



合瑞斯机械  
COMRI SE

# 产品选型手册

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合瑞斯机械  
COMRI SE

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青岛合瑞斯机械有限公司

Qingdao Comrise Machinery Co., Ltd



# 企业简介

山东青岛合瑞斯机械有限公司座落在美丽富饶素有“东方瑞士”之称的海滨城市——青岛，占地面积约1.2万平方米，环境优美，地理位置优越，交通便利。公司成立十多年的时间里，不断加大科技创新力度，内抓管理外拓市场，是一家涉足高分子材料学科，集塑料机械研发，设计制造，生产经营及技术服务为一体的高科技企业。

本公司以高新技术为依托，靠优质的产品、完善的服务创造良好的经济效益和社会效益。

公司研制的高效PE供给水管生产线、PE大口径中空壁缠绕管生产线、PPR冷热供水管生产线、内肋缠绕排污管生产线、双塑复合缠绕管生产线、连续缠绕克拉管生产线、PE大口径中空壁缠绕管生产线及波纹管包覆三层壁设备、PE黑夹克保温管生产线及PE板材片材生产线等二十多种新产品，畅销国内、并远销俄罗斯、东南亚、中东、非洲等许多国家和地区。

“诚信为根、质量为本、研创新品、奉献社会”是我们永恒的信念与追求。我们将以优质的产品、完善的服务不断开创塑料机械领域的新局面，做到公司效益与社会价值的同步增长。

在新的市场领域，我们愿与各相关行业携手共进，共创美好的未来。

Shandong Qingdao Comrise Machinery Co., Ltd. is located in Qingdao, a beautiful and rich coastal city known as "Oriental Switzerland". It covers an area of about 12,000 square meters, with beautiful environment, superior geographical location and convenient transportation. Company has ten years experience in technological innovation, internal management and external market. We are a high-tech enterprise involved in the subject of polymer materials, integrating plastic machinery research and development, design and manufacturing, production management and technical services.

Our company rely on high-tech, high-quality products and perfect services to create good economic and social benefits.

Our company main production line including high-efficiency PE water supply pipe production line, PE large-diameter hollow-wall winding pipe production line, PPR cold and hot water supply pipe production line, the inner-rib winding sewage pipe production line, the double-plastic composite winding pipe production line, the continuous winding carat pipe production line, and the PE large-diameter hollow wall production line, the plastic coated corrugated pipe production line, PE black jacket insulation pipe production line and PE sheet/board production line, . HC has more than 20 kinds new products, which are sold world widely such as Russia, Southeast Asia, Middle East, and Africa.

"Integrity is the root, quality is the foundation, research and innovate products, and contribute to the society" is our eternal belief and pursuit. We will continue to provide high-quality products and perfect services, to achieve the simultaneous growth of company benefits and social value.

In the new market field, we are willing to join hands with all related industries to create a better future.





## PE高效供水管材生产线16-1600mm



合瑞斯公司生产的PE、MPP电力管、PP燃气供水管材生产线，主要用于生产农用给排水、建筑给排水、线缆敷设等方面。该机组由真空定性台、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变频调速装置，真空泵及牵引电机均采用优质产品。牵引机由二爪、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、ABS、PPR、PEX、硅芯管等其他物料管材。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。

Comrise company manufacture new technology high speed PP/ PE gas/water pipe production line, and MPP electric pipe production line, it has reliable performance and high production efficiency. The finished pipes are mainly used in agricultural water supply and drainage, building water supply and drainage, cable laying, etc.

The production line is composed of high efficiency single screw extruder, vacuum sizing water tank, tractor, cutting machine, and pipe bracket.

The high efficiency single-screw extruder and tractor adopt imported frequency conversion speed control device, and the vacuum pump and traction motor are all made of high-quality brands. The traction machine has two claws, three claws, four claws, six claws, eight claws, ten claws, twelve claws according detail pipe diameters. The cutting machine can choose chipless cutting, saw blade cutting or planetary cutting etc. The planetary cutting machine adopts fully automatic computer numerical control, which has the advantages of convenient operation and reliable performance.

We can provide customers valuable technical support to meet different requirements, for example, by replacing some parts to produce inner wall spiral pipes, inner wall hollow pipes and core layer foam pipe, for different material like PP, PE, ABS, PPR, PEX etc.

## HDPE高效管材生产线规格参数

HDPE High efficiency pipe production line parameters:

型号 Model	管径 Pipe Dia	主机型号 Extruder Model	主机功率 Main Motor Power	最大挤出量 Max.output/h
HCPE-63	20-63	HCH60/38	90	450
HCPE-110	20-110	HCH60/38	110	500
HCPE-160	40-160	HCH60/38	110	500
HCPE-250	50-250	HCH75/38	160	680
HCPE-400	160-400	HCH90/38	250	1000
HCPE-630	280-630	HCH90/38	280	1100
HCPE-800	315-800	HCH120/38	315	1300
HCPE-1200	500-1200	HCH120/38	355	1400
HCPE-1600	1000-1600	HCH90/38&HCH90/38	250+250	2000
HCPE-2000	1000-2000	HCH90/38&HCH90/38	280+280	2200

**1、高效挤出机:强制冷却逆向冷却逆向螺旋槽加料段,配以高速低噪音硬齿面减速机,产量高,物料融温低,节能效果好。**  
High-efficiency extruder: forced cooling, reverse cooling, reverse spiral groove feeding section, equipped with high-speed, low-noise, hard-toothed gear box, high output, low material melting temperature, and good energy-saving effect

**2、螺旋分流式复合机头:保证融体压力、流量均匀无波动,制品密实,表面光滑,无流痕。**  
Spiral flow-distributing composite machine head: ensure that the melt pressure and flow are uniform without fluctuation, the product is dense, the surface is smooth, and there is no flow mark

**3、真空定径与冷却系统:采用叠片定径套,冷却速度快,效率高,水槽采用不锈钢。**  
Vacuum sizing and cooling system: Laminated sizing sleeve is adopted, with fast cooling speed and high efficiency, and the water tank is made of stainless steel.

**4、牵引:采用两爪或多爪牵引机,变频调速。**  
Traction: Two-claw or multi-claw tractor, frequency conversion speed regulation.

**5、切割:行星切割,可以切割大口径厚壁管。**  
Cutting: Planetary cutting, which can cut large-diameter & thick-walled pipes

**6、标识线:符合机头,共挤标识线。**  
Marking line: in line with machine head, co-extrusion marking line





## HDPE中空壁缠绕管生产线200-4000mm



HDPE中空壁缠绕管作为排水管代替水泥管和铸铁管获得成功,有着广阔的市场前景。我公司是国内权威生产大口径中空壁缠绕管生产线的厂家,拥有强大的技术优势和丰富的贯彻生产安装经验。设备设计先进,配置高端,运行可靠,使用寿命长,同等型号产量远远高于同行业水平,尤其对超大管径机型有丰富的经验,能满足国内外大型高端客户的需求。生产线的性能指标达到国际领先水平。

HDPE hollow-wall winding pipes have been successfully used as drainage pipes instead of cement pipes and cast iron pipes, and have broad market prospects. Our company is the authoritative manufacturer of large diameter hollow wall winding pipe production line in China. It has strong technical advantages and rich experience in production and installation. The equipment is advanced in design, high-end configuration, reliable operation, long service life, the output of the same model is far higher than the level of the same industry, especially has rich experience in super large diameter models, and can meet the needs of large scale high-end customers at home and abroad. The performance index of the production line has reached the international advanced level.



## 主要技术参数

### Main Technical Parameter

型号 Model	管径范围 /mm Pipe range	挤出机 Extruder			生产线总装机容量 (KW) 负荷率50% Installed power (kw) Loading factor 50%	最大产量 kg/h Max.Capacity	机组外形尺寸 长*宽*高 Overall dimension (L*W*H)
		型号 Model	长径比 L/D	主电机功率 Motor power			
HC-800	200-800	SJ75\33	33:1	55	145	290	23*10*3.2
		SJ65\33		30			
HC-1200	300-1200	SJ90\33	33:1	75	175	380	24*10*3.5
		SJ65\33		37			
HC-1600	800-1600	SJ100\33	33:1	110	250	540	26*11*5
		SJ75\30		45			
HC-2200	1200-2200	SJ100\33	33:1	132	280	740	32*16*6
		SJ75\30		55			
HC-2600	1400-2600	SJ120\33	33:1	132	260	500	39*17*6.5
		SJ75\33		75			
HC-3000	1800-3000	SJ120\33	33:1	160	330	820	42*17*7
		SJ75\33		75			
HC-4000	2000-4000	SJ150\33	33:1	250	440	1200	48*20*7.5
		SJ90\33		90			

#### 1、主机采用哦高效单螺杆挤出机,确保高效、高质量挤出。

The main extruder adopts high-efficiency single-screw extruder to ensure high-efficiency and high-quality extrusion.

#### 2、采用复合式机头,螺旋转动成型,结构精巧,设计独特,保证产品高品质。

Adopt composite head, spiral rotation forming, exquisite structure, unique design, to ensure high-quality products.

#### 3、操作方便,稳定可靠。

Easy to operate, stable and reliable.

#### 4、管材可用于塑料检查井,化粪池,施工方便安全。

The pipe can be used in plastic inspection wells, septic tanks, and the construction is convenient and safe.

#### 5、可生产矿用防静电瓦斯抽排气管材。

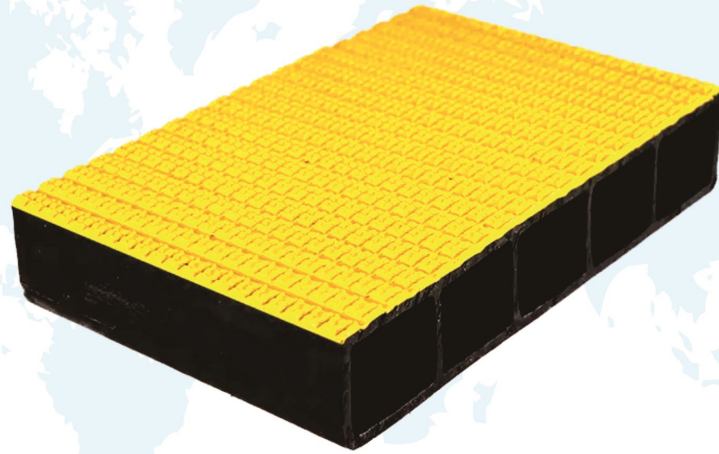
It can produce anti-static gas exhaust pipes for mining.

#### 6、特种管件连接,连接方便,施工经济。

Special pipe fitting connection, convenient connection and economical.



## 海洋踏板生产线



我公司生产的海洋踏板生产线,通过挤出工艺加工而成;可根据实际需求或工艺设计,在其他金属或塑料配件的辅助下进行连接、固定、组合、安装成各式形式。用于码头、浮桥、平台等场所进行水陆连接的漂浮于水面上的产品。

The marine pedal production line produced by our company is processed by extrusion process; it can be connected, fixed, combined and installed into various forms with the assistance of other metal or plastic accessories according to actual needs or process craft design. It is a product floating on the water for water and land connection in docks, pontoon bridges, platforms and other places.

### 设备组成

#### Production line composition

- 1、单螺杆挤出机-挤出主型材  
Single-screw extruder-extrude the main profile
- 2、单螺杆挤出机-用于方管护栏共挤  
Single screw extruder - used for co-extrusion of square tube guardrail
- 3、机头模具  
Die head and mold
- 4、真空定型平台  
Vacuum setting platform
- 5、单螺杆挤出机-挤出表面防滑层  
Single-screw extruder - extrude anti-skid layer on the surface
- 6、防滑层片材挤出模具  
Anti-skid layer sheet extrusion die

- 7、压光机  
Calender
- 8、喷淋水箱  
Spray water tank
- 9、牵引机  
Tractor
- 10、自动切割机  
Automatic cutting machine
- 11、翻料架  
Auto Turning bracket



## 波纹管包覆三平壁设备



塑料包覆挤出机主要对外层包覆PVC、PE、ABS、PA等不同塑料。生产的产品适用于户外和室内等不同场合,在装饰、保温、防腐等领域得到广泛应用。

The plastic coating extruder mainly coats different plastics such as PVC, PE, ABS, PA, etc. on the outer layer. The products produced are suitable for different occasions such as outdoors and indoors, and are widely used in decoration, heat preservation, anti-corrosion and other fields.

### 三层壁设备设备组成

**Plastic coating extrusion machine**  
(Outer layer Plastic coating inner double wall corrugated pipe machine)

- 1、输送托架  
conveyor bracket
- 2、四爪牵引机(输送机)  
four-claw tractor(with conveyor)
- 3、SJ-90/33单螺杆挤出机  
SJ-90/33 single screw extruder



### 塑料包覆挤出生产线组成

**Plastic coating extrusion production line composition**

- 1、放卷(送料)装置:根据被包覆内芯不同,设计对对应的配套装置  
Unwinding (feeding) device: according to the difference of the inner core to be coated, design and match the corresponding supporting device
- 2、单螺杆挤出主机:根据包覆大小和外层材质,可选用不同大小的单螺杆主机或双螺杆主机  
Single-screw extruder: According to the size of the coating and the material of the outer layer, different model of single-screw or twin-screw extruder can be selected.
- 3、包覆机头模具  
Coating die head mold
- 4、冷却水箱  
Cooling water tank
- 5、输送托架  
Conveyor bracket  
规格:200-300-400-500-600-800mm  
Specifications: 200-300-400-500-600-800mm





## HDPE实壁缠绕管设备



合瑞斯机械有限公司生产的实壁缠绕管设备主要用于生产地下顶管,中空壁缠绕管、内勒管、仿克拉管、双塑复合管接头,保温管;前两种应用主要采用厚壁管,后一种应用采用薄壁管,管子厚度可通过调节片材厚度和距离来调节,操作灵活简单,可任意生产不同厚度和管径的管子。

用于管件接头的管子主要是厚壁管,生产完成厚壁管后,需要经过机床铣头,焊接电熔网或电熔丝等,确保成品插头直接焊接到管子上正常使用。

The solid wall winding pipe machine produced by HC Greesense Plastic Machinery Co., Ltd. is mainly used for the production of underground pipe jacking, hollow wall winding pipe joint, inner tube joint, continuous carat pipe joint, double plastic composite pipe joint, insulation pipe; if for jacking or joint usage the pipe is thick wall, if for insulation the pipe is thin wall. The thickness of the tube can be adjusted by adjusting the thickness of the sheet and distance. The operation is flexible and simple, and tubes of different thicknesses and diameters can be produced arbitrarily. The pipes used for pipe fittings are mainly thick wall pipes. After the thick wall pipes are produced, they need to be milled by machine tools, welded with electric fuses or electric fuses, etc., to ensure that the finished plugs are directly welded to the pipes for normal use.

### 设备简介

设备主要包括:成型机,切割机,片材机头,管材托架。

The production line mainly including: forming machine, cutting machine, sheet die head, pipe bracket.

#### 一、HDPE实壁缠绕管生产线简介:

Brief introduction of HDPE solid wall winding pipe production line:

该设备用于生产PE缠绕保温管夹克管,内层为钢管,中间层为聚氨酯保温层;生产出的管材利用穿管机和发泡平台可在钢管与PE缠绕管之间进行发泡,发泡机为高压发泡机。

The line is used to produce PE winding insulation jacket pipe, the inner layer is steel pipe, and the middle layer is polyurethane insulation layer; the produced pipe can be foamed between the steel pipe and PE winding pipe by using the pipe threading machine and foaming platform. The foam machine is a high pressure foam machine.

二、设备包含:成型机,单螺杆挤出机,片材机头,切割机,卸料托架;管径范围可生产:200-3000mm;根据客户需求定制。

The production line including: winding forming machine, single screw extruder, sheet die head, cutting machine, unloading bracket; pipe diameter range can be produced: 200-3000mm; customized according to customer needs.

三、应用:可生产排污管接头;可生产保温夹克管子。

Application: It can produce sewage pipe joints; it can produce insulation jacket pipes.

## 双塑复合缠绕管生产线



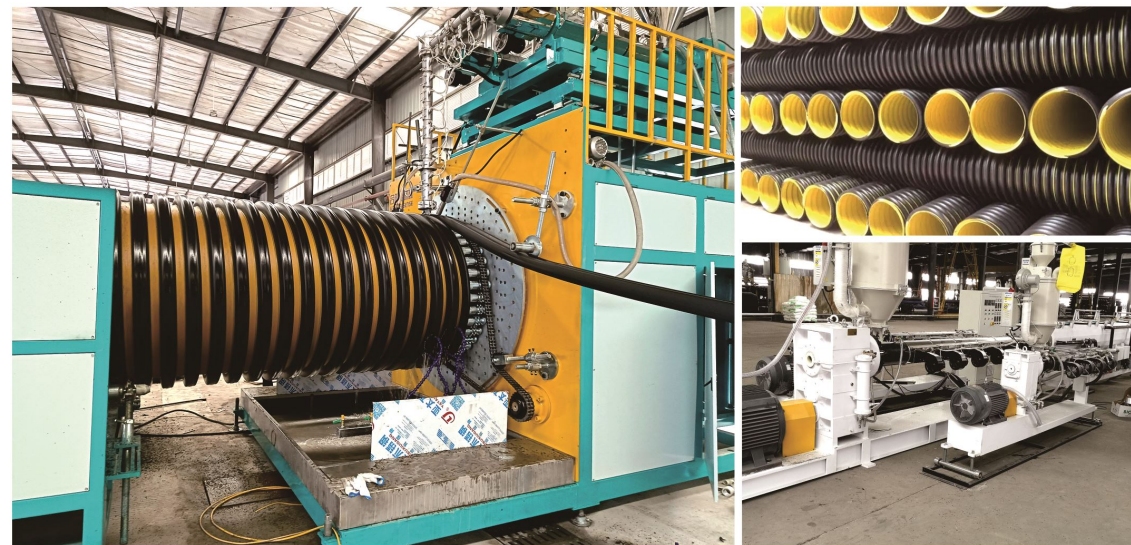
### 性能及特点

FRPE双塑复合结构壁管是采用高分子聚乙烯及复合玻纤聚丙烯,在热熔状态下整体支撑的管道,其整体性能好,化学性质稳定,强度高,使用寿命长,可长达50年以上。

Double plastic composite winding pipe production line

Performance and features:

FRPE double-plastic composite structure wall pipe is supported by high molecular polyethylene and composite glass fiber polypropylene in a hot-melt state. It has good overall performance, stable chemical properties, high strength, and long service life for 50 more years.





## HDPE内肋缠绕管生产线

内肋管缠绕排污管设备可同时生产中空壁缠绕管,内肋管,克拉管;  
 制品环刚度为4/6/8/12.5/16  
 制品管径范围:300-1200,800-2200,1000-3000mm;根据客户定制;



PE inner rib pipe winding sewage pipe machine can produce hollow wall winding pipe, inner rib pipe and carat pipe at the same time;  
 The product ring stiffness is 4/6/8/12.5/16  
 Product diameter range: 300-1200, 800-2200, 1000-3000mm; according to customer requirements;

### 产品介绍

内肋增强波纹管设备主要是以内肋结构为主要设计的一种管材生产设备,而且其是经过研发而成的性能优越的波纹管生产设备。当然在生产中这种波纹管才主要是以聚乙烯为原材料制成的,拥有较高的密度,并且经过技术的改进,使其在处理后的管材不仅外形美观,而且拥有较大的面积,所以流通性较好,同时还具有较强的抗压能力。另外,这种波纹管才在生产中还具有较好的熔接处理,能够在一定程度上提高其增强缝的效果,而且使用时间较长;

Product introduction: The inner rib reinforced corrugated pipe machine is mainly designed with the inner rib structure, the production line is getting superior performance by researching and development. The material for this pipe mainly is PE (polyethylene), which has a high density, and after technical improvement, the processed pipe not only has a beautiful appearance, but also has a larger area. Therefore, the circulation is better, also has a strong ability to resist pressure. In addition, this kind of corrugated pipe also has better welding treatment in production, which can improve the effect of its reinforced seam to a certain extent, and has a longer service life;

### 产品特点

内肋增强螺旋波纹管设备的结构设计较为合理,所以在使用中不易出现松动的现象,而且还能够一定程度上提高波纹管的使用时间。而且其还拥有内肋的结构设计,使其在使用中具有较高的稳定的性能,所以具有较优良的抗冲击、抗压的性能。

Product features: The inner rib reinforced spiral corrugated pipe machine is with relatively reasonable structural design, so it is not easy to loosen during use, and it can also increase the service time. Moreover, it also has a structural design of inner ribs, which makes it have high stability in use, so it has excellent impact resistance and compression resistance.

### 设备组成

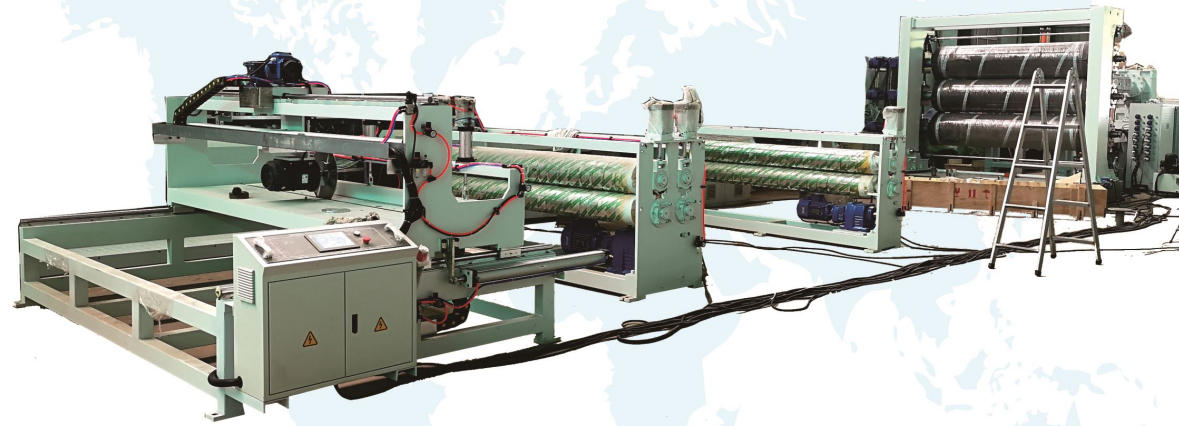
#### Machine line composition

- 1.单螺杆挤出机 Single screw extruder
- 2.机头模具 Die head&molds
- 3.真空定型平台/真空定型箱 Vacuum sizing water tank
- 4.牵引机 Tractor

- 5.成型机 Winding forming machine
- 6.切割机 Cutting machine
- 7.成品管托架 Finished pipe bracket

以上设备可以通过更换模具生产中空壁缠绕管;  
 The above production line can produce HDPE hollow wall winding pipe by replacing the molds.

## PE板材片材生产线



本机组是我公司吸收国外技术自主开发研制的用于生产片、板材的物以稀为贵;PET片材具有优良的加工性、透明性、阻隔性以及以无毒无味无环境污染、易回收等特点。特别是在仪器包装方面,是取代PVC最理想的材料。制品有效宽度最大2200mm。

本生产线也可PS、PP、PE等片、板材制品。机组设计性能优越,自动化程度高,塑化均匀、挤出量稳定、产量高、精密压光辊具有精确的调节装置,确保片、板材定型准确;切割采用对边、定尺切割装置;可选用进口变频调速器,PLC触摸屏控制。



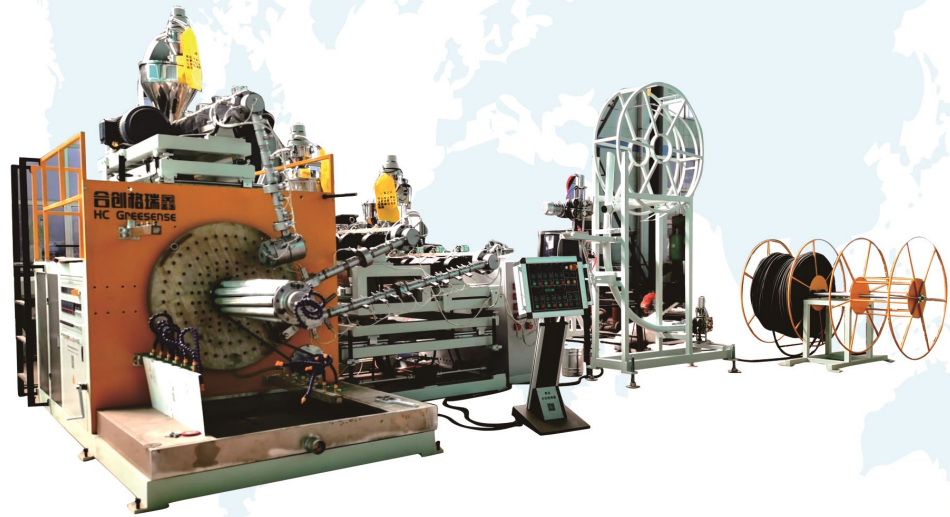
### 主要技术参数

#### Main Technical Parameter

型号	HCBY-1200	HCBY-1600	HCBY-2200
挤出机型号	SJ-80*33	SJ-100*33	SJ-120*33
产量 (kg/h)	160-400	200-600	400-1000
生产速度 (m/min)	0.5-10	0.5-5	0.2-3
装机容量 (kw)	200	260	400



## 连续缠绕克拉管生产线



合瑞斯 机械克拉管生产范围200-3000mm.该生产线可由中空壁缠绕管设备或内肋管设备上改造。

The continuous carat pipe production line manufactured by HC Greesense can produce diameter range from 200mm to 3000mm. This production line can be modified by hollow wall winding tube machine or inner rib tube machine.

### 设备组成

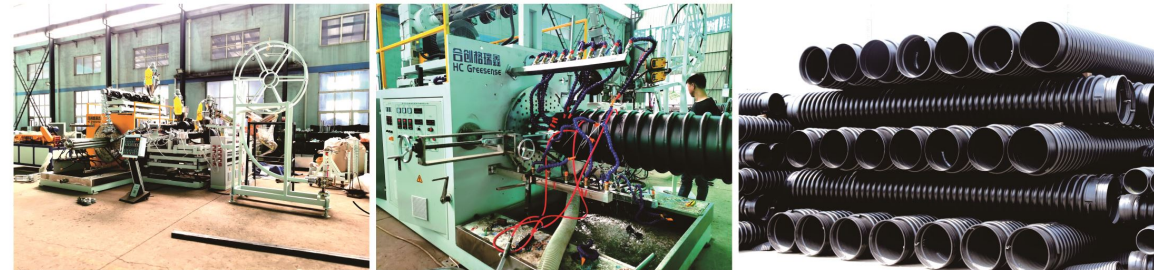
本设备必须配单壁波纹管生产线一套,或者客户自备单壁波纹管。

Production line composition: This production line must be equipped with one set single wall corrugated pipe production line, or the customer prepare the single wall corrugated pipe by himself.

### 设备组成

- 1、成型机1台forming machine --1set
- 2、挤出机两台extruders-- 2sets
- 3、包覆机头1台coating head--1set
- 4、片材机头一台sheet die head--1set

- 5、单壁波纹管牵引机  
Single wall corrugated pipe traction machine-- 1set
- 6、单壁波纹管卷取机  
Single wall corrugated pipe coiling machine--1set



## 造粒回收设备



### 性能及特点

水冷拉条造粒生产线采用挤出拉条造粒,由平行双螺杆挤出机或单螺杆挤出机与相应造粒辅机组成的成套造粒设备。

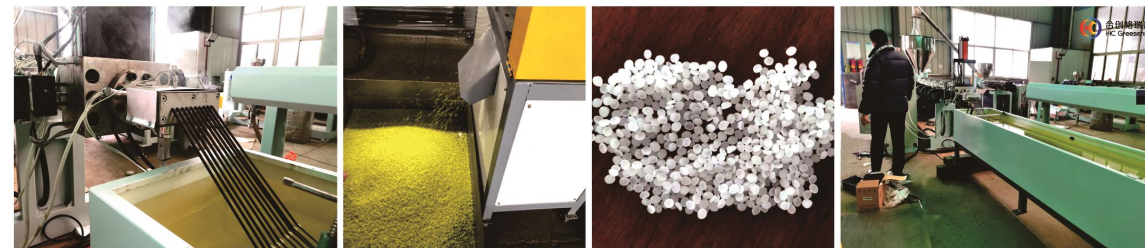
采用特殊的螺杆设计及不同配置,适用于生产PP、PE、PET、PS、ABS、PA、PVC、PC、POM、EVA、PMMA等多种塑料的再生及混色造粒。减速机采用高扭矩的设计,实现了低噪音及运转平稳等性能。螺杆、机筒经过特殊的表面处理,具有耐磨,混炼效果好,产量高的特性。真空排气或自然排气口的设计,能在生产过程中将水分、废弃排除,使出料更稳定,胶粒更密实,保证了产品的优良品质。

The water-cooled strand granulation production line adopts extrusion strand granulation, which is a complete set of granulation equipment composed of parallel twin-screw extruders or single-screw extruders and corresponding granulation auxiliary machines. With special screw design and different configurations, it is suitable for the recycling and color mixing granulation of various plastics such as PP, PE, PET, PS, ABS, PA, PVC, PC, POM, EVA, PMMA, etc. The reduction box is designed with high torque to achieve low noise and smooth operation. The screw and barrel have been specially treated on the surface, which has the characteristics of wear resistance, good mixing effect and high output. The design of vacuum exhaust or natural exhaust can remove moisture and waste during the production process, making the output more stable and the particles denser, ensuring the excellent quality of the product.

### 设备组成

- 1、单螺杆挤出机 Single screw extruder
- 2、机头模具 die head mold
- 3、自动换网装置 automatic net changer

- 4、冷却水槽 cooling water tank
- 5、打水机 water removal device
- 6、切粒机 Particle cutting machine





## PPR,PERT管材生产线

PP-R冷热水管生产线主要用于生产住宅供水系统、工业用水输送、压缩空气运输等方面广泛应用的各种管径、壁厚的管材。在国际管材发展史上,PP-R具有价廉、无毒、无锈蚀、耐高温、安装方便等特点。该生产线也可用于生产PERT地暖管。

该生产线是我公司引进吸收国外先进技术自行研制成功的新产品,其螺杆和机头等关键部件均是按PP-R的特性专门设计的。控制电器采用变频调速,主要电器部件采用进口名牌产品;整条生产线具有产量高、质量稳定、制品误差小等特点,是当今塑机行业中的一流设备。同时,该生产线可适用PP-C、PE-X交联管及聚烯烃等制品生产。本公司均可提供工艺配方及交钥匙工程。

The PP-R hot and cold water pipe production line is mainly used to produce pipes of various diameters and wall thicknesses that are widely used in residential water supply systems, industrial water transportation, compressed air transportation, etc. In the history of international pipe development, PP-R has the characteristics of low price, non-toxic, no rust, high temperature resistance, and convenient installation. This production line can also be used to produce PERT floor heating pipes. This production line is a new product successfully developed by our company by absorbing world advanced technology. Its key components such as screw and head are specially designed according to the characteristics of PP-R. The control appliances adopt frequency conversion and speed regulation, and the main electrical components are imported famous brands; the whole production line has the characteristics of high output, stable quality, and small product error, which is the first-class quality in the plastic machine industry currently. At the same time, the production line is suitable for the production of PP-C, PE-X cross-linked pipes and polyolefin products. The company can provide process formula and turnkey project.



### 规格参数

#### Specifications & Parameters

型号 [Model]	HCPR-20-63	HCPR-75-110
管径 [Pipe specification (mm)]	20-63	75-110
挤出机 [Main Extruder Type]	SJ-65*30	SJ-90*30
打线机 [Assistant Extruder Type]	SJ-30*25	SJ-30*25
产量 [Output (kg/h)]	120	250
线速度 [Line Speed (m/min)]	1-12	0.5-6
装机功率 [Installed Power (kw)]	80	160
总尺寸 [Overall dim (m)]	28*2.5*2.8	32*3*3.2

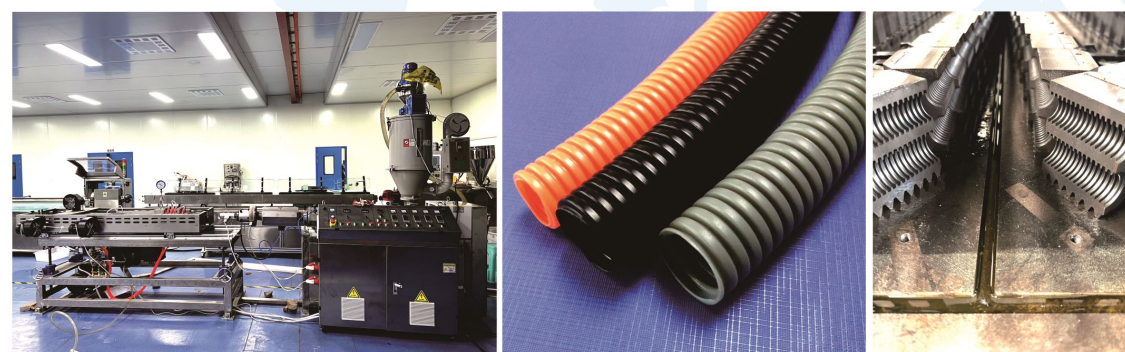
## PE,PA,PP,PVC单壁波纹管生产线

合瑞斯机械有限公司生产的单壁波纹管设备应用:该设备生产出的管材,耐高温,耐腐蚀,耐磨损,强度高。用于电气穿线管、汽车穿线管、保护管、机床产品、包装食品机械、电力机车、工程安装、灯具、自动化仪器仪表等领域,市场需求大。

性能和优点:特殊螺杆、模具的结构设计合理,更换模具方便可靠,解决了螺杆机筒易磨损及物料成型难的问题,生产速度快,运行稳定,控制简捷易操作。

材料:聚乙烯,聚丙烯,尼龙。

The single wall corrugated pipe machine manufactured by HC Greense has advantages of high temperature resistant, corrosion resistant, wear resistant and high in strength. It is widely used in the fields of electrical threading pipes, automobile threading pipes, protective pipes, machine tool products, packaging food machinery, electric locomotives, engineering installations, lamps, automation instruments and meters, etc., and has a large market demand. The production line has special screw and mold design, replacement of the mold is convenient and reliable, which solves the problems of easy wear of the screw barrel and difficult forming of materials. The production line speed is fast, the operation is easy and stable. Material: PE(Polyethylene), PP(Polypropylene), PA(Nylon)



### PE/PA/PP/PVC单壁波纹管规格参数

#### PE/PA/PP/PVC Single wall corrugated pipe specifications

型号 [Model]	HCDB-90	HCDB-65	HCDB-45	HCDB-30
螺杆直径 [Screw diameter (mm)]	Φ90	Φ65	Φ45	Φ30
长径比 [L/D]	30:1	30:1	30:1	30:1
产量 [Output (kg/h)]	200	100	40	20
总功率 [Total power (kw)]	120	80	50	20
管径范围 [Pipe range (mm)]	Φ110-Φ200	Φ16-Φ75	Φ8-Φ50	Φ2-Φ15
牵引速度 [Haul-off speed (m/min)]	10	10	15	15
年产量 [Capacity annual (10km)]	150	150	150	150



OD mm	PE63(HDS 5 MPa)(discontinued)		PN2.5		PN3.2		PN4		PN5		PN6.3		PN8		PN10		PN12.5		PN16	
	PE100(HDS 6.3MPa)(discontinued)		PN3.2		PN4		PN5		PN6.3		PN8		PN10		PN12.5		PN16		PN20	
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
16	16,30	1,20																		
20	20,30	1,20																		
25	25,30	1,20																		
32	32,30	1,30																		
40	40	1,40																		
50	50	1,40																		
63	63,40	1,50																		
75	75,50	1,60																		
90	90,60	1,80																		
110	110,70	2,20																		
125	125,80	2,50																		
140	140,90	2,80																		
160	161,00	3,20																		
180	181,10	3,60																		
200	201,20	4,00																		
225	226,40	4,50																		
250	251,50	5,00																		
280	281,70	9,80																		
315	316,90	11,10																		
355	357,20	12,50																		
400	402,40	14,00																		
450	452,70	15,60																		
500	503,00	17,50																		
560	563,40	19,60																		
630	633,80	22,10																		
710	716,40	SeeNote																		
800	807,20	SeeNote																		
900	908,10	SeeNote																		
1000	1009,00	SeeNote																		

Note: For coiled pipe and for straight lengths with diameters > 710, the maximum out-of-roundness shall be agreed between manufacturer and purchaser.

Non-SANS specification SANS specification

Standard Diameter Ratio	PN6			PN10		
	SDR17.6			SDR33		
	OD mm	Wall Thick-ness	Pipe ID&Mass	Wall Thick-ness	Pipe ID&Mass	
	Min	ID	kg/m	Min	ID	kg/m
16	2,30	27,17	0,21	2,30	11,17	0,10
20	2,30	35,17	0,27	2,30	15,17	0,13
25	2,90	43,91	0,43	2,30	20,17	0,16
32	3,60	55,44	0,67	3,00	25,70	0,27
40	4,30	65,97	0,95	3,70	32,23	0,42
50	5,20	79,08	1,38	4,60	40,34	0,65
63	6,30	96,77	2,04	5,80	50,82	1,03
75	7,10	110,09	2,62	6,80	60,72	1,45
90	8,00	123,20	3,30	8,20	72,82	2,09
110	9,10	140,89	4,29	10,00	89,00	3,12
125	10,30	158,37	5,46	11,40	101,06	4,04
140	11,40	176,06	6,72	12,70	113,33	5,04
160	12,80	198,12	8,49	14,60	129,34	6,62
180	14,20	220,18	10,46	16,40	145,56	8,37
200	15,90	246,61	13,12	18,20	161,78	10,32
225	17,90	277,41	16,62	20,50	181,95	13,07
250	20,20	312,58	21,13	22,70	202,33	16,09
280	22,80	352,12	26,87	25,40	226,66	20,16
315	25,60	396,24	33,94	28,60	254,94	25,54
355	28,40	440,36	41,85	32,20	287,38	32,41
400	31,90	493,01	52,63	36,40	323,56	41,27
450	35,80	554,82	66,46	40,90	364,11	52,17
500				45,40	404,66	64,35
560				50,90	453,11	80,80
630				57,30	509,67	102,32

Ovality and internal Coli Diameter is based on SANA 4427

Note: Kg/m or mass is nominal