



# 管材挤出生产线

## PIPE EXTRUSION LINES

[www.bestextrusion.com](http://www.bestextrusion.com)



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## COMPANY PROFILE 公司简介



佛山巴斯特科技股份有限公司，成立于2008年，是一家集研发、生产、销售塑料挤出生产线的企业，主要员工均从事行业工作多年，并曾经服务于行业内国际知名企业。公司产品定位高端，致力制造最符合中国市场需求的塑料设备；严谨的设计、严格的标准化生产制造过程、及时的配件保障、以客为尊的售后服务理念，造就性能卓越的机械设备和优质贴心的服务产品；

FOSHAN BEST EXTRUSION TECH. CO., LTD was established in 2008. It is a comprehensive enterprise specialized in research, production and selling all kinds of plastic extrusion machinery. Our senior employees have been engaged in this field as outstanding personnel for many years and served for the famous international extrusion machinery enterprise more than a decade. We keep the rigorous design and standardization manufacturing process. Our equipments are positioned in high-end standard. Our goal is to provide high quality equipments and good after-sales service for our customers.

2017年底，公司完成三件大事：

- 股改成为股份有限公司
- 荣评国家级高新技术企业
- 成功在广东省金融市场挂牌，企业代码230198。

By the end of 2017, our company has completed three major events.

- Completed the share reform to become an incorporated company.
- Our company was awarded Nation High-tech Enterprise.
- Successfully listed on the financial market in Guangdong Province (Enterprise code : 230198).

### 我公司现提供以下产品及服务：

1. HDPE管材生产线，管线规格16-1600mm;
2. PPR/PERT/PB高速管材挤出生产线，最高速度40米/分钟;
3. 多层复合实壁管挤出生产线;
4. PVC型材及管材挤出生产线;
5. 其他进口品牌挤出生产线售后服务、零配件及技术改造升级；

### Products and Service Scope Including:

- 1.HDPE pipe extrusion line, pipe size 16-1600mm;
- 2.PPR/PERT/PB pipe high-speed extrusion line with speed up to 40m/min;
- 3.Multilayer pipe extrusion line;
- 4.PVC profile and pipe extrusion line;
- 5.Providing spare parts, after-sales service, technical support & upgrade for imported brand extrusion machinery.



## 单螺杆挤出机 SINGLE-SCREW EXTRUDER

### 特点/Features:

- ◆ 对于聚烯烃管材挤出机，巴斯特单螺杆挤出机采用螺旋喂料机筒与分离型螺杆设计相结合，获得高塑化率和良好的熔体均匀度。
- ◆ 全系列挤出机配备电柜水冷空调，在恒温恒湿的环境中保证电子元件的稳定性及获得更长的使用寿命。
- ◆ 根据客户需求，操作系统可以选择配有触摸屏、数据存储等高级功能的奥地利B&R公司或德国西门子PCC操作系统，以及直观、便于操作和维护保养的分立原件控制系统。
- ◆ 配备优质轴承的齿轮箱，在长期高挤出量运行状态下，其稳定性、噪音及温升完全达到进口齿轮箱水平。
- ◆ 控制系统与主机变频控制器、与牵引及变频控制器之间的通讯信号均为数字信号，抗干扰能力强，保证控制及反馈的精确。
- ◆ 温度控制范围在±1度。
- ◆ Combination of spiral feeding barrel and separate screw design, it guarantees a high plasticizing rate and excellent melt uniformity.
- ◆ Using water-cooled air conditioner, it ensures electric components work in a constant temperature and humidity, which makes them more stable and get longer lifetime.
- ◆ Austria B&R or Germany SIEMENS PCC operating system with touch-screen, data storage and other advanced function features.
- ◆ Equipped with high quality bearings, its stability, noise and temperature levels fully meet the imported gearbox performance even at high throughput rates.
- ◆ The communication signal between control system and extruder frequency controller, and haul off is digital signal, which have strong anti-interference ability and ensure accurate control and feedback.
- ◆ The temperature control range is ±1 degree.



◆ 单螺杆挤出机: CE90-36

### 技术参数/Technical Data

型号/Type	CE45-36	CE60-36	CE75-36	CE90-30	CE90-36	CE120-30	CE120-36
螺杆直径 Screw diameter(mm)	45,L/D=36	60,L/D=36	75,L/D=36	90,L/D=30	90,L/D=36	120,L/D=30	120,L/D=36
电机功率 Motor power (kw)	AC,45	AC,90	AC,185	DC,200	DC,220	DC,315	DC,355
最高产量 Max.output (kg/h)	130	340	640	780	900	1100	1200

备注：以上产量基于HDPE管材专用料原料。The outputs are based on HDPE materials.

## 管材挤出模头

### DIES FOR PIPE EXTRUSION

#### 特点/Features:

- ◆ 模块化的螺旋模具设计，提供了丰富的选装件（例如：色条、防划伤保护层等功能）
- ◆ 双倍螺旋设计，模头压力低
- ◆ 物料分布均匀，分散性好
- ◆ 流道短，无死角，换色快
- ◆ 配备内冷装置，缩短冷却长度30%、抑制熔垂，高效节能而且降低设备采购成本



#### 技术参数/Technical Data

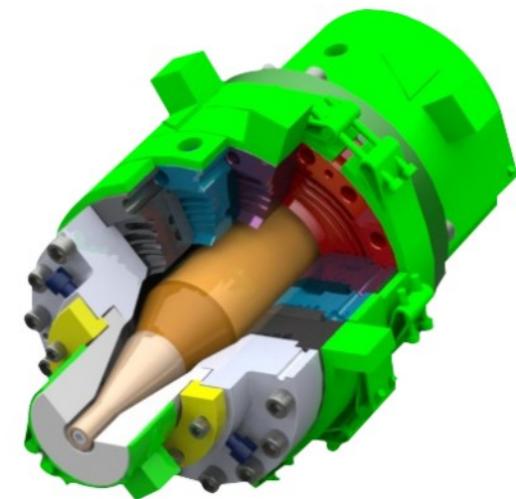
型号/Type	M32S	M125S	M160S	M250S	M315S	M450S	M630S	M800S	M1200S
管材直径 Pipe diameter(mm)	12-32	16-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200
最高产量 Max.output(kg/h)	350	350	350	600	600	800	800	1000	1200

## 多层模头

### MULTI-LAYER DIES

#### 特点/Features:

- ◆ 针对具体的要求，巴斯特提供适用于广泛共挤加工的挤出模头
- ◆ According to the specific demand, we can offer wide range co-extrusion multilayer die heads.

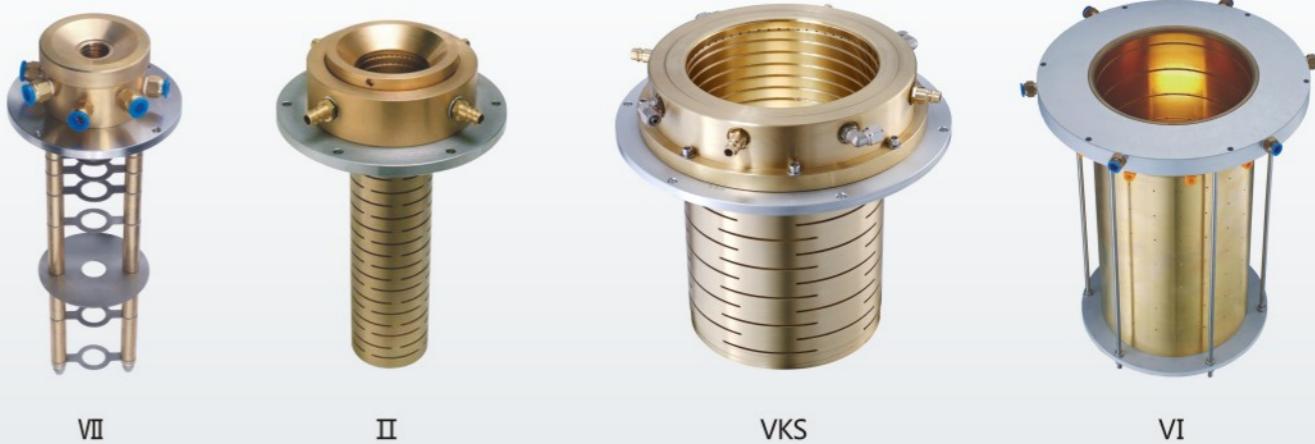


## 定径套

### CALIBRATING SLEEVES

#### 特点/Features:

- ◆ 巴斯特提供适用于各种聚烯烃管材的高速定径套
- ◆ We can offer high-speed calibrating sleeves for all kinds of plastic pipe.



#### 技术参数/Technical Data

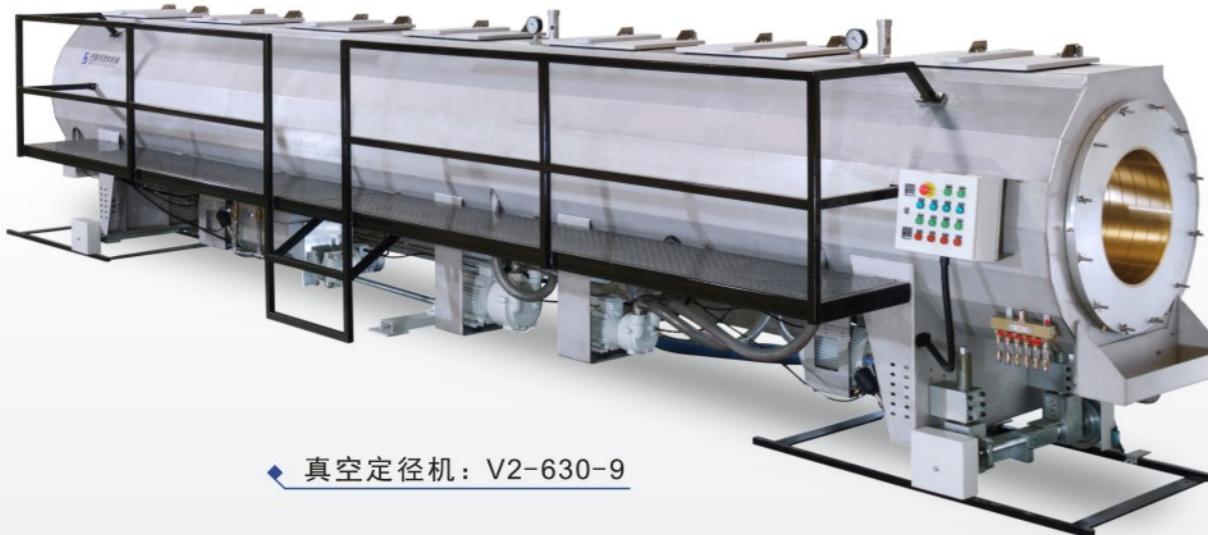
型号/Type	VII	II	VKS	VI
材料 Material	PO.PB	HDPE	PO	HDPE
管材直径 Pipe diameter(mm)	16-32	32-110	160-630	110-1600
冷却原理 Cooling principle	涡流式定径套 Vortex calibrating sleeve	强冷却，带可调节水环 Intensive cooling, adjustable water ring	与真空箱强冷环配合使用 Be used in cooperation with forced cooling ring of vacuum calibrator	干式导入和喷淋冷却 Dry inlet and spray cooling

## 真空定径机

### VACUUM CALIBRATING UNITS

#### 特点/Features:

- 最新的喷头布局，保证高产量下管材的椭圆度
- 不锈钢304箱体，使用寿命长
- 专利水位控制装置
- 根据需求可选择单室或双室设计
- 集中给排水设计
- 全系列采用真空变频技术



◆ 真空定径机：V2-630-9

#### 技术参数/Technical Data

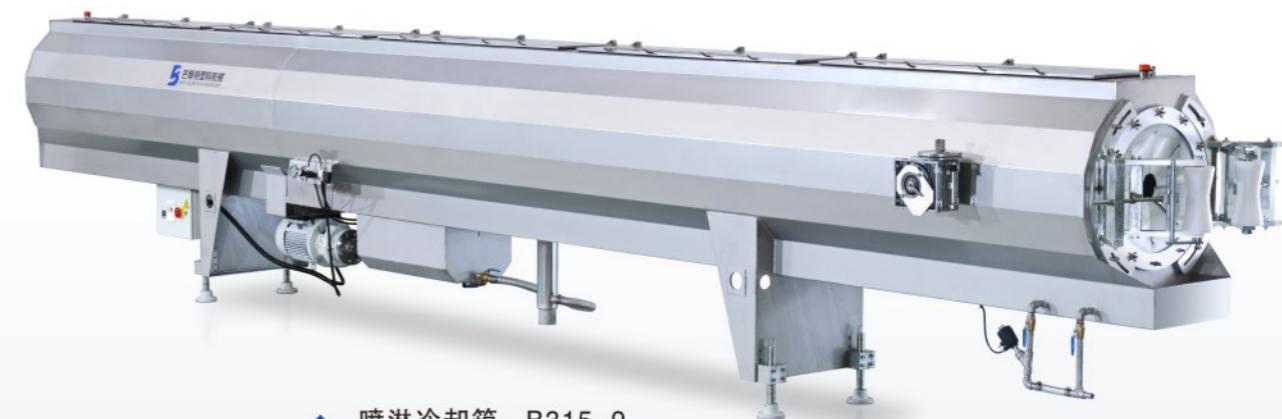
型号/Type	V32-9	V63-9	V2-160-9	V2-250-9	V2-315-9	V2-450-9	V2-630-9	V2-800-9	V2-1200-6
管材直径 Pipe diameter (mm)	12-32	12-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200
长度 Length (mm)	9000	9000	9000	9000	9000	9000	9000	9000	12000

## 喷淋冷却箱

### SPRAY COOLING BATHS

#### 特点/Features:

- 不锈钢304箱体，使用寿命长
- 优化设计的雾化喷头，保证冷却效果
- 管材支撑可调节适用不同管径，且带自锁功能
- Tank made from stainless steel 304 with long service life.
- Optimized design for the atomizing nozzle, it can guarantee the cooling effect.
- Pipe support can be adjusted for different pipe diameters with self-locking function



◆ 喷淋冷却箱：B315-9

#### 技术参数/Technical Data

型号/Type	B63-18A	B160-9B	B250-9B	B315-9B	B450-9B	B630-9C	B800-9C	B1200-6C
管材直径 Pipe diameter(mm)	10-63	20-160	50-250	75-315	90-450	200-630	315-630	630-1200
长度 Length (mm)	18000	9000	9000	9000	9000	9000	9000	6000

#### 备注/Remark:

A-浸泡式，B-全封闭式箱体，C-框架式推拉门结构  
A-Immersion style, B-Overall structure, C-PC board sliding door

# 牵引机

## HAUL-OFFS

### 特点/Features:

- 超长的接触长度在管材和皮带/胶块之前摩擦系数很低的情况下，仍能保证很高的牵引力；
- 下履带通过机械/电动方式调节到管径位置，上履带/胶块由气缸压紧到管的表面；
- 每一履带由单独的异步电机驱动，通过数字控制器达到同步控制，保证各履带速度的精确同步；
- 三履带及以上标配进口伦茨电机，双履带标配诺德电机；
- 采用进口编码器，保证速度真实稳定反馈到主机；



◆ 双履带牵引机：H32



◆ 六履带牵引机：H800-6

# 无屑行星切割机

## SWARFLESS PLANETARY SAW

### 特点/Features:

- 大口径PO管材切割
- 无锯末,无噪音
- 低成本,高效能
- 切割台由气缸驱动

- For the cutting of large PO pipe
- Swarfless and noiseless cutting
- Low cost, high performance
- Cutting table is driven by cylinder



◆ 无屑行星切割机：C800P

### 技术参数/Technical Data

型号/Type	H32	H63	H160-3	H250-4	H315-4	H450-4	H630-6	H800-6	H1200-10
接触长度 Contact length(mm)	1000	1200	1600	1600	1600	1600	1600	1600	2000
管径范围 Pipe range.(mm)	10-32	10-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200
最高牵引速度 Max. hauling speed (m/min)	1-50	1-30	0.5-15	0.2-10	0.1-5	0.1-5	0.05-2.5	0.05-2.5	0.1-0.55

### 技术参数/Technical Data

型号/Type	C32F	C63RF	C160RF	C250R	C315P	C450P	C630P	C800P	C1200P
管径直径 Pipe diameter.(mm)	10-32	16-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200
最高切割频率 Max. cutting frequency (1/min)	60	6	6	4	4	3	2.5	2	1
最高切割速度 Max. cutting speed (m/min)	50	30	20	10	5	5	5	2.5	1.3

## 飞刀切割机

### FLYING KNIFE CUTTER

#### 特点/Features:

- ◆ 用于小管径PO管材切割
- ◆ 由直接安装伺服电机上的刀具切割
- ◆ 由伺服定位控制刀具
- ◆ 高效快速切口美观
- ◆ For the cutting of small PO pipe
- ◆ Cutting by knife which is directly installed on the servo motor
- ◆ Servo positioning controls the knife
- ◆ Quick and efficient with a nice cutting



◆ 飞刀切割机: C32F



◆ 飞刀切割机: C63F

## 半自动盘卷机

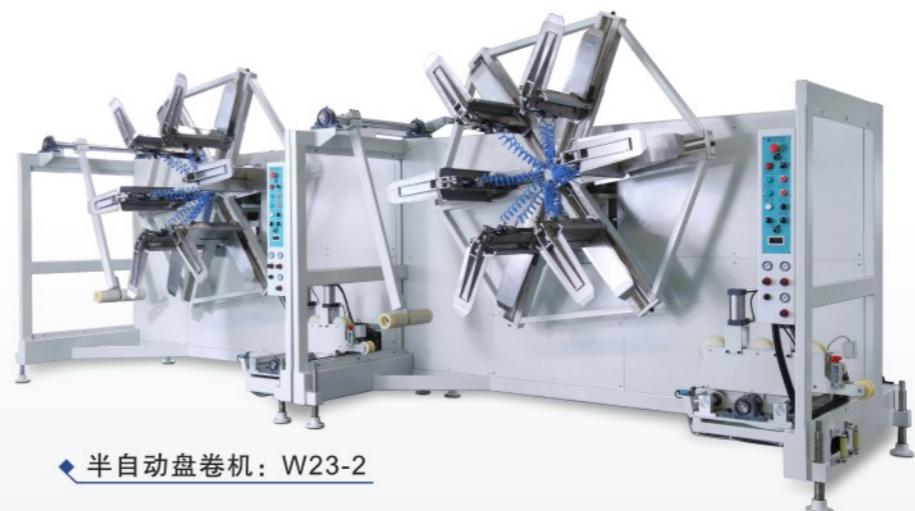
### SEMI-AUTOMATIC COILER

#### 特点/Features:

- ◆ 齿轮箱和电机使用德国诺德品牌，保证长期高速稳定运行
- ◆ 自动排线
- ◆ Gearbox and motor using Nord brand from Germany, can ensure long-term, high-speed and stable operation.
- ◆ Automatic emissions line.



◆ 半自动盘卷机: W12/2



◆ 半自动盘卷机: W23-2

## 双工位切割机

### DOUBLE STATION CUTTING UNIT

#### 特点/Features:

- ◆ 无屑切割保持生产环境清洁
- ◆ 切刀由线性导轨引导
- ◆ 切割台由伺服电机同步或气缸驱动
- ◆ Swarfless cutting keeps a clean production environment.
- ◆ Cutting tool is guided by linear guide.
- ◆ Cutting table is driven by synchronous servo motor or cylinder



◆ 双工位切割机C160RF

#### 技术参数/Technical Data

型号/Type	WA10-2	WA11-2	W12-2	W23-2	W27-2	W35-2
工位 Station	2	2	2	2	2	2
管径直径 Pipe diameter.(mm)	16-25	16-32	16-32	20-63	40-75	90-140
最高盘卷速度 Max. coiling speed(m/min)	60	60	50	25	20	12
最大外径 Max. outside diameter (mm)	1000	1100	1200	2300	2700	3500
内径可调 Inside diameter adjustable (mm)	400-500	400-600	360-600	600-1500	700-1900	1500-2500
宽度可调 Width adjustable (mm)	200-320	200-320	150-360	150-500	150-500	300-670
最大深度 Max. depth (mm)	250	250	300	350	350	450

# 双管挤出

## DUAL-STRAND EXTRUSION

### 特点/Features:

- 在生产小口径管材而要求高产量的情况下，尤其显现出使用双管挤出的优势。我们的双管下游设备的特点是带两套独立的控制回路，每条管线的速度可以分别调整，甚至可以同时生产不同管径的管材。
- 有效节省生产场地所需空间。
- 降低对工人操作技术难度，同时降低工艺要求。
- 适用于32以下管材的高速生产，管材稳定生产速度达到40m/min。

- In the production of small pipes, it can especially show the advantages of using dual strand extrusion line. The features of our dual strand downstream equipments is with two sets of independent control loops. Speed of each line can be adjusted separately, and it can even produce pipes with different diameters at the same time.
- Save space effectively for production site.
- Reduce technical difficulty for workers to operate, and also reduce process requirements at the same time.
- Suitable for the high speed pipes less than 32mm. The line speed can achieve 40m/min with stable operation.



◆ 双牵引切割机：HCD32

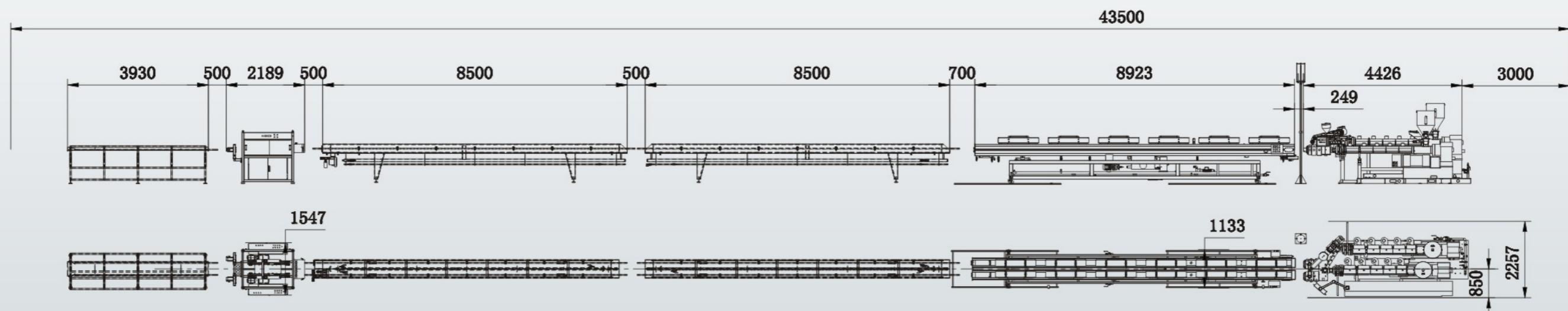


◆ 双管模具：MD32S

# PPR一出四双色管材生产线解决方案

## THE SOLUTIONS OF PPR FOUR STRAND DOUBLE COLOR EXTRUSION LINE

机型 Machine NO:	挤出机 Extruder	模具 Extrusion die	真空定径机 Vacuum calibrator	冷却槽 Cooling bath	牵引切割 Haul-off and cutter combination
型号Type	CE75-36L & CE60-36Z	MQ25-2S	VQ25-9	BQ25-9	HCQ25
特点 Characteristic	高塑化率和良好的熔体均匀度 High plasticizing rate and excellent melt uniformity	一出四双色模具 Four-strand die head 适用管径16-32mm For 16-32mm diameter 带彩条共挤 Co-extrusion with color stripe	一体化箱体 Overall structure 真空变频控制 Vacuum frequency conversion control 浸泡模式 Immersing mode	一体化设计 Integrated design 旋涡水流 Vortex flowing	紧凑型设计 Compact design 四组独立回路 Four sets of independent control loops 飞刀切割无屑高效 Flying knife cutter with Swarfless and high efficiency

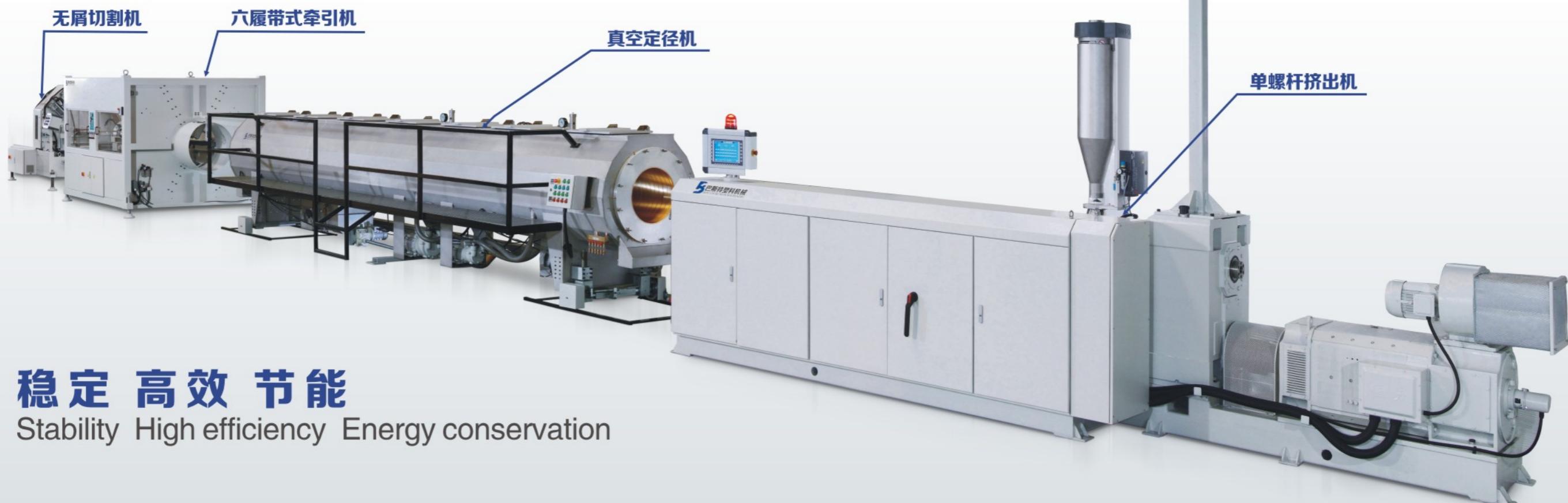


# 630MM HDPE 管材挤出生产线

## 630MM HDPE PIPE EXTRUSION LINE

- ◆ 挤出机电机转速、牵引机电机转速均由编码器测速反馈，从而保证了螺杆转速和牵引速度的稳定
- ◆ 挤出机机螺杆优化设计，保证螺杆高转速时的塑化效果，实现高产低能耗
- ◆ 模具使用内冷系统，提高冷却效果，减少喷淋箱长度，减少生产成本
- ◆ 生产线可在主挤出机实现对下游设备的各项控制
- ◆ 生产线使用多个国际知名品牌部件
- ◆ The motor speed of extruder and haul-off are measured and feedback by the encoder, which ensures the stability of screw speed and traction speed.
- ◆ With optimized screw design for extruder, it can guarantee a good plasticizing effect under the high screw speed, and achieve high output and low power consumption.
- ◆ Die head using Inner Pipe Cooling System, can improve cooling effect, reduce the length of spray cooling tank and save production costs.
- ◆ The extrusion line can achieve various control of downstream equipments by the extruder.
- ◆ The extrusion line uses several international famous brands.

生产线 Extrusion line	挤出机型号 Extruder Model	挤出量 Output (kg/h)	每吨消耗 Consumption per ton
HDPE 16–63mm pipe extrusion line 管材挤出生产线	CE60–36	Output: 340–420kg/h	290kwh/ton
HDPE 50–250 mm pipe extrusion line 管材挤出生产线	CE75–36	Output: 550–600kg/h	280kwh/ton
HDPE 200–630 mm pipe extrusion line 管材挤出生产线	CE90–36	Output: 800–900kg/h	275kwh/ton
HDPE 315–800 mm pipe extrusion line 管材挤出生产线	CE120–30	Output: 1100–1200kg/h	260kwh/ton



**稳定 高效 节能**

Stability High efficiency Energy conservation