

Guangdong Liansu machinery manufacturing co.,ltd



LSP- 630PE 3-layers Co-extrude Pipe Production Line



Equipment composition

1	LSS80-40 Single Screw Extruder with Siemens motor and taiwan gearbox	1 set
2	LSS50-34 Single Screw Extruder with Siemens motor and taiwan gearbox	2 set
3	LSPZ-630PE Vacuum Tank A (2m)	1 set
4	LSPZ-630PE Vacuum Tank B (8m)	1 set
5	LSPZ-630PE Vacuum Tank B (6m)	1 set
6	LSPL-630PE Spray Tank	4 sets
7	LSPQ6-630A Six-Caterpillar Haul-Off Unit	1 set
8	LSXX-630PE Swarfless Cutting Unit	1 set
9	LSS30-25B Color Strip Co-extruder	1 set
10	Ø160~Ø630 PE Three-layer Co-extrude Pipe Extrusion Die Body	1 set
10.1	Ø160~Ø630PE Die Core, Die Lips	1 set
10.2	Ø160~Ø630 PE Calibrators	1 set

Technical Features

MAIN		10/22/2021 3:44:07 PM		4030210			
All Overall Yield(kg)		3911.9		All Yield Clear			
Weight/meter PV(kg/m)		83.571		Weight			
Main Yield Clear	Overall Yield (kg)	Feed Rate (g/u)	Screw Speed PV (r/min)	Mass Throughput PV(kg/h)	Weight/meter PV (kg/m)	Weight/meter SV (kg/m)	MAIN AUTO
Aux.1 Yield Clear	3072.4	74.8	184.5	828.2	66.560	67.500	AUX1 AUTO
Aux.2 Yield Clear	420.5	17.1	103.0	105.8	8.506	8.500	AUX2 AUTO
	419.1	17.0	104.0	105.8	8.505	8.500	
Energy		0.240		Kwh/Kg		Extruder	
Press. Limit (mpa)	Torque Limit (%)	Pressure PV (mpa)	Torque PV (%)	Current PV (A)	Speed PV (r/min)	Speed SV (r/min)	Main ON
45.0	98.0	23.4	90.1	328.8	185.0	185.0	Aux1. ON
45.0	98.0	17.7	76.9	44.6	103.0	103.0	Aux2. ON
45.0	98.0	20.4	79.8	46.3	103.9	103.9	Color ON
					6.2	6.2	
Synch. Speed		Windlass OFF		Pedrail down		Puller Reversal	
					Speed PV (m/min)	Speed SV (m/min)	Puller ON
					0.207	0.207	
LIANSU	MAIN2	MAIN TEMP.	DIE TEMP.	AUX1. TEMP.	AUX2. TEMP.	COLOR TEMP.	ALL TEMP.
							ALARM

Production range :Ø160-Ø630mm

Wall thickness: SDR9-SDR26(with wall thickness more than 70mm)

Maximum real output:1030kg/h

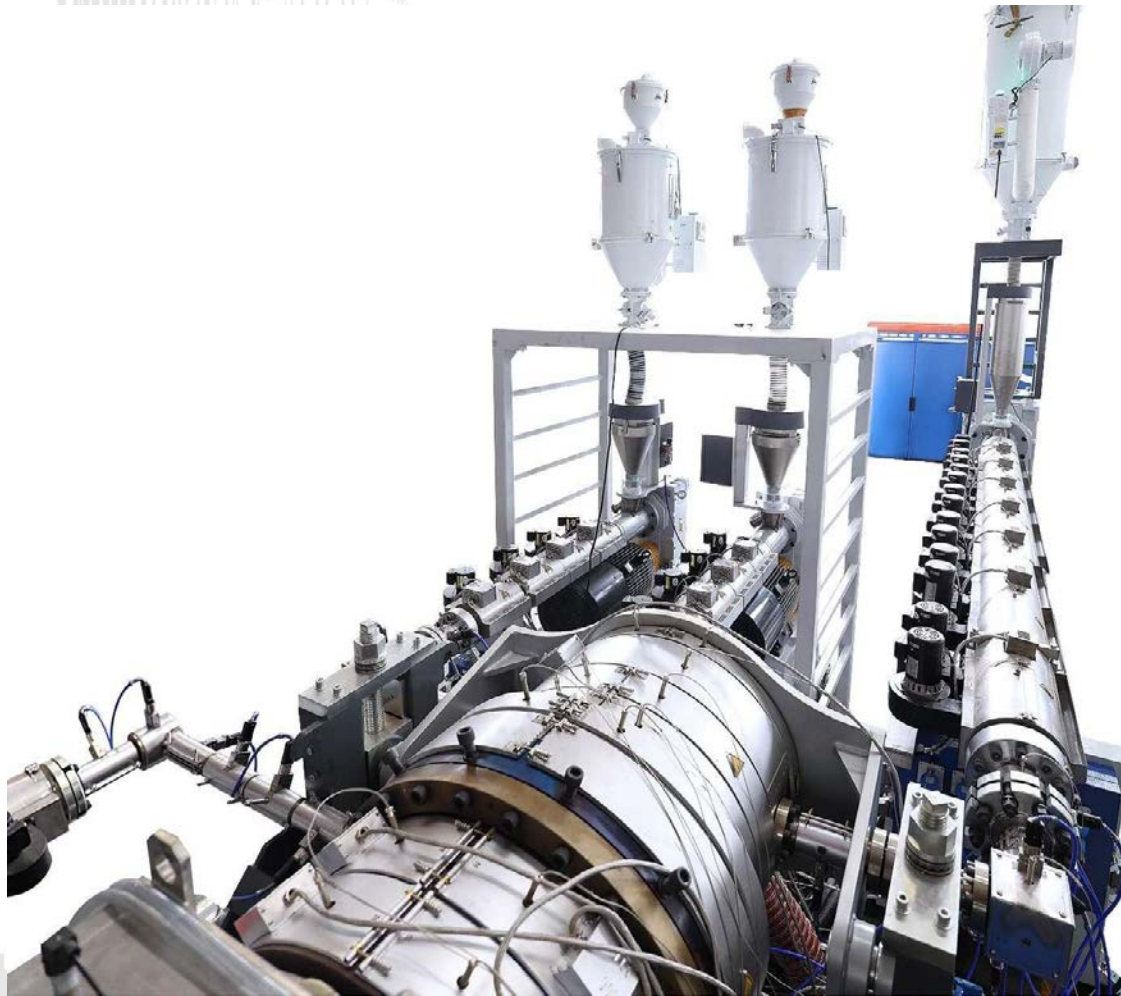
Three-layer thickness ratio A: B: C = 10%: 80%: 10%

Hauling speed: 0.05-1.6m/min

Central height: 1250 mm

Body dimension:
73000 × 3200 × 3300 mm

Extruders



1, Adopted SIEMENS AC motor (high efficiency 1LE0001) with ABB or inovance inverter

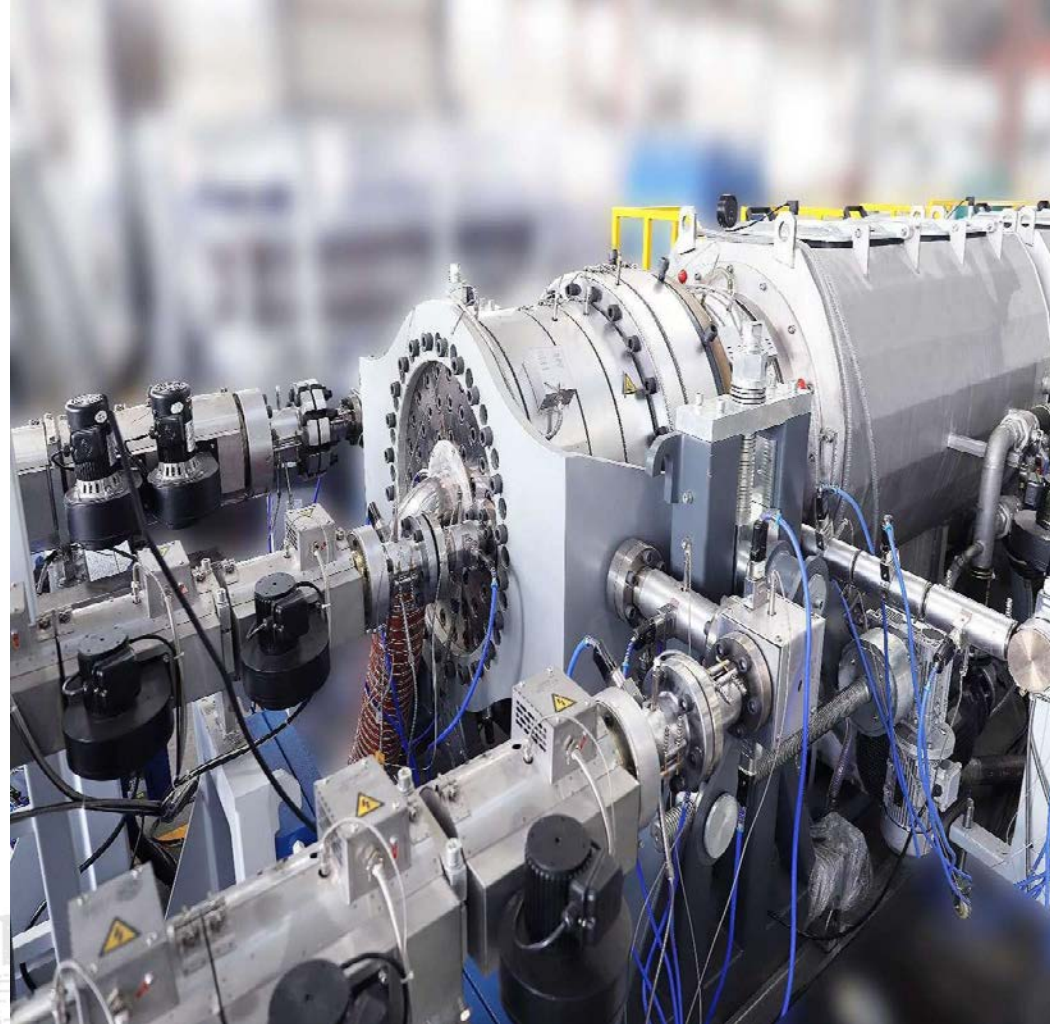
2, Taiwan Sumlung gearbox

3, Equipped with Germany inox gravimetric weighing system for all extruders

4, Main control electric cabinet uses air conditioning cooling

Die head

- 1 The design of die head adopt the structure of spiral flow channel which ensures an even melt temperature, eliminates melting marks, and overcomes the stripe defect from basket structure.
- 2 Die body with exhausting system makes faster cooling of the die head and energy saving up to 25-30%
- 3 Specialized design of die head ensures even thickness for each layer
10% 80% 10%



Vacuum calibration tanks

- 1, Tank material : stainless steel 304
- 2, With circle arc nylon supporter
- 3, With pipe roundness device for vacuum tank
- 4, Vacuum negative pressure closed loop control
Regular vacuum range: $-0.02 \sim -0.07\text{MPa}$. Within this range, the parameters of vacuum degree can be set arbitrarily



Spray tank and hauling unit



Independent servo motor control for each caterpillar with Pre-hauling winding device ,effective hauling length 2000mm



Swarfless Cutting Unit

Blade feed structure :
lead screw

V shape clamping, no
need to change
clamping block when
changing
specification

Maximum wall
thickness 72mm

Without any scraps
or dusts ,smooth
cutting surface



Finished products



Contact

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Thanks fo viewing