径箱及水路系统均采用不锈钢制作。
2. 水路系统及真空系统稳定可调。
3. 真空箱前后、上下、左右可调。

#### Characteristics of the equipment

1. Optimized design tank and water pipe system made from stainless steel.
2. Water pipe and vacuum system stability and adjustable.
3. Vacuum table adjustable in 3-D direction.



#### PVC 真空定径箱技术参数

#### Parameter of PVC Vacuum Calibration Tank

型号 Model	FZD63×2	FZD63-S	FZD63	FZD110-S	FZD110	FZD160	FZD250	FZD400	FZD630	FZD800
生产管径 (mm) Pipe range	φ16-φ63	φ16-φ63	φ16-φ63	φ63-φ110	φ63-φ110	φ63-φ160	φ110-φ250	φ200-φ400	φ315-φ630	φ400-φ800
水泵 (Kw) Water pump(s)	7.5	2×4	4	2×4	5.5	5.5	7.5	2×5.5	2×7.5	3×7.5
真空泵 (Kw) Vacuum pump(s)	4	2×2.2	3	2×3	3	4	5.5	2×4	2×4	4×4
箱体长度 (mm) Length of vacuum calibration tank	6000									10000

规格及标准设备若有变动, 恕不另行通知

Specifications and standard equipment are subject to change without notification

# PE

## Vacuum Calibration Tank

### PE 真空定径机

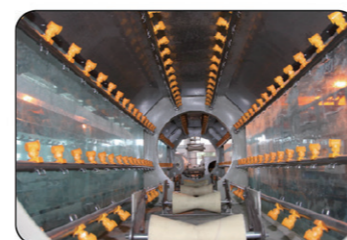


#### 设备特点:

1. 优化设计的真空定径箱及水路系统均采用不锈钢制作。
2. 水路系统及真空系统稳定可调。
3. 真空箱前后、上下、左右可调。

#### Characteristics of the equipment

1. Optimized design tank and water pipe system made from stainless steel.
2. Water pipe and vacuum system stability and adjustable.
3. Vacuum table adjustable in 3-D direction.



#### PE 真空定径箱技术参数

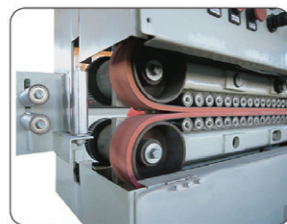
#### Technical Datar of PE Vacuum Calibration Tank

型号 Model	STV63	STV125	STV250	STV450	STV630	STV800	STV1000	STV1200	STV1400	STV1600	ST2000
生产管径 (mm) Pipe range	φ16-φ63	φ32-φ125	φ63-φ250	φ110-φ450	φ250-φ630	φ315-φ800	φ500-φ1000	φ630-φ1200	φ710-φ1400	φ1000-φ1600	φ1400-φ2000
水泵 (Kw) Water pump(s)	4	5.5	7.5	2×5.5	2×7.5	3×7.5	2×4+4×4	2×7.5+4×11	2×7.5+4×11	2×7.5+4×11	2×11+4×11
真空泵 (Kw) Vacuum pump(s)	2.2	3	5.5	2×4	2×4	4×4	2×5.5+4×7.5	2×4+4×5.5	2×5+4×5.5	2×5+4×5.5	2×5+4×5.5
箱体长度 (mm) Length of vacuum calibration tank	6000					1500+8500		1500+10500			2500+8000

规格及标准设备若有变动, 恕不另行通知

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# 2-Caterpillars Haul-off Unit 二履带牵引机



皮带式牵引机  
Belt type haul-off unit



## 牵引机技术参数

### Technical Date of Caterpillar Haul-off Units

型号 Model	QY63P	QY63L	QY160L	QY250L	QY450L	QY630L	QY800L	QY1200L	QY1400L	QY1600L	QY1800L	QY2000L
生产范围 (mm) Production range	20-63	20-63	63-160	63-250	110-450	315-630	400-800	630-1200	500-1400	800-1600	1000-1800	1200-2000
牵引方式 Drawing method	皮带	履带	履带	履带	履带	履带	履带	履带	履带	履带	履带	履带
最快牵引速度 (m/min) Haul-off speed	2-20	1.6-16	0.5-5	0.4-4	0.15-1.5	0.1-0.7	0.1-0.7	0.04-0.4	0.04-0.4	0.04-0.4	0.04-0.4	0.04-0.4
有效牵引长度 (mm) The length of the traction	6000	1000	1200	1400	1500	1600	2000	2400	2600	2600	2600	2800

规格及标准设备若有变动, 恕不另行通知  
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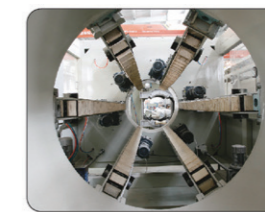
# Multi- Caterpillars Haul-off Unit 多履带牵引机

## 设备特点:

- 履带传动采用直联式变频调速控制。
- 上部履带采用气缸柔性压紧, 自动适应管材规格变化, 并与管材保持良好的接触压力, 下部履带根据管材规格电动调节上下。
- 采用 V 型高摩擦系数橡胶块。

## Characteristics of the equipment

- Drive by coupling and controlled by inverter.
- Upper caterpillar adopt cylinder flexible pinched to suit for different pipe diameter and keep contact pressure reason. Lower caterpillar is adjustable electrical as per pipe diameter.
- Adopt V-shaped rubber bad with high friction factor.



# Multi- Caterpillars Haul-off Unit



# Knife Cutting Machine

## 飞刀切割机

### 设备特点:

1. 采用特殊刀具，切口光滑美观。
2. 采用伺服电机驱动，稳定可靠。
3. 切割频率大于 60 次 / 分钟 (注  $\phi 50\text{mm}$  以下)。

### Characteristics of the equipment

1. With special saw blade for smooth cut.
2. Adopt servo-motor to make drive stability.
3. Cutting frequency is more than 60 times/minute for pipe diameter  $\leq 50\text{mm}$ .



# Planetary Cutting Unit

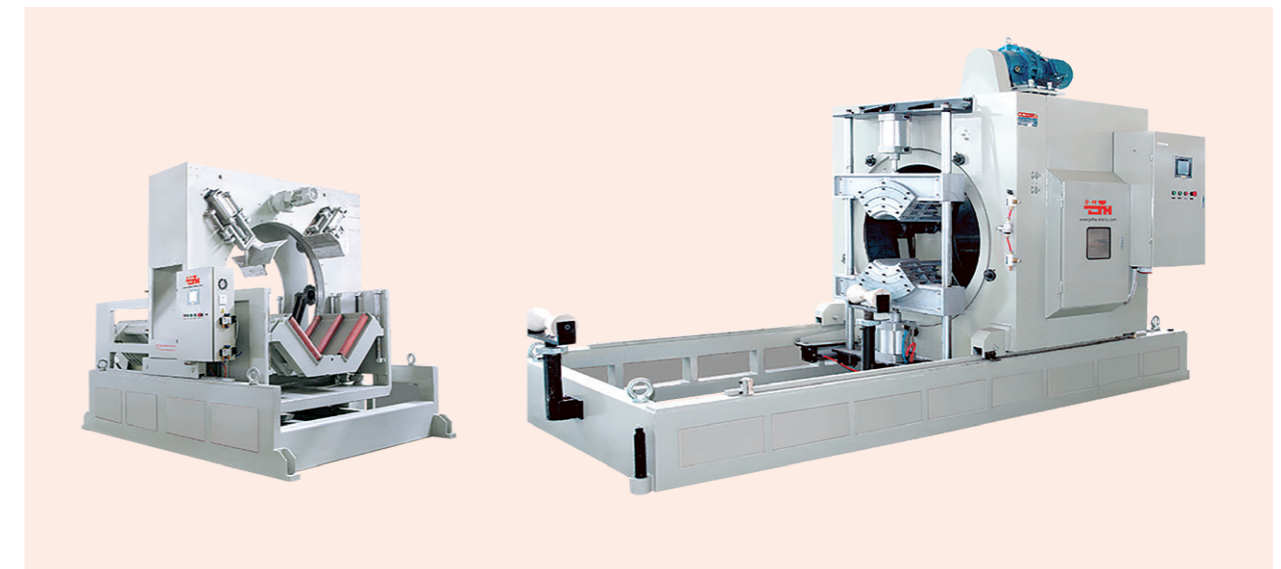
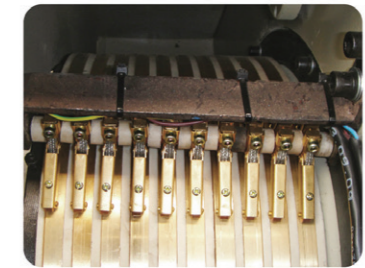
## 行星切割机

### 设备特点:

1. 采用特殊结构锯片，切口光滑美观。
2. 切割及倒角可同步完成。

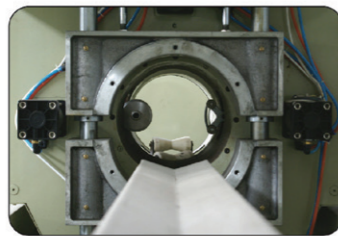
### Characteristics of the equipment

1. With special saw blade for smooth cut
2. Cutting and chamfering is synchronal



# No-scrap Cutting Unit

## 无屑切割机



### 切割机技术参数

#### Technical Parameter of Cutting Unit

型号 Model	32 四出	63		63 双出	110 双出	125	250		450		
切割范围 (mm) Cutting range		$\phi 16-\phi 63$				$\phi 32-\phi 160$	$\phi 63-\phi 250$		$\phi 160-\phi 500$		
切割方式 (mm) Cutting method	离心式 无屑切割 Centrifugal chipless cutting	高速飞刀 Fly sawin high speed	行星无屑 Planetary&non- scrap	抬到切割 Liftable saw blade	抬到切割 Liftable saw blade	抬刀锯片 Liftable saw blade	行星无屑 Planetary&non- scrap	行星锯片 Planetary saw blade	行星无屑 Planetary&non- scrap	行星锯片 Planetary saw blade	
切割功率 (Kw) Cutting power	-	6.9	-	-	-	2.2	-	-	2.2	-	2.2/3
环绕功率 (Kw) Surrounding power	0.25	-	1.5	1.5	1.5	-	1.5	3	1.5	3	1.5

规格及标准设备若有变动，恕不另行通知  
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### 切割机技术参数

#### Technical Parameter of Cutting unit

型号 Model	630		800		1000		1200		1600		2000	
切割范围 (mm) Cutting range	$\phi 250-\phi 630$		$\phi 315-\phi 800$		$\phi 315-\phi 1000$		$\phi 630-\phi 1200$		$\phi 800-\phi 1600$		$\phi 1000-\phi 2000$	
切割方式 (mm) Cutting method	无屑 non- scrap	锯片 saw blade	无屑 non- scrap	锯片 saw blade	无屑 non- scrap	锯片 saw blade	无屑 non- scrap	锯片 saw blade	无屑 non- scrap	锯片 saw blade	无屑 non- scrap	锯片 saw blade
切割功率 (Kw) Cutting power	/	4	/	4	/	4	/	4	/	4	/	4
环绕功率 (Kw) Surrounding power	4	4	4	4	5	2.2	5	2.2	5	2.2	5	2.2

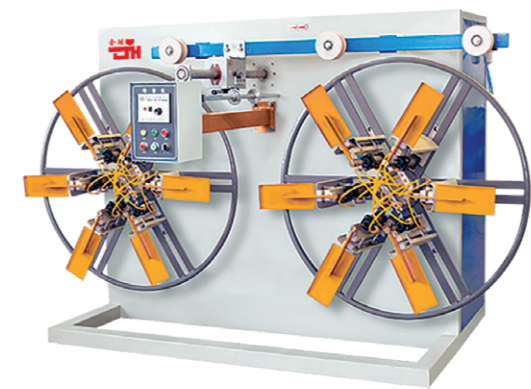
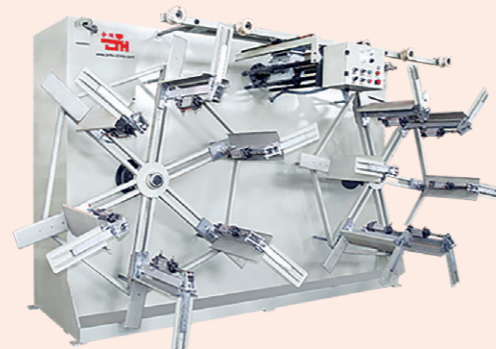
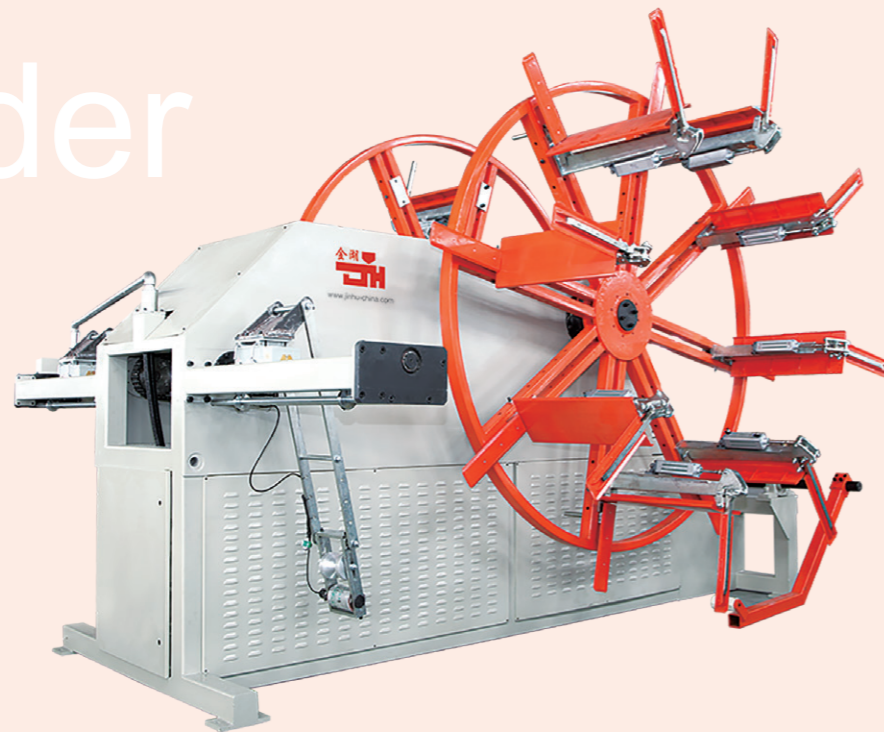
规格及标准设备若有变动，恕不另行通知  
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# Winder

## 收卷机

# Winder



### 收卷机技术参数 Technical Date of Winder

型号 Model	收卷内径 inner diameter of coil	收卷外径 Outside diameter of coil	收卷宽度 coil Width	收卷速度 Winding speed	管径 Pipe diameter	力矩电机 Moment motor
SPS-32 双工位 SPS-32 double stations	480-800mm	800-1200mm	200-370	1-20m/min	φ16-φ32	10N.M
SPS-63 双工位 SPS-63 double stations	600-1200mm	1400-2000mm	360-560	1-20m/min	φ32-φ63	25N.M
SP-110 单工位 SP-110 single station	2500-3500mm	-	700	0.5-5m/min	φ63-φ110	40N.M

规格及标准设备若有变动, 恕不另行通知  
Specifications and standard equipment are subject to change without notification

# PVC $\varnothing$ 16- $\varnothing$ 1000

## Die Head

### PVC $\varnothing$ 16- $\varnothing$ 1000 模具

#### 设备特点:

- 1、采用支架式流道结构，结构合理。
  - 2、基材使用 40Cr 材料，流道表面镀铬处理。
- PVC 模具标准规格: 16-50 双出 16-63, 75-110, 110-60, 160-250, 200-400, 400-630, 500-800, 630-1000。

#### Characteristics of the equipment

1. Adopt holding type runner, structure reasonable.
  2. Base material is 40Cr Steel, and chroming coated on runner surface
- PVC Die head standard specification: 16-50 double pipe, 16-63,75-110, 110-60,160-250,200-400,400-630,500-800,630-1000.



# PE.PP $\varnothing$ 16- $\varnothing$ 2000

## Die Head

### PE.PP16-2000 模具

- 1、采用篮式或螺旋式流道结构，结构合理。
- 2、基材使用 40Cr 或 45 # 钢锻打件，流道表面镀铬处理。

#### PE, PP 模具标准规格:

16-63, 32-125, 75-250, 160-450, 250-630, 315-800, 450-1000, 630-1200, 710-1400, 1000-1600, 1400-2000。

1. Adopt basket or spiral type runner, structure reasonable.
- 2 Base material is 40Cr or 45#, and chroming coated on runner surface.

#### PE, PP Die head standard specification:

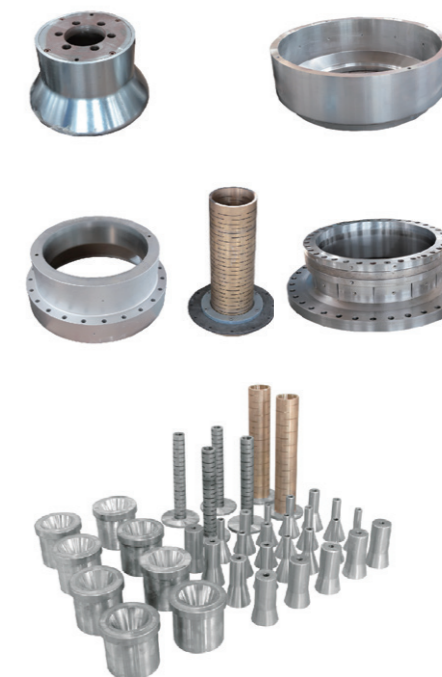
16-63, 32-125, 75-250, 160-450,250-630,315-800,450-1000,630-1200,710-1400, 1000-1600,1400-2000.



# Calibrating

## Sleeve

### 定径套



上海金湖可以提供所有工程塑料管材用定径套。包括如下优点

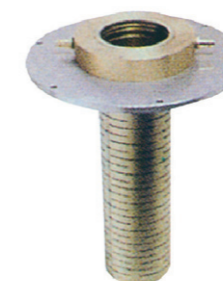
- 热传导率高
- 高耐磨性
- 优良的表面滑动性。

Jinhu can supply all sorts of calibration sleeve for engineering plastic pipe Merits as below:

- High thermal conductivity
- High abrasive resistance
- Surface sliding very well

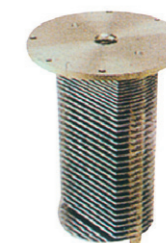
I 型: PVC, ABS

I type: PVC, ABS  
适用管径: 10-800mm  
Suitable pipe diameter:  
10-800mm



II 型: PB, PA, PO

II type: PB, PA, PO  
适用管径最大 32mm  
Suitable max pipe diameter:  
32mm



III 型 HDPE

III type: HDPE  
适用管径: 32-125mm  
Suitable pipe diameter:  
32-125mm



IV 型: HDPE

IV type: HDPE  
适用管径: 110-2000mm  
Suitable pipe diameter:  
110-2000mm



# PVC

## Profile Extrusion Line

### PVC 型材生产线

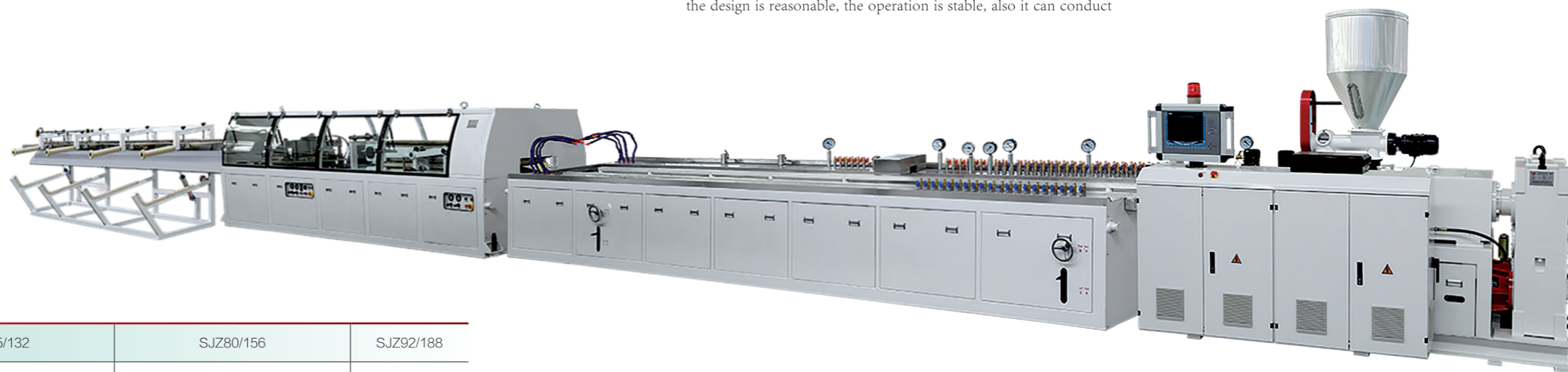
#### 生产线特点和功能:

YF 系列 PVC 异型材生产线主要用于 PVC 门窗型材、宽幅门板、窗台板、多孔穿线管(四孔、六孔、七孔、九孔等)挤出。该生产线可以根据不同型材断面及模具,选用不同规格的平行(锥形)双螺杆挤出机,并配置相应的真空定型台,牵引机,切割机,翻料平台等辅助设备。主机挤出量可以在每小时 60 公斤到 700 公斤之间任选。牵引机采用我公司独特升降技术,工作平稳,可靠性好,牵引力大。真空定型采用特殊加大涡流冷却系统,便于冷却定型,以满足高速挤出的需要。切割机移动速度与牵引速度保持同步,全部动作采用进口 PLC 电脑控制,设计合理,运行稳定,可自动定长切割,并配备粉尘回收装置。根据不同的模具,定型台可选用 4 米、6 米、8 米、11 米等规格。配置平行双螺杆挤出机,特别适用于型材高速挤出。

#### Characteristics and functions of the production line

YF series PVC profile extrusion line is mainly used in PVC door & window profile, wide door board, window board, extrusion of multi-holes tube for passing through lines ( four holes, six holes, seven holes, nine holes. .etc). For different sectional surface and die head, twin parallel ( conical) screw extruder of different specifications can be chosen together with corresponding vacuum calibrating table, haul-off unit, cutting unit, tilter...etc. Capacity of main frame can be optionally chosen from 60-700 Kg/h. The haul-off unit has applied unique lift technique of our JINHU Co. Stable work. good reliability and large pulling force. Vacuum setting has applied special enlarged vortex cooling system which is good for cooling and calibrating so as to meet demand of high speed extrusion. Movement speed and drawing speed of cutting machine keep synchronous. All movements are controlled by imported PLC, the design is reasonable, the operation is stable, also it can conduct

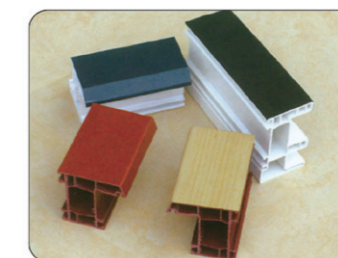
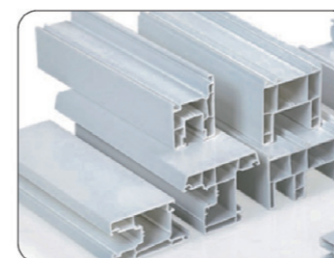
automatic cutting with fixed length. Powder & dust suction device can be provided. With different die tooling, the tiler platform can choose such specifications as 4 -meter, 6-meter,8-meter, 11-meter.. etc. With twin parallel screw extruder, it is particularly suitable for high speed extruding of profile material.



#### 主要技术参数 Main Technical Parameter

主机型号 Extruder Model	SJZ55/110	SJZ65/132		SJZ80/156		SJZ92/188
电机功率 Main motor power(kw)	22	37		55		110
辅机型号 Down-stream Equipment Model	YF240S	YF240A	YF300A	YF600	YF900	YF1200
制品宽度 Product width(mm)	Max240	Max240	Max300	Max600	Max900	Max1200
真空泵 Vacuum pump(kw)	2×5.5	4×5.5	4×5.5	4×5.5	1×7.5 2×11	2×7.5 2×11
水泵 Water pump(kw)	1.5	4	4	7.5	7.5	7.5
牵引速度 Haul-off speed	0-5	0-5	0-5	0-3	0-2.5	0-5
辅机功率 Down-stream Equipment power	22	35	35	44	25	62
挤出量 Output (kg/h)	100	220	220	350	350	750

规格及标准设备若有变动,恕不另行通知  
Specifications and standard equipment are subject to change without notification



# PVC.PE.PP

## Wood-plastic Profile Extrusion Line

### PVC,PE,PP 木塑型材生产线

#### 设备特点:

木塑挤出生产线:采用特殊设计的螺杆机筒、模具及挤出机加工工艺生产木塑产品。  
公司产品系列:木塑一步法厚板设备;木塑一步法异型材设备;木塑一步法装饰材设备;  
木塑造粒设备;各种木塑模具。

挤出机单机两级混合直接挤出,也可造粒后两步法挤出,省电省空间,具有产量高,挤出压力稳定,预热加料机置于主机顶部,先抽出大部分木粉中残留的水份,使主机加料段更加充实;塑化混炼效果好等特点。优化的螺杆设计使用剪切小,不易剪断木质纤维,能使物料在机内停留时间均匀。螺杆机筒采用双金属处理,耐磨耐腐蚀,使用寿命大大延长。

该生产线能生产 PE、PP 或 PVC 木塑异型材制品,主要用于托盘,包装箱板,地板,户外装饰材料等,用途十分广泛。木粉及植物纤维添加量高(最高可达 50-75%);设备适应能力强,可同时加工 PP、PE、ABS、PS 等。

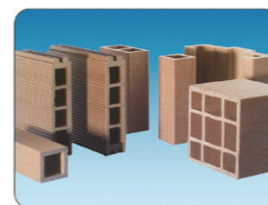
#### Characteristics of the equipment

Wood-Plastic profile extrusion lines adopt special design screw & barrel, die head and processing technique for wood-plastic products. Series products including: One step wood-plastic thick plate equipment; One step wood-plastic profile equipment; One step wood-plastic decorative material equipment; Wood-plastic granulation equipment; all sorts of wood-plastic die head.

Used two extruders extrusion directly, also can granulation and then with two stage approach extrusion, power saving and space efficient, high output and steady going extrusion pressure, preheating filling machine fixed on top of main extruder, extract most of water remaining in wood powder to make the feeding stage of extruder more solidify, plasticization and mixing performs very well. Optimized screw design allows a small clearance to make wood fiber not easy to shear and to ensure melting material residence well-distribute. Screw & barrel made with bimetallic and nitride to ensure wear resistant and corrosion resistance of equipment, so as to prolong service life.

This line applied to Wood-Plastic profiled products for PE, PP. and

PVC, mainly apply to pallet, packaging plate, floor, and out door decorating materials, widely application. Wood powder and plant fiber addition volume very high (Max. Can be reached to 50-75%), equipment with high flexibility to processing material such as PP, PE, ABS, PS at one time.



#### 主要技术参数

#### Main Technical Parameter

主机型号 Extruder Model	SJZ55/110M	SJZ65/132M			SJZ80/156M		SJZ92/188M
电机功率 Main motor power(kw)	22	37			55		110
辅机型号 Down-stream Equipment Model	YF240S	YF240A	YF300A	YF600	YF900	YF1200	
制品宽度 Product width(mm)	Max240	Max240	Max300	Max600	Max900	Max1200	
真空泵 Vacuum pump(kw)	2×5.5	4×5.5	4×5.5	4×5.5	1×7.5 2×11	2×7.5 2×11	
水泵 Water pump(kw)	1.5	4	4	4	7.5	7.5	
牵引速度 Haul-off speed	0-5	0-5	0-5	0-3	0-2.5	0-2.5	
辅机功率 Down-stream Equipment power	22	35	35	44	52	62	
挤出量 Output (kg/h)	90	220	220	320	650	650	

规格及标准设备若有变动,恕不另行通知  
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# PVC

## Plastic Wood Door Panel Extruding Production Line

### 宽幅门板生产线

#### 设备特点:

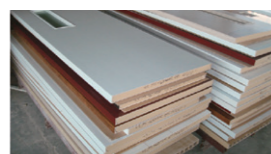
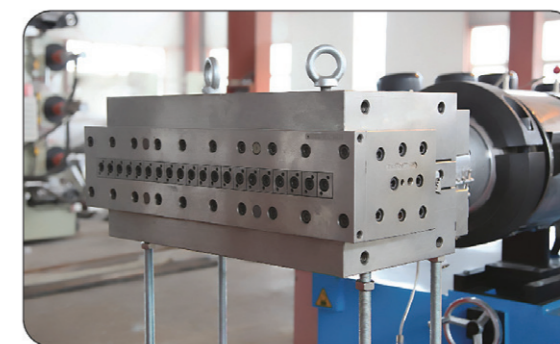
我公司研制生产的 PVC 木塑发泡板材生产线，所生产的制品—木塑发泡板集中了木材和塑料的优点，不仅有天然的外观且克服了天然木材的不足之处，具有同木材相类似的良好加工性能，可锯、可钉、可刨，使用木工工具即可完成，且握钉力明显优于普通木质材料；具有与硬木相当的抗压、抗冲击等物理机械性能，并且其耐用性明显优于普通木质材料；塑木材料及其产品，可抗强酸碱、耐水、耐腐蚀，并且不繁殖细菌，不易被虫蛀、不长真菌；还可以抗老化、防静电、阻燃。

本机组所生产的产品也可用于建筑模板、玩具积木用板、托盘、包装箱、集装器具等包装产品，底铺板、枕木等仓储用品，室外地板、护栏、园木椅等户外用品；室外地板、阳光房、指示牌、周转箱、场馆座椅、承重梁等。

#### Characteristics of the equipment

The company successfully developed the PVC wood-plastic foam plate production line. The product made by this line collects the advantages of wood and plastic. It not only has appearance of natural wood, it but also overcomes shortcoming of wood, it has good processing performance which is similar to wood, it can be sawed and nailed. It can be finished with woodworker tools. Its fixed force is clearly stronger than normal wood material. It has physical characteristics, such as resistance to compression, resistance to impact and others which are similar to hard wood, And its durable function is clearly better than normal wood. Wood-plastics material and its products can be resistance strong acid and alkali, water proof, corrosion resistance, besides, germ can not breed on it. It is not moth-eaten. It can be aging resistance, static electricity resistance.

The product made by this machine group can also be used in making building template, toy building blocks use the board, tray, ackage box, sleeper, outdoor floor, railings, garden chair and other outdoor facilities, indicating plate, circulating box, roof beam and others.



# PROFILE

## Haul-off Cutting Unit 型材牵引切割机

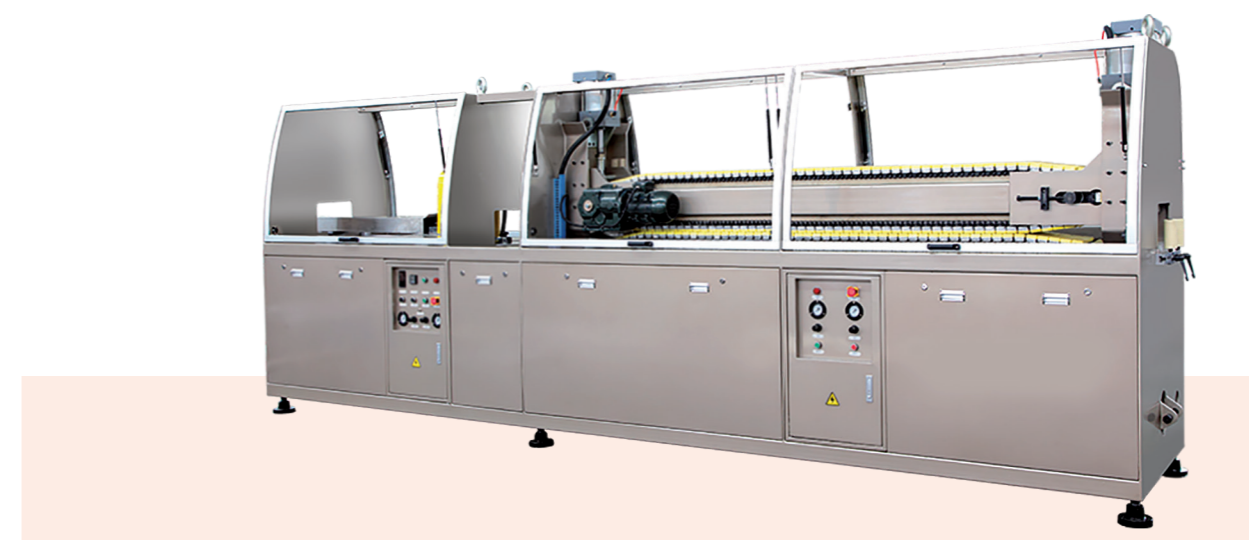
### 生产线特点和功能:

牵引机采用我公司独特升降技术，工作平稳，可靠性好，牵引力大。真空定型采用特殊加大涡流冷却系统，便于冷却定型，以满足高速挤出的需要。切割机移动速度与牵引速度保持同步，全部动作采用进口 PLC 电脑控制，设计合理，运行稳定，可自动定长切割，并配备粉尘回收装置。



### Characteristics and functions of the production line

The haul-off unit has applied unique lift technique of our JINHU Co. Stable work, good reliability and large pulling force. Vacuum setting has applied special enlarged vortex cooling system which is good for cooling and calibrating so as to meet demand of high speed extrusion. Movement speed and drawing speed of cutting machine keep synchronous. All movements are controlled by imported PLC, the design is reasonable, the operation is stable, also it can conduct automatic cutting with fixed length. Powder & dust suction device can be provided.



### 主要技术参数 Main Technical Parameter

型号 Extruder Model	YG240S	YF240A	YF300A	YG600	YF900	YG1200
牵引有效宽度 Product width(mm)	240	240	300	600	900	1200
牵引有效高度 Vacuum pump(mm)	140	140	140	140	140	140
牵引力 Water pump(kN)	2	4	4	4	4.5	5
牵引速度 Haul-off speed ( m/min)	0-5	0-5	0-5	0-3	0-2.5	0-2

规格及标准设备若有变动，恕不另行通知  
Specifications and standard equipment are subject to change without notification

# JH Series

## Co-extrusion Single Extruder

### 共挤机系列

#### 特点及用途:

我公司开发的 JH 系列前、后单螺杆共挤机引进德国最新技术，操作方便，物料适应范围广，主要用于型材表面的彩色共挤和型材密封胶条的共挤，以及聚烯烃管材的色带共挤。

#### Characteristics and applications

JH series back & forth single screw co-extruder is developed and imported the lasted German technique, easy operation and have a wide range use for different material, it is mainly used for color extrusion and sealing joint strip co-extrusion of profiled, and polyolefin Pipe color Co-extrusion.



#### 主要技术参数

#### Main Technical Parameter

型号 Model	JH20-20		JH25-20		JH30-25		JH35-25		JH45-25		JH50-25		SJZ45/90	
传动功率 Driving Power (kw)	0.55	1.1	1.1	2.2	3	5.5	5.5	7.5	7.5	11	11	15	15	15
螺杆直径 Screw diameter(mm)	20		25		30		35		45		50		45/90	
长径比 Ratio L/D	20		20		25		25		25		25		-	
物料 Material	PE/PP		1	2	3	4	-	-	-	-	-	-	-	-
	PMMA/ASA		-	-	-	-	-	10	12	15	18	25	-	-
	PVC		-	-	-	5	8	15	15	18	25	35	50	50
适用共挤范围 Application	色标线 Mark Line						前后共挤 Front/rear co-extruder			前共挤 Fron co-extruder				

规格及标准设备若有变动，恕不另行通知  
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# Granulation Machine Set

## 造粒机组



#### 造粒机组生产线技术参数

#### Technical parameter of Granulation Machine sets production line

主机型号 Main Extruder Model	主电机功率 Main motor power(kw)	切粒功率 Power cutting	切粒刀数 Number of power blade	风送节数 Step number of blowing	挤出量 Output (kg/h)
SJZ55/110	22KW	1.1KW	3	1	100
SJZ65/132	37KW	1.1KW	3	2-3	220
SJZ80/156	55KW	1.1KW	3	2-3	300
SJZ92/188	110KW	1.1KW	3	3-4	700

规格及标准设备若有变动，恕不另行通知  
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# PVC.PP.PE

## Full Auto-belling Machine

### PVC、PP、PE 全自动扩口机

#### 设备特点:

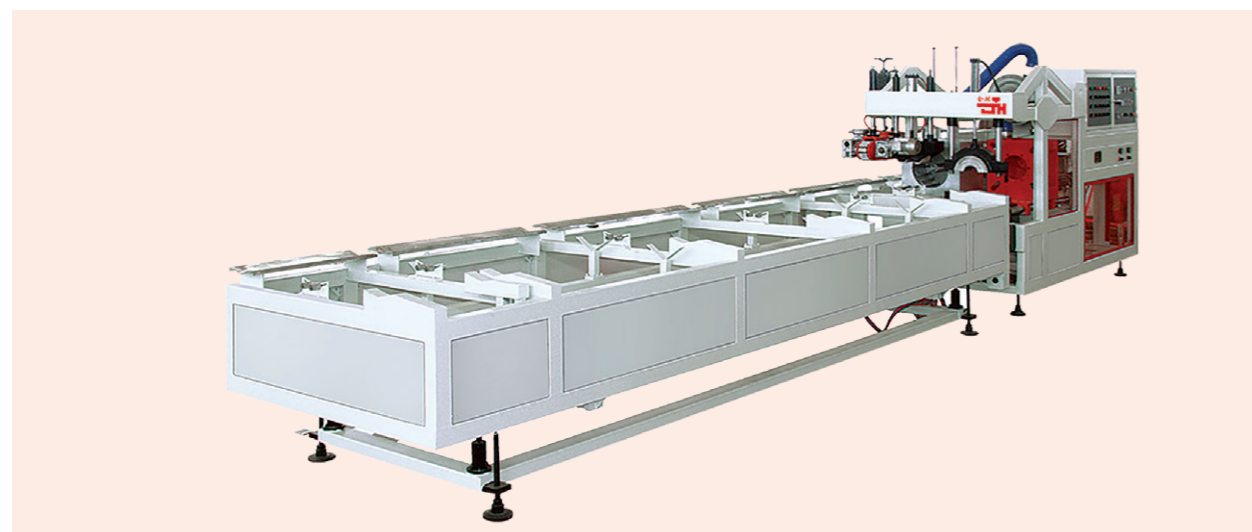
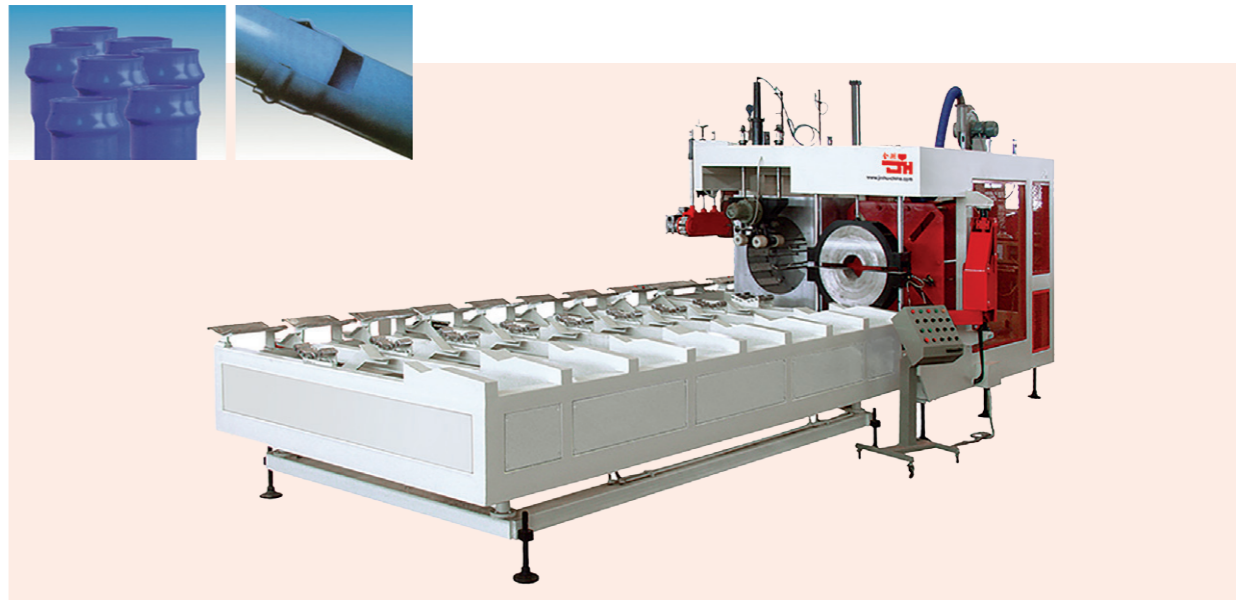
JHLK250、JHL K630 全自动扩孔机是我公司根据国内管材生产中市场需求。根据本公司的技术优势，借鉴国外先进设备而开发设计制造的产品。它具有外形美观，结构合理技术先进，操作方便等优点。

JHLK250、JHLK630 全自动扩孔机与相应的管材生产线、并配以相应的各规格扩孔模具，可完成  $\phi 75\sim\phi 630$  各规格内的塑料管材直口、凸口扩孔的全过程自动化生产。

#### Characteristics of the equipment

With our technical superiority and advanced technology drawing from abroad, we have designed and developed JHLK250、JHLK630 full auto-belling machine in accordance with market demand. They have merits of aesthetic appearance, reasonable structure, advanced technology and easy operation.

Matching with expanding die tooling of each specification and relevant pipe production lines ,JHLK250、JHLK630 full auto-belling machine can automatically finished the course of production on all specification of  $\phi 75\sim\phi 630$  pipe belling.



#### 主要技术参数

#### Main Technical Parameter

扩孔中心高距离	Belling center height of machine	1100~1200mm	900~1200mm
扩孔管材直径规格	Diameter range of pipe	(管材外径) $\phi 200\sim 630$ mm	(管材外径) $\phi 75\sim 250$ mm
扩孔管材最大长度	Max.Length of pipe	8000mm	8000mm
扩孔管材轮廓直径	Dimension of belling machine	(长×宽×高)8466×2901×2499mm	(长×宽×高)7656×1410×1900mm
工作移动距离	Distance of moving	900mm	600mm
扩孔机电总功率	Total power of belling machine	50KW	32KW
加热炉内外加热量大功率	Max.Outside heating power of heating furnace	16.8KW	15KW
加热炉内内加热量大功率	Max.Inner heating power of heating furnace	5KW	3KW
液压系统工作压力	Working pressure of hydraulic system	1.5~5.5Mpa	1.5~3.5Mpa
扩孔机用气最大压力	Max.Air pressure of belling machine	0.7Mpa	0.6Mpa
扩孔机整机重量	Weight of belling machine	700Kg	2800Kg

规格及标准设备若有变动，恕不另行通知

Specifications and standard equipment are subject to change without notification



# SRL-W

## Series Horizontal Type Mixer

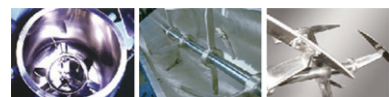
### SRL-W 系列卧式混合机组

#### 设备特点:

- 1、用于各种塑料的配料、混合、干燥、着色等工艺，是型材、管材生产厂家最理想的首选设备。
- 2、主轴密封装置具有电、汽两种加热功能。
- 3、锅盖采用双道密封，热混锅盖的开启采用气动，冷混锅盖开启采用气动或手动。
- 4、电气控制采用进口名牌仪表及控制元件，实现自动控制。
- 5、选配有脉冲除尘回收装置。
- 6、浆叶均通过静、动平衡试验机特殊试验。
- 7、另可选配简易上料系统。

#### Characteristics of the equipment

- 1.applied to all kinds of plastic technics such as mixture、mixing、drying、coloring, preferences by pipe manufacturers.
- 2.Shaft seal device with two functions of electrical heating and steam heating.
- 3.the cover adopt double sealing, hot compounding cover with pneumatic start, and cooling compounding cover with pneumatic start or manual start.
- 4.Imported famous meter and control elements equipped on electro control cabinet to achieve automation.
- 5.Matching pulse dust collector.
6. Blade has get through special test with static-dynamic balancing test.
- 7.Also can matching simple feeding system.



# SRL-Z

## Series Vertical Type Mixer

### SRL-Z 系列立式混合机组

#### 设备特点:

- 1、用于各种塑料的配料、混合、干燥、着色等工艺，是型材、管材生产厂家最理想的首选设备。
- 2、主轴密封装置具有电、汽两种加热功能。
- 3、锅盖采用双道密封，热混锅盖的开启采用气动，冷混锅盖开启采用液压系统。
- 4、电气控制采用进口名牌仪表及控制元件，实现自动控制。
- 5、选配有脉冲除尘回收装置。
- 6、浆叶均通过静、动平衡试验机特殊试验。
- 7、另可选配简易上料系统。



#### Characteristics of the equipment

- 1.applied to all kinds of plastics such as mixture technics mixing drying coloring preferences by profile & pipe manufacturers.
- 2.Shaft seal device with two functions of electrical heating and steam hating.
- 3.the cover ado double sealing. hot compounding cover with pneumatic start and cooling compounding over with pneumatic start or manual start.
4. imported famous meter and control elements equipped on electro control cabinet to achieve automation.
5. Matching pulse dust collector.
6. Blade has get through special lest with static-dynamic balancing test.
7. Also can matching simple feeding system.



# Standard 标准

**给水用聚乙烯 (PE80) 管材规格及理论重量表 (GB/T13663-2000)**  
Specification and Theoretical weight form of polyethylene Pipe (PE 80) for water supply (GB/T13663-2000)

公称外径 Nominal outside diameter mm	公称壁厚 en,mm Nominal wall thickness																
	标准尺寸 Standard size																
	SDR21			SDR17			SDR13.6			SDR11			SDR9				
	公称压力 MPa Nominal pressure																
0.6			0.8			1.0			1.25			1.6					
壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m			
20														2.3	0.5	0.103	
25														2.3	0.5	0.133	
32									2.3	0.5	0.172	2.8	0.5	0.201			
40									3	0.5	0.280	3.6	0.6	0.329			
50									3.7	0.6	0.432	4.5	0.7	0.511			
63			16						4.6	0.7	0.669	5.6	0.9	0.797			
75				4.5	0.7	1.020	5.6	0.9	1.251	6.8	1.1	1.491	8.4	1.3	1.790		
90	4.3	0.7	1.190	5.4	0.9	1.476	6.7	1.1	1.799	8.2	1.3	2.154	10.1	1.6	2.585		
110	5.3	0.8	1.783	6.6	1.0	2.191	8.1	1.3	2.657	10.0	1.5	3.199	12.3	1.9	3.844		
120	6	0.9	2.293	7.4	1.2	2.807	9.2	1.4	3.417	11.4	1.8	4.157	14	2.1	4.962		
140	6.7	1.1	2.886	8.3	1.3	3.517	10.3	1.6	4.291	12.7	2.0	5.189	15.7	2.4	6.238		
160	6.7	1.2	3.776	9.5	1.5	4.603	11.8	1.8	5.610	14.7	2.2	6.794	17.9	3.5	8.270		
180	8.6	1.3	4.736	10.7	1.7	5.834	13.3	2.0	7.105	16.4	3.2	8.744	20.1	4.0	10.464		
200	9.6	1.5	5.886	11.9	1.8	7.185	14.7	2.3	8.753	18.2	3.6	10.795	22.4	4.4	12.939		
225	10.8	1.7	7.453	13.4	2.1	9.123	16.6	3.3	11.315	20.5	4.0	13.663	25.2	5.0	16.389		
250	11.9	1.8	9.105	14.8	2.3	11.194	18.4	3.6	13.920	22.7	4.5	16.838	27.9	5.5	20.160		
280	13.4	2.1	11.507	16.6	3.3	14.325	20.6	4.1	17.479	25.4	5.0	21.092	31.3	6.2	25.335		
315	15	2.3	14.473	18.7	3.7	18.145	23.2	4.6	22.137	28.6	5.7	26.741	35.2	7.0	32.065		
355	16.9	3.3	18.715	21.1	4.2	23.083	26.1	5.2	28.082	32.2	6.4	33.927	39.7	7.9	40.754		
400	19.1	3.8	23.867	23.7	4.7	29.212	29.4	5.8	35.615	36.3	7.2	43.085	44.7	8.9	51.710		
450	21.5	4.2	30.176	26.7	5.3	37.022	33.1	6.6	45.146	40.9	8.1	54.597	50.3	10.0	65.452		
500	23.9	4.7	37.292	29.7	5.9	45.757	36.8	7.3	55.742	45.4	9.0	67.351	55.8	11.0	80.642		
560	26.70		46.23	33.20		56.28	41.20		69.39	50.80		83.96					
630	30		58.44	37.40		71.85	46.30		87.74	57.20		106.37					
710	33.90		74.41	42.10		91.29	52.20		111.48								
800	38.10		94.24	47.40		116.48	58.80		141.50								
900	42.90		119.38	53.30		146.52											
1000	47.40		147.48	59.30		181.11											
1200	57.2																

**埋地排污用硬聚氯乙烯 (PVC-U) 管材规格及理论重量表 (GB/T10002 3-1996)**  
Specification and Theoretical weight form of rigid polyethylene Pipe (PVC-U) for buried wastewater discharging

公称尺寸 mm Nominal diameter	S25		S20		S16.7	
	壁厚 mm wall thickness	质量 kg/m quality	壁厚 mm wall thickness	质量 kg/m quality	壁厚 mm wall thickness	质量 kg/m quality
110+0.4			3.2+0.6	1.756	3.2+0.6	1.756
125+0.4	3.2+0.6	2.003	3.2+0.6	2.003	3.7+0.6	2.280
140+0.5	3.2+0.6	2.250	3.5+0.6	2.438	4.1+0.7	2.841
160+0.5	3.2+0.6	2.580	4.0+0.7	3.189	4.7+0.8	3.721
180+0.6	3.6+0.6	3.235	4.4+0.7	3.921	5.2+0.8	4.600
200+0.6	3.9+0.6	3.873	4.9+0.8	4.860	5.9+0.9	5.792
225+0.7	4.4+0.7	4.928	5.5+0.9	6.139	6.5+1.0	7.187
250+0.8	4.9+0.8	6.108	6.2+1.0	7.678	7.3+1.1	8.953
280+0.9	5.5+0.9	7.680	6.9+1.1	9.564	8.1+1.3	11.179
315+1.0	6.2+1.0	9.729	7.7+1.2	11.990	9.2+1.4	14.227
355+1.1	7.0+1.1	12.355	8.7+1.4	15.301	10.3+1.6	17.979
400+1.2	7.8+1.2	14.493	9.8+1.5	19.352	11.7+1.8	22.991
450+1.4	8.8+1.4	19.710	11.0+1.7	24.455	13.1+2.0	28.949
500+1.5	9.8+1.5	24.321	12.3+1.9	30.377	14.6+2.2	35.813
560+1.7	11.0+1.7	30.594	13.7+2.1	37.880	16.3+2.5	44.839
630+1.9	12.3+1.9	38.490	15.4+2.4	47.960	18.4+2.8	56.906
710+2.2	13.9+2.1	48.492	17.4+2.7	61.046	20.0+2.9	71.447

**给水用聚乙烯 (PE100) 管材规格及理论重量表 (GB/T13663-2000)**  
Specification and Theoretical weight form of polyethylene Pipe (PE100) for water supply (GB/T13663-2000)

公称外径 Nominal outside diameter mm	公称壁厚 en,mm Nominal wall thickness																
	标准尺寸 Standard size																
	SDR26			SDR21			SDR17			SDR13.6			SDR11				
	公称压力 MPa Nominal pressure																
0.6			0.8			1.0			1.25			1.6					
壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m			
32														3.0	0.5	0.284	
40														3.7	0.6	0.439	
50														4.6	0.7	0.680	
63														4.6	0.7	0.680	
75														5.8	0.9	1.081	
90														6.8	1.1	1.515	
110	4.2	0.7	1.462	5.3	0.8	1.811	6.6	1.0	2.226	8.1	1.3	2.699	10.0	1.5	3.250		
125	4.8	0.8	1.897	6.0	0.9	2.329	7.4	1.2	2.851	9.2	1.4	3.471	11.4	1.8	4.223		
160	6.2	1.0	3.129	7.7	1.2	3.836	9.5	1.5	4.676	11.8	1.8	5.699	14.6	2.2	6.901		
180	6.9	1.1	3.916	8.6	1.3	4.811	10.7	1.7	5.935	13.3	2.0	7.217	16.4	3.2	8.882		
200	7.7	1.2	4.846	9.6	1.5	5.979	11.9	1.8	7.298	14.7	2.3	8.891	18.2	3.6	10.965		
225	8.6	1.3	6.079	10.8	1.7	7.571	13.4	2.1	9.267	16.6	3.3	11.494	20.5	4.0	13.879		
250	9.6	1.5	7.555	11.9	1.8	9.249	14.8	2.3	11.371	18.4	2.1	14.140	22.7	4.5	17.104		
280	10.7	1.7	9.445	13.4	2.1	11.689	16.6	3.3	14.551	20.6	3.6	17.755	25.4	5.0	21.425		
315	12.1	1.9	12.003	15.0	2.3	14.702	18.7	3.7	18.432	23.2	4.1	22.487	28.6	5.7	27.163		
355	13.6	2.1	15.188	16.9	3.3	19.011	21.1	4.2	23.447	26.1	4.6	28.525	32.2	6.4	34.462		
400	15.3	2.3	19.219	19.1	3.9	24.244	23.7	4.7	29.673	29.4	5.2	36.177	36.3	7.2	43.765		
450	17.2	3.3	24.216	21.5	4.2	30.652	26.7	5.3	37.606	33.1	5.8	45.859	40.9	8.1	55.459		
500	19.1	3.8	30.028	23.9	4.7	37.811	29.7	5.9	46.479	36.8	6.6	56.622	45.4	8.9	67.414		
560	21.4	5.0	37.42	26.7		46.23	33.20		56.78	41.20		69.39	50.80		83.96		
630	24.1		47.42	30		58.44	37.40		71.98	46.30		87.74	57.20		106.37		
710	27.20		60.29	33.9		74.41	42.10		91.29	52.20		111.48					
800	30.6		76.44	38		94.24	47.40		116.48	58.80		141.50					
900	34.4		96.67	42.9		119.38	53.0		146.52								
1000	38.20		119.28	47.70		147.48											
1200	46.2																
1400	53.9																
1600	61.6																

**给水用 PVC 管材规格及理论重量表 (ISO4422-2:1996)**  
Specification and Theoretical weight form of rigid polyethylene Pipe for water Supply (ISO4422-2:1996)

公称外径 Nominal outside diameter mm	公称壁厚 en,mm Nominal wall thickness															扩口端长度 mm				
	0.68MPa			0.8MPa			1.00MPa			1.25MPa			1.60MPa							
	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m	壁厚 mm	公差 mm	重量 kg/m					
20																2.0	0.4	0.178		
25																2.0	0.4	0.228		
32															2.0	0.4	0.298	2.4	0.5	0.354
40	2.0	0.4	0.379	2.0	0.4	0.379	2.0	0.4	0.379	2.4	0.5	0.571	3.0	0.5	0.692	3.0	0.5	0.544		
50	2.0	0.4	0.479	2.0	0.4	0.479	2.4	0.5	0.571	3.0	0.5	0.692	3.7	0.6	0.828					
63	2.0	0.4	0.609	2.5	0.5	0.754	3.0	0.5	0.884	3.8	0.6	1.100	4.7	0.8	1.344	114.2				
75	2.3	0.5	0.841	2.9	0.5	1.030	3.6	0.6	1.263	4.5	0.7	1.549	5.6	0.9	1.899	120.2				
90	2.8	0.5	1.207	3.5	0.6	1.491	4.3	0.7	1.807	5.4	0.9	2.241	6.7	1.1	2.732	131.0				
110	2.7	0.5	1.438	3.4	0.6	1.791	4.2	0.7	2.185	5.3	0.8	2.77	6.6	1.1	3.348	137.9				
125	3.1	0.6	1.882	3.9	0.6	2.310	4.8	0.8	2.836	6.0	0.9	3.481	7.4	1.2	4.262	143.1				
140	3.5	0.6	2.356	4.3	0.7	2.868	5.4	0.9	3.573	6.7	1.1	4.382	8.3	1.3	5.340	153.1				
160	4.0	0.6	3.048	4.9																