



Specifications for PE Foam Pipe Extrusion Line

FS-FPG75 PE FOAM PIPE MACHINE



Photo Is only for reference



I 75型发泡管棒生产线包括以下主要部分

75 foam tube/rod extrusion line includes the following components

序号 No	名称 Name	数量 Quantity	图片 Picture
----------	------------	----------------	---------------

<p>1</p>	<p>挤出机 Extruder</p>	<p>1 set</p>	
<p>2</p>	<p>挤出模头 Extruder head and mold</p>	<p>1 set</p>	
<p>3</p>	<p>发泡剂注入单元 Blowing agent injection unit</p>	<p>1 set</p>	
<p>4</p>	<p>抗缩剂注入单元 Anti-shrinkage agent injection unit</p>	<p>1 set</p>	

5	<p>冷却单元 Air fans drying device</p>	1set	
6	<p>牵引机 Puller machine</p>	1 set	
7	<p>重力收卷单元 Gravity winding unit</p>	1 set	
8	<p>控制柜 Control cabinet</p>	1 set	

9	上料梯子 Feeding ladder	1set	
10	混料机 100kg Mixer	1set	

II 主要技术参数 Main Parameters

项目 Item	单位 Unit	参数 Parameter	备注 Remark
型号 Model		FS-FPG-75	
螺杆直径 Diameter of screw	mm	75	
适用材料 Applicable material		LDPE	
制品直径 Diameter of product	mm	10-50 (管 tube) 6-38 (棒 rod)	
产量 Output	kg/h	20-40	
线速度 Line speed	m/min	0-80	
电源 Power supply		三相 three phase 380v/50Hz	
整机额定功率 Rated power	Kw	40	
外形尺寸 External dimension	mm	20000×3000×3000	
整机重量 Weight	Ton	约 2.5 About 2.5	

III 各部分详细介绍 Details of foam sheet extrusion line

A 挤出机 Extruder



1. 螺杆, 机筒材质 Screw bolt and barrel material:

38CrMoAlA 氮化处理 38CrMoAlA nitrogen treatment

2. 主电机形式 Main motor style

交流电机配变频调速 Three-phase asynchronous motor with frequency converter

3. 减速机 Speed reducer

挤出机专用减速机, 硬齿面, 高扭矩, 低噪音

Extruder dedicated reducer, hard tooth surface, high torque, and low noise

4. 加热器 Heater

铸铝加热器, 固态继电器无触点输出, 智能温控仪控温 Cast aluminum heater, adopt the solid-state relay, no contact to output, intelligent temperature controller control the temperature.

5. 冷却降温方式 Cooling type

水循环冷却, 带自动旁路系统 Circulating water cooling, automatic by-pass systems.

6. 技术参数 Technical data

驱动电机功率 Driving motor power (kw)	11
螺杆直径 Diameter of screw (mm)	Φ75
螺杆长径比 L/D ratio of screw	55: 1
螺杆最高转速 Max rev of screw (rpm)	60
最高挤出量 Max yield per hour (kg/h)	50
加热段数 Number of heating zones	8
加热功率 Heating power (kw)	25

B 挤出模头 Extruder head and mold

1. 结构 Structure

圆形挤出模头, 模具可依据客户要求的规格调换

Round of the extruder head, mold can be changed according to customer's specifications

2. 材质 Material

优质中碳锻钢, 经热处理, 流道表面粗糙度: Ra0.025μm:

High quality carbon forging steel, heating processing, flow channel roughness Ra0.025μm



3. 主要技术参数 Main technical data

模口直径 Diameter of molds	根据客户要求 According to customer's pipes diameter
温度控制区数 Zones of temperature control	2
加热功率 Heating power (kw)	3

C 发泡剂注入单元 Blowing agent injection unit

1. 泵种类 Pump type

高压计量泵 high pressure measure pump

2. 主要技术参数 Main technical data

发泡剂种类 Blowing agent type	液化丁烷 Liquefied butane
计量泵流量 Metering pump flow (L / H)	25
输出压力 Output pressure (MPa)	10-30
压力表 Pressure gauge (MPa)	0-60
电机功率 Motor power (kw)	1.1

D 抗缩剂注入单元 Anti-shrinkage agent injection unit

1. 泵种类 Pump type

高压计量泵，单缸柱塞式 high pressure measure pump , single-cylinder plunger type

1. 主要技术参数 Main technical data

抗缩剂种类 Anti-shrinkage agent type	单硬脂酸甘油酯 (D-95) Distilled glycerin monostearate
泵流量 Pump flow (L / H)	3
融化锅体积 Size of melting pot (L)	6
输出压力 Output pressure (MPa)	10-30
压力表 Pressure gauge (MPa)	0-60
电机功率 Motor power (kw)	0.75

E 冷却定型及牵引机 Cooling, conveying and hauling machine

1. 冷却方式：输送带自然冷却加风冷 Cooling type: natural cooling by conveyor belt and wind cooling

2. 牵引方式：压辊牵引 Pulling type: Press roller

3. 压辊规格：钢制，滚花，表面镀硬铬 Specification of press roller: steel, knurling, hard chromium on the



龙口市富士包装机械有限公司

Longkou Fushi Packing Machinery Co., Ltd

Langao Industrial Zone, Longkou City, Shandong Province, 265709, China.

www.plastic-foam-machine.com

Mail:sales@fushijixie.cn

Tel: +86 -15253598306

surface.

4. 牵引控制: 交流电机 变频调速 Hauling machine control: Three-phase asynchronous motor with frequency converter

5. 主要参数 Main technical data

风机功率 Blower power (w)	120×2sets
输送带电机功率 Conveyor motor power (kw)	0.75
牵引功率 Puller power (kw)	0.75
压辊数量 Quantity of press roller (piece)	2
计米器 Meter counter	1

F 重力收卷单元 Gravity winding unit

变频电机控制 Frequency changer motor control, 0.75kw

G 控制柜 Control cabinet

挤出机控制柜一套 Extruder control cabinet: one set

IV 主要部件及生产厂家 Main parts and manufacturers 主要部件及生产厂家 Main parts and manufacturers

序号 Number	名称 Name	单位 Unit	数量 Quantity	产地或品牌 Origin and brand
1	电机 Motor	台 set	1	贝德西门子 Beide Siemens
2	减速机 Reducer	台 set	1	山东 Shandong
3	变频器 Frequency converter	台 set	3	ABB
4	Φ75 螺杆 Φ75 screw	套 set	1	浙江 zhejiang
5	温控表 Temperature controller	个 unit	若干 some	欧姆龙 Omron
6	丁烷泵 Butane pump	套 set	1	华黎 Huali
7	单干脂泵 Single monoglyceride pump	套 set	1	华黎 Huali
8	铸铝加热器 Cast aluminum heater	条 unit	若干 some	江苏 Jiangsu
9	固态继电器 Solid state relay	只 unit	若干 some	德力西 Delixi
10	热继电器 Thermal relay	只 unit	若干 some	施耐德 Schneider



龙口市富士包装机械有限公司

Longkou Fushi Packing Machinery Co., Ltd

Langao Industrial Zone, Longkou City, Shandong Province, 265709, China.

www.plastic-foam-machine.com

Mail: sales@fushijixie.cn

Tel: +86 -15253598306

11	接触器 Contactor	只 unit	若干 some	施耐德 Schneider
12	空气开关 Air switch	只 unit	若干 some	正泰 CHNT

V 随机工具备件清单 Free list of tool spare parts

名称 Name	数量 Quantity	名称 Name	数量 Quantity
内六角扳手 Hexagon wrench	1 套 1Set	固态继电器 Solid state relay	2 块 2 Blocks
呆扳手 Fixed wrench	2 个 2Piece	丁烷泵密封圈 Butane pump seal ring	6 个 6Pieces
口模扳手 Mold spanner	1 把 1piece	单甘脂泵密封圈 Single-monoglyceride pump seal ring	3 个 3Pieces
模头螺丝 Mold screw	10 组 10Groups	单向阀 One-way valve	1 个 1Piece
温控表 Temperature controller	2Blocks	铸铝加热器 Cast aluminum heater	1 个 1 Piece
热电偶 Thermocouple	2 根 2 Pieces	抗缩剂锅加热器 Anti-shrinkage agents pot heater	1 个 1 Piece
模唇加热器 Mold lip heater	1 个 1 Piece		

BOOSTER PUMP WITH ONE CYLINDER AND HYDRAULIC PIPE 15M



two valves cylinder

1. Equipped with a safety valve, when the compressor air pressure exceeds 1.2Mpa, it will automatically release the pressure to the air.
2. For butane part, installed filter, for the air compressor air part, installed with oil water separator.
3. The gas-liquid interval is larger than that of ordinary pumps, preventing the cold liquid from solidifying the sealing ring, causing the sealing ring to wear faster

PE 发泡管包覆机配置(双包覆)

Configuration for PE Foam pipe covering machine (double cover)





龙口市富士包装机械有限公司

Longkou Fushi Packing Machinery Co., Ltd

Langao Industrial Zone, Longkou City, Shandong Province, 265709, China.

www.plastic-foam-machine.com

Mail: sales@fushijixie.cn

Tel: +86 -15253598306



1. 放卷部分各 1 个 Unwinding portion



2. 主机 Host machine



3. 双工位收卷 Winder: double arms type:



Arm length: 50cm

Arm diameter: 28cm

Winding diameter max: 100cm.

4. 技术参数 Technical parameters

型号 Model number	FS-BGJ2
管的直径 Diameter of pipe (mm)	20~ 60



线速度 Speed (m/min)	3-30, 带计米器 Equip with meter counter
加热方式 Mode of heating	电加热 Electric heating
电源 Power supply	三相 Three phase 380v/50Hz
总功率 Total Power (kw)	约 18 About 18

FS-XFQ1300 XPE 分条机

FS-FT1300 XPE SHEET SLICING AND REWINDING MACHINE



主要技术参数:

Main Technical parameters:

型号 model	FS-XFQ1300
适用最宽制品宽度 (mm) Max width of product	1300
产量 output	About 600-2400m/h

分切规格 Slicing size	10 pieces (or custerized) , the width of each piece can be adjustable
电源规格 power specifications	Three-phase 380V 50Hz
总功率 total power	About 1.5KW

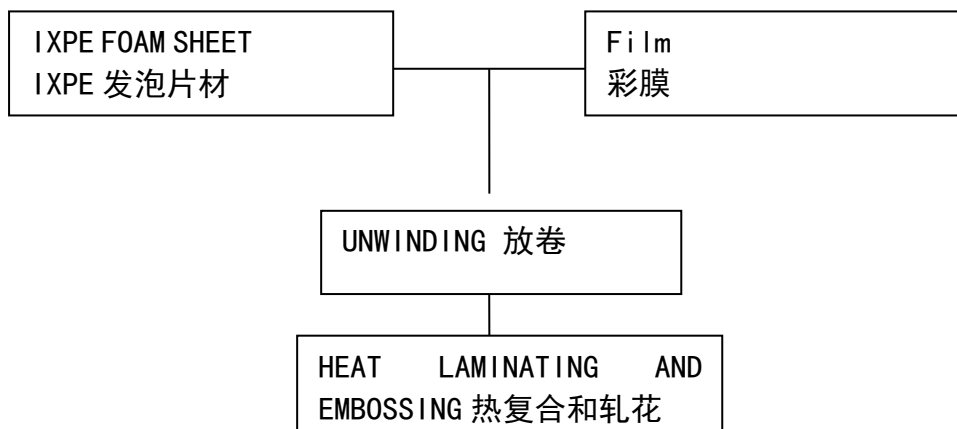
FS-XFM1200 覆膜机

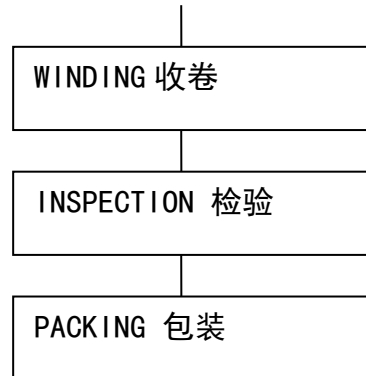
FS-XFM1200 Sheet Laminating Machine



1. 工艺流程图

Flow chart





2. 主要技术参数:

Main Technical parameters:

生产能力: 500-1500 米/小时, 根据材料材质不同和厚度不同, 速度不同

Production efficiency: 500-1500m/h, the speed is different according to different material and thickness.

制品宽度 (最大): 1200mm

Width of product (Max.): 1200mm

外型尺寸: 8000mm×2000mm×2000mm

Overall size: 8000mm×2000mm×2000mm

装机容量: 37KW

Mounted power: 37kw

整机重量: 2.2 吨

Total weight: 2.2T

使用压缩空气, 压缩气体: 0.2~0.4 m³/min, 0.6Mpa

Used Compressed Air, Compressed air: 0.2~0.4 m³/min, 0.6Mpa

3. 机器单元:

Machine unit:

覆膜辊尺寸: 192mm×1200mm

Size of laminating roller: 192mm×1200mm

覆膜辊材料: 钢辊镀铬

Material of laminating roller: steel roller with hard chromium plating

覆膜辊开合方式: 两辊由气缸带动开合



Open and close method of laminating roller: two rollers are driven by cylinder open and close

驱动功率:1.5KW

Drive power: 1.5Kw

驱动方式: 变频器调速, 操作简便。

Driving method: frequency converter adjusting speed, easy operation

加热方法: 电加热

Heating Method: electric heating

加热箱: 一套, 2 个加热器组成

Heating box :one set: composed by 2 heaters

加热功率: 16KW X 2 个

Heating power: 16KW X 2pcs

风机功率:1.5kw

Air engine power:1.5kw

收卷方式: 力矩电机

Winding method: torque motor control

收卷电机:10N.M

Winding motor: 10N.M

4. 控制单元:

Controlling unit:

电器控制柜一套

Electric control cabinet one set

温度控制: 采用高精度智能温控表,内置 PID 控制, 保证工作温度的控制准确

For temperature control: adopt high accuracy intelligent temperature controller, set PID controller inside, guarantee the working temperature control accuracy

加热控制方式: 可控硅调压块控制加热器两端电压, 从而改变加热温度。

Heating control method: silicon controlled voltage regulator control two sides voltage of heater to change the heating temperature.

5.工具备件清单

List of spare parts



序号 NO.	名称 Name	件数 Pc
1.	旋钮 a knob	2 套 2 sets
2.	交流接触器 AC contactor	1 个 1 pc
3.	壁纸刀 wallpaper cutter	2 把 2 pcs

备注：加热器属于易耗品，无质保，使用前务必先打开风机，关机时延迟风机至出风口冷风后再关闭电源。

Remarks: The heater is a consumable product and has no warranty. Be sure to turn on the fan before use. When shutting down heater, delay the fan until the air outlet is cold, then turning off the fan power.

铜管校直穿管机
Pipe Threading Machine





- 1、 Two sets of copper tube discharge device system.
- 2、 Two sets of copper pipe straightening system.
- 3、 Two sets of copper pipe traction system. (Power 1.5KW, variable frequency speed regulation)
- 4、 A set of insulation pipe positioning and clamping system.
- 5、 One set of cutting system.
- 6、 One set of winding device.
- 7、 One set of touch screen+PLC control system.

FS-ZL125/300 PE 发泡回收造粒机

FS-ZL125/300 PE FOAM RECYCLING AND PELLETING MACHINE



流程: Flow Chart:

选料—投料—机头挤出—水箱冷却—牵引—切粒—装包

Material —Put into—Extrude—Water tank cooling—Pulling—Pelletizing—Packaging

1.主要技术参数 Main specifications:

螺杆直径 Screw Diameter	Φ300×φ125mm (变径 reducing)
主电机功率 Main motor power	30kw
切粒机功率 Pelletizer power	0.75kw
加热功率 Heating power	22kw
总功率 Total power	53kw
加热区数 Segments of heating	4
产量 Throughput	100-120kg/h
适用范围 Application	PE 发泡废料回收造粒 PE foam scraps recycling and pelletizing.

2.主要部件 Main parts

主机 Main machine	1 台 set
切粒机 Pelletizer	1 台 set



龙口市富士包装机械有限公司

Longkou Fushi Packing Machinery Co., Ltd

Langao Industrial Zone, Longkou City, Shandong Province, 265709, China.

www.plastic-foam-machine.com

Mail: sales@fushijixie.cn

Tel: +86 -15253598306

水箱 Water tank	1 个 pc
四区温度控制柜 Four heating-zones temperature control panel	1 个 pc
主电机带动破碎 Motor for screw and crusher (30kw)	1 台 set.
电动换网器 Electric screen changer	1 套 set

3. Tools and spare parts list for recycling machine

名称 Name	数量 Quantity	
温控表 Temperature controller	1 个	1 piece
加热圈 Heating ring	2 个	2pcs
过滤网 Filter Screen	10 个	10pcs

Contact: Hedy Wang

Mob: 15253598306

E-mail: fushi04@foamextruder.cn



龙口市富士包装机械有限公司

Longkou Fushi Packing Machinery Co., Ltd

地址: 山东省龙口市兰高工业园

Add: Langao Industrial Zone, Longkou, Shandong 265709, China

注: 本资料内图片及数据仅供参考, 本公司保留设备元件及结构更改权, 如遇更改, 恕不另行通知。购买设备所涉及的内容、数据、配置、价格等皆以合同约定为准。

Note: The data and picture within the information for reference only, the company reserves the right to change equipment and structural components, in the case to change without notice. Purchase of equipment involved in the content, data, configurations, prices, etc, subject to contract