呈乾集团
CHENG QIAN GROUP

橡塑设备生产线定制

Rubber and Plastic Equipments Customized Production Line

专业为本

创新立业

合作共赢

昆山呈乾机械有限公司
KUNSHAN CHENGOIAN MACHINERY CO.,LTD.

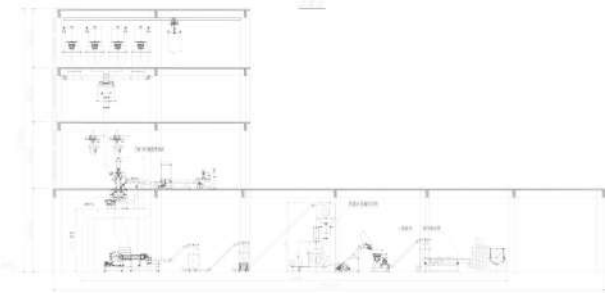
CHENG QIAN GROUP

呈乾集团

呈乾集团致力于打造全球最好的橡塑成套装备，实现更加智能、高效、数字化。聚焦科研、生产、销售、服务于橡塑行业的高新技术企业。处于世界同行业领先地位。公司总部位于上海青浦，在江苏地区设有研发及生产基地，以创新研发为主。主要产品:橡/塑密炼生产线、橡/塑压延生产线、橡/塑造粒生产线、冷/热喂料橡胶齿轮泵滤胶设备、橡胶预成型及胶胚冷却生产线等五大类。

呈乾集团坚持“强化中间夯实两端，创新引领,跨越发展”的战略发展方针，成为全球备受推崇的橡塑成套装配企业。

Chengqian Group is committed to creating the world's best rubber and plastic equipment, achieving greater intelligence, efficiency, and digitization. As a high-tech enterprise focused on scientific research, production, sales, and service in the rubber and plastic industry, we are at the forefront of the industry worldwide.
Located in Qingpu, Shanghai, the headquarters of our group is with 5 subsidiaries and R&D and production bases in Jiangsu, focusing on innovative research and development. Main products of five categories: rubber/plastic mixing production line, rubber/plastic calendaring production line, rubber/plastic pelletizing production line, cold/hot feeding rubber gear pump strainer equipment, rubber preformer and vibracool production line.
Chengqian Group adheres to the strategic development policy of "strengthening the middle and consolidating the two ends, innovation leading, and forward development", and has become a globally respected rubber and plastic equipments enterprise, providing guarantee and support for national strategies.



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HOT FEEDING GEAR PUMP STRAINER

热喂料齿轮泵在线过滤机

TECHNICAL PARAMETER 技术参数

型号 Model	最大产量 Max.Capacity	出条最大宽度 Strips Max.Width	机械尺寸 Machine Size	重量 Weight
	kg/h	mm	mmxmm	kg
GS-1000	1000	150	2500X1200	3600
GS-1500	1500	210	3800X1500	6000
GS-2000	2000	320	4100X1700	8500
GS-2500	2500	400	4200X1900	10000
GS-3000	3000	500	4400X2200	12000
GS-5000	5000	620	4700X2500	15000

齿轮泵在线滤胶机:

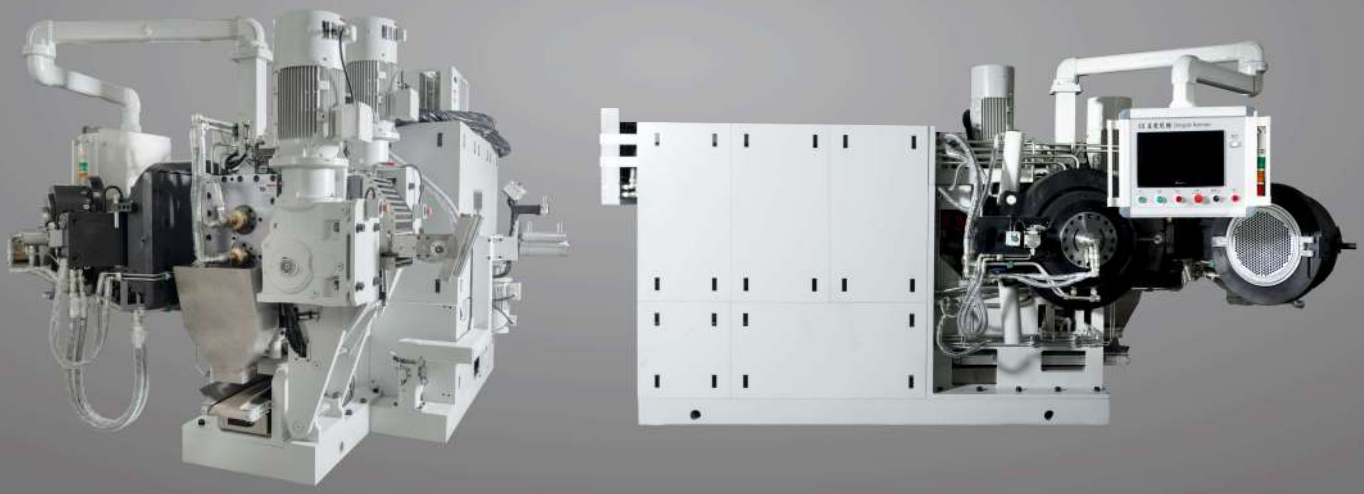
齿轮泵在线滤胶机可以低温过滤,配合混炼胶生产线在线使用,实现连续生产,操作简洁节省人工,橡胶可加硫后过滤。不同种类橡胶可过滤目数0-300目

Gearpump strainer:

The gear pump strainer can be strained at low temperature.It can be used in conjunction with the rubber mixing production line to achieve continuous production. The operation is simple and labor saving. The rubber can be filtered after adding sulfur, and different types of rubber can filter 0-300 meshes.

HOT FEEDING GEAR PUMP STRAINER

热喂料齿轮泵在线过滤机



Product advantages 产品优势 ▶

1.可用于A炼胶、B炼胶在线过滤；
2.过滤过程温升更小。
3.结构简洁，占地面积小；
4.胶料停留时间短，不影响橡胶特性。
5.可用于在线式生产，搭配开炼机使用。
6.可用于冷喂料，产量同型号热喂料的80%。

1. Can be used for online filtration of rubber compound A and rubber compound B
2. The temperature rise during the filtration process is smaller.
3. .Simple structure and small footprint;
4. The rubber material has a short residence time and does not affect the rubber properties.
5. Can be used for online production and pained with an open mill.
6. Can be used for cold feeding, with a yield of 80% of the same model as hot feeding

COLD FEEDING GEAR PUMP STRAINER

冷喂料齿轮泵在线过滤机

冷喂料齿轮泵过滤机：
冷喂料齿轮泵过滤机可以实现低温过滤，橡胶可加硫后过滤，不同种类橡胶可过滤目数0-300目，更换胶料时清理余料方便简洁。

The cold feeding gear pump Strainer can realize low temperature straining.
The rubber with sulfur inside can be also filtered. The filtering nets of different types of rubber can be 0-300 meshes. It is convenient and simple to clean the remaining material when changing the rubber.

TECHNICAL PARAMETER

技术参数

型号 Model	最大产量 Max.Capacity	螺杆直径 Screw Size	加热/冷却区 Heatin/Coolingzones	最大操作压力 Max Operating Pressure	重量 Weight
	kgs	mm		Mpa	kgs
50	70	50	4	35/60	2000
75	220	75	4	35/60	2450
90	400	90	5	35/60	3800
120	700	120	5	35/60	4500
150	1200	150	6	35/60	6000
200	2000	200	6	35/60	10000
250	3000	250	6	35/60	15000
300	4500	300	7	35/60	22000

Product advantages

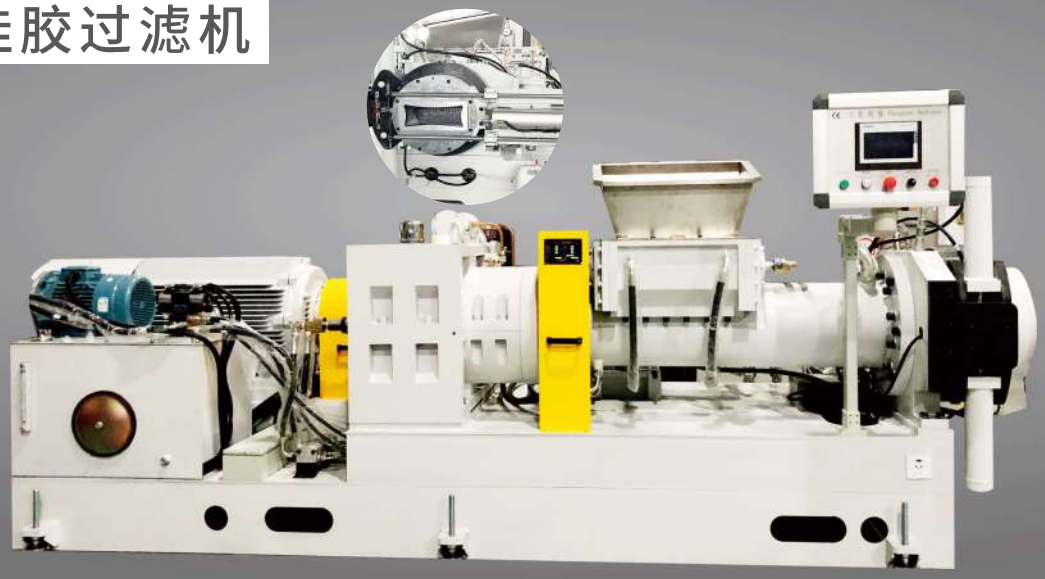
产品优势

1.A段B段均适用，加硫过滤不胶烧； **2.**清理余料方便；
3.压力可选，适用各种高低硬度橡胶； **4.**持续性生产，大幅提高生产效率；

1. Section A and B are applicable, and rubber with sulfur inside can be filtered and is not burned;
2. It is convenient to clean up the surplus materials;
3. Pressure has many options, applicable to all kinds of high and low hardness rubber;
4.Continuous production, greatly improving production efficiency;

SILICONE STRAINING MACHINE

硅胶过滤机



TECHNICAL PARAMETERS

技术参数

筒及螺杆 Barrel and screw	200	250
螺杆直径Screw diameter	200mm	250mm
长径比 L/D	5.5:1	5.5:1
螺杆转速Screw rotating speed	0–50r/min	0–40r/min
齿轮箱Gearbox		
减速比reduction ratio	20:1	25:1
强制喂料系统Forced feeding system		
喂料方式 feeding methods	双挽下压喂料 double wrists	双挽下压喂料 double wrists
电气部分Electrical parts		
主电机功率Main power	90kw变频	200kw变频
双腕喂料电机Double wrist feeding Motor	7.5Kw变频 7.5Kw variable	11Kw变频 11Kw variable
整机尺寸(长宽高)Machine sizes	4400mm*2300mm*1800mm (LxWxH)	5500mm*2500mm*1900mm (LxWxH)
重量 Weight (kgs)	5100	6200

产品用途:用于过滤各类硅橡胶的杂质。

1.本系列过滤机采用硬齿面减速机,机头采用液压抱哈式,配定长切割输送机构;
2.螺杆结构采用特殊设计避免扫膛; 3.双挽密封采用特殊的材料,及结构,有效地避免黑胶线的产生;
4.自动化程度高,大幅降低劳动强度,增产提效。

Product use:Used to filter impurities from various types of silicone rubber.

1.This series of filters adopts a hard tooth surface reducer, and the machine head adopts a hydraulic gripper type, equipped with a fixed length cutting and conveying mechanism;
2.The screw structure adopts a special design to avid sweeping the chamber;
3.The double seal adopts special materials and structures to effectively avoid the production of black glue lines;
4.High degree of automation, significantly reducing labor intensity, increasing production and efficiency

RUBBER STRAINING MACHINE

橡胶过滤机

- 可过滤丁腈橡胶、丁基橡胶、氟橡胶、硅橡胶等橡胶混合物。
- 过滤精度可达300目。与螺杆式过滤机相比，过滤过程不发热，或有烧胶现象。

- We can filter nitrite rubber, butyl rubber, fluorine rubber, silicone rubber and other rubber mixture.
- The filtration precision ups to 300 meshes. Compared to screw filter, the straining process does not heat up, or include scorching phenomenon.

PRODUCT FEATURES

产品特征 ▶

橡胶过滤机是利用柱塞推挤、输送作用,把胶料或再生胶中的杂质清除掉的机械。主要由柱塞、机筒、滤胶机头和传动装置等组成。滤胶机头上装有孔板及过滤网,孔板用于支承过滤网并为排料口,可过滤丁睛胶、丁基胶、氟胶、硅胶等各种胶料和橡胶混合料,过滤精度可达300目。相比螺杆式滤胶机,滤胶过程不升温、无焦烧现象。

Rubber straining machine is using the pushing and delivering function of the plunger to remove the impurities in the rubber or recycle rubber. Mainly consist of the plunger, barrel, filter head and transmission device, etc. The filter head is equipped with filter plates and filter net. The filter plates is used for supporting the net as the vent for material. You can flter nitrile rubber, butyl rubber, fluorine rubber, silicone rubber and cother rubber mixture. The filtration precision is up to 300 meshes. Compared to straining to screw filter, the straining process does not heat up ,or include scorching phenomenon.

TECHNICAL DATA

技术参数 ▶

项目名称 / Item	单位 / Unit	ES-20P	ES-40P
料筒内径/Cylinder diameters	mm	200	250
最大挤出压力Maximum squeezing pressure	Mpa	24	24
一次装胶量/Rubber capacity per time	L	20	40
料桶最高温度/Maximum temperature in the cylinder	C	95	95
过滤精度/Filtering accuracy	目	40-300	40-300
总功率/Total Power	kw	14	20
重量/Weight	kg	2800	3800
外形尺寸 长*宽*高/Outline size L*W*H	mm	3000*1100*1750	4000*1100*1750

DISPERSION KNEADER MIXER

加压式密炼机

TECHNICAL PARAMETER 技术参数

型号 Model	混合容量 Working(liters)	常用气压 Air pressure	主动电机 Power	翻转电机功率 Tilting motor	气缸直径 Air cylinder diameter	倾倒角度 Tilting angie	搅拌轴转速 Speed (前/后before/after)	机械重量 Weight (kgs)	投料方式 Material direction	安装尺寸 (size)l*w*h
CXN-3L	3L	0.6-0.8Mpa (6-8KG/cm)	7.5KW 6PAC	0.75KW	100mm	135°	32/26RPM(可选)	1600	背投式 front	1580X1100X1700
CXN-5L	5L	0.6-0.8Mpa (6-8KG/cm)	11KW 6PAC	0.75KW	125mm	135°	32/26RPM(可选)	1300	背投式 front	1580X1100X1700
CXN-25L	25L	0.6-0.8Mpa (6-8KG/cm)	37KW 6PAC	1.5KW	200mm	135°	32/26RPM(可选)	5000	背投式/前投式 (front or back)	2700X1700X2600
CXN-35L	35L	0.6-0.8Mpa (6-8KG/cm)	55KW 6PAC	2.2KW	250mm	135°	32/26RPM(可选)	7000	背投式/前投式 (front or back)	3200X1900X2950
CXN-55L	55L	0.6-0.8Mpa (6-8KG/cm)	75KW 6PAC	3.0KW	300mm	140°	32/25RPM(可选)	8500	背投式/前投式 (front or back)	3250*2300*3350
CXN-75L	75L	0.6-0.8Mpa (6-8KG/cm)	110KW 6PAC	4.0KW	350mm	140°	32/25RPM(可选)	10800	背投式/前投式 (front or back)	3760*2800*3280
CXN-110L	110L	0.6-0.8Mpa (6-8KG/cm)	160KW 6PAC	7.5KW	420mm	140°	32/25RPM(可选)	15000	背投式/前投式 (front or back)	4300*3000*3400
CXN-150L	150L	0.6-0.8Mpa (6-8KG/cm)	220KW 6PAC	11KW	550mm	140°	32/25RPM(可选)	20000	背投式/前投式 (front or back)	4600*3250*4200

Product advantages 产品优势

密炼机特性:

1、本机装置全自动温度及时间控制系统,操作精准.简单容易,混炼可达到最佳之分散效果。
2、混合槽为可倾倒式，搅拌轴防漏采用韩式机械轴封使清洗换色简便容易。
3、加压密封式混合槽除可确保混合物品质外并可防止环境污染。
4、混合槽采用高级合金钢制造，表面皆经耐磨处理，表面电镀硬铬耐磨性特佳。
5、电控配置可按客户要求设计。

Character:

1.This equipment possesses temperature and time control system for easy but accurate operation and best decentralization.
2.Tilt-able mixing chamber and mechanical shaft sealing design for easy cleaningand color changing.
3.Pressure sealed mixing chamber to assure the quality of mixed material and also prevent environment pollution.
4.The mixing chamber is made of soud alloy steel and work surface is hare chromim coated for supper antiabrasion.
5.Electric control configuration can be designed according to customer's request.

LAB KNEADER

实验型密炼机

Product advantages 产品优势 ▶

主要用于：

实验型密炼机：适用于各种橡胶塑料、色母等十种原材料的小批量试验混炼。体积小，低能耗，省人工，为客户提供节省原材料的最佳混炼设备。

Lab kneader: suitable for small-scale experimental mixing of ten types of raw materials such as rubber, plastics, colorants, etc. Small size, low energy consumption, labor-saving, providing customers with the best mixing equipment that saves raw materials.

LAB MILL

实验型开炼机

Product advantages 产品优势 ▶

主要用于：

小型炼胶机适用于橡胶和塑料行业材料研发和小规模生产的设备，适合高校和企业研发调试橡胶配方的小型炼胶机器，双辊设计，辊轴平行且可调节间距，具有多重规格、配置和特点，能够满足不同用户的需求。

Lab mill: suitable for small-scale experimental mixing of ten types of raw materials such as rubber, plastics, colorants, etc. Small size, low energy consumption, labor-saving, providing customers with the best mixing equipment that saves raw materials.

OPEN MIXING MILL

开炼机

TECHNICAL PARAMETER 技术参数

型号 Model	辊筒直径 Roll Diameter	工作长度 Roll Working Length	前辊线速 Front Roll linear Speed	前后辊速比 Speed Ratio Of Rolls	最大辊距 Max roll space	一次加料量 Compound Feeding Capacity	电机功率 Motor Power	外形尺寸 Overall Dimensions			约重 Weight
	mm		m/min	m/min	mm	kg	kw	L(mm)	W(mm)	H(mm)	t
CXK-160	160	320	8.5	1:1.2	4.5	1-2	5.5	1133	920	1394	1
CXK-250	250	620	16.3	1:1.1	8	10-15	18.5	3200	1115	1345	2.3
CXK-300	300	750	15.7	1:1.17	10	15-20	22	3800	1320	1350	5.9
CXK-360	360	900	17.7	1:1.25	10	20-25	30	4200	1780	1560	6.8
CXK-400	400	1000	19.4	1:1.27	10	18-35	45	4670	1860	1600	8.8
CXK-450	450	1200	21.8	1:1.27	12	50	55	5250	1900	1750	12.1
CXK-550	550	1530	28	1:1.2	16	50-65	110	6350	2320	2280	24.5
CXK-610	610	1930	30	1:1.13	15	140	160	6650	2980	2350	40
CXK-660	660	2130	31.5	1:1.24	15	165	250	6750	3450	2380	50
CXK-710	710	2200	31.9	1:1.2	15	190	280	8300	4080	2700	66

Product advantages 产品优势

主要用于:

橡胶胶料的塑炼、混炼、压片以及为后续设备供胶。开放式炼胶机简称开炼机或炼胶机,它通过两个水平放置并以不同线速度相对回转的辊筒,将橡胶或塑料原材料进行剪切、挤压,达到对材料的塑炼、胶料的混炼、热炼、压片的过程。辊筒有中空和周边钻孔两种结构:调距方式有手动调距、电动调距、液压调距形式;挡胶板分为固定式、手动移动式、液压移动式;传动方式分为单驱动单出轴、单驱动双出轴和双驱动;可根据工艺流程选配翻料装置,节省人力,提高工作效率。

Mainly used for plasticizing, mixing, and pressing rubber materials to provide rubber for subsequent equipment. An open type rubber mixing machine, also known as an open mill or rubber mixing machine, uses two horizontally placed rollers that rotate at different linear speeds to shear and squeeze rubber or plastic raw materials, achieving the process of material plasticization, rubber mixing, hot refining, and tablet pressing. There are two types of roller structures: hollow and peripheral drilling. The distance adjustment methods include manual distance adjustment, electric distance adjustment, and hydraulic distance adjustment; Rubber blocking plates are divided into fixed, manually movable, and hydraulic movable types; The transmission methods are divided into single drive single output shaft, single drive dual output shaft, and dual drive; A flipping device can be selected according to the process flow to save manpower and improve work efficiency.

产品特点:

本机为两辊卧式结构,采用滚动轴承支承辊筒,省电节能,使用寿命长,提供稀油润滑或干油润滑两种方式,依据再生胶生产工艺流程配置多种速比,剪切力大,速度快,捏炼效果好,辊筒采用合金冷硬铸铁,硬度符合国家标准,前后辊均为光辊,机器可分右传动和左传动,订货时没有提出要求均按右传动供货。

Product features

This machine is two horizontal roller structure,the use of rolling bearing support roller,save electricity and energy saving,service life is long,thin oil lubrication or dry oil lubrication in two ways,on the basis of reclaimed rubber production process configuration a variety of speed ratio,shear strength,speed,mastication effect is good,using alloy chilledcast iron roller,hardness meet the national standard,and roller are light roller, the machine can be divided into transmission and the left and right order without asking allthe righttransmission supply.l drive; A flipping device can be selected according to the process flow to save manpower and improve work efficiency.

HOT FEEDING EXTRUDER

热喂料挤出机

SE-150/200/250 TECHNICAL DATA 技术参数

筒及螺杆 Barrel and screw	150	200	250
螺杆直径Screw diameter	150mm	200mm	250mm
长径比 L/D	L/D=7:1	L/D=6:1	L/D=5.5:1
螺杆转速Screw rotating speed	0–58r/min	0–58r/min	0-42r/min
齿轮箱Gearbox			
减速比reduction ratio	16:1	18:1	22:1
输入功率 conveying power	55kw–6p	90kw-6p	110 kw-6p
强制喂料系统Forced feeding system			
喂料方式 feeding methods	双挽下压喂料 double wrists	双挽下压喂料 double wrists	双挽下压喂料 double wrists
电气部分Electrical parts			
主电机功率Main power	55kw变频	75kw变频	110kw变频
双腕喂料电机Double wrist feeding Motor	5.5kw变频 5.5kw variable	7.5kw变频 7.5kw variable	11.5kw变频 11.5kw variable
液压站电机 Hydraulic Station Motor	5kw	5kw	5kw
整机尺寸(长宽高) Machine sizes	3900*2100*1700(mm) (LXWXH)	4400*2300*1800(mm) (LXWXH)	5400*2600*1800(mm) (LXWXH)
重量 Weight（kgs）	3400	5100	6200

产品用途:本机型主要用于过滤天然胶、丁基胶、三元乙丙胶、硅胶、再生胶等橡胶中的杂质,也可用于各类橡胶挤出成型。

特点:与传统过滤机相比,具有以下优点::

1.采用双挽喂料装置,从密炼机倒出的团状料可顺利喂料。

2.采用液压换网器,换网快、操作方便快捷。　　3.可装配出片机头,直接出胶片。

Product use: This model is mainly used to filter impurities in natural rubber, butyl rubber, EPDM rubber, silicone rubber, recycled rubber and other rubber, and can also be used for various rubber extrusion molding.

Features: Compared with traditional filter machines, it has the following advantages:
1. Adopting a double roll feeding device, the bulk material poured out from the mixer can be fed smoothly.
2. Adopting a hydraulic screen changer, the screen replacement is fast and the operation is convenient and fast.
3. It can be equipped with a film head to directly produce film.

HOT FEEDING EXTRUDER
热喂料挤出机

TECHNICAL PARAMETER
技术参数

型号 Model	螺杆直径 Screw Diameter	长径比	螺杆转速 Screw Speed	主电机 Main Motor	齿轮箱速比 Gear Ratio	喂料方式 Loading	最大生产能力 Max. Capacity	机器尺寸 Machine Sizes
	mm	L/D	r/min	kw			kg/h	LxWxH(mm)
CQD-150	150	7:1	58	55变频	16:1	热喂料 hot feeding	500-800	3900*2100*1700
CQD-200	200	6:1	56	90变频	18:1		900-1500	4400*2300*1800
CQD-250	250	5.5:1	45	110变频	22:1		1500-2000	5300*2600*1900
CQD-300	300	5.5:1	45	160-变频	22:1		2500-3000	5400*2700*1900

Product advantages
产品优势

热喂料过滤挤出机,要求喂入的胶料必须经过热炼，且供料均匀、稳定、等速，热喂料过滤挤出机生产工艺需要配合开炼机使用,开炼机下片直接喂料,可实现边过滤、边出片。

The hot feeding straining extruder requires hot feeding of rubber, and the feeding should be uniform and stable with a constant speed. The material temperature should be maintained at 50-70 ℃. The production process of the hot feeding straining extruder needs to be used together with the open mixing mill to achieve filtering and sheeting. The open mixing mill directly conveys the sheet for loading.

PIN TYPE COLD FEED RUBBER EXTRUDER

销钉挤出机

TECHNICAL PARAMETER 技术参数

型号 Model	螺杆直径 Screw Diameter	长径比	螺杆转速 Screw Speed	电机功率 Main Motor	最大生产能力 Max. Capacity	喂料方式 Loading
	mm	L/D	r/min	kw	kg/h	
XD-90	90	12:16:20	60	55	250-350	旁压辊喂料 Side Roller Feeding
XD-120	120	12:16:20	50	110	600-800	
XD-150	150	14:16	43	160-250	800-1200	
XD-200	200	12:14:16	38	200-355	1200-2000	
XD-250	250	12:14:16	3.5-25	355-500	2000-3000	

Product advantages 产品优势

销钉式冷喂料橡胶挤出机
用于挤出各种橡胶制品及供胶

1.选配不同的机头可挤制不同的橡胶半成品,或为压延机供胶。
2.销钉机筒为分段式结构,喂料段机筒与旁压辊配合增加喂料能力,塑化段和挤出段的机筒上装有数量不等的销钉。
3.该机的优点是塑化效果好,挤出能力强,出胶温度低,运行平稳等。
4.根据客户需要,可为销钉式冷喂料挤出机配备供胶装置输送胶片等。

Pin type cold feed rubber extruder used for extruding various rubber products

1.Optional different machine heads can be use? to extrude different semifinished rubber products, or to supply rubber for rolling machines.
2.The pin barrel is a segmented structure, and feeding section barrel is matched with the side roller to increase the feeding capacity. The plasticizing and extrusion sections of the barrel are equipped with various numbers of pins.
3.The advantages of this machine are good in plasticiztion effect, strong extrusion capacity, low temperature of extruded rubber, and smooth operation.
4. According to customer's requirements, the pin type cold feed extruder can be equipped with a rubber supply device to transport sheet.

COLD FEEDING GEAR PUMP PREFORMER MACHINE

冷喂料齿轮泵预成型机

TECHNICAL PARAMETER 技术参数

型号 Model	最大产量 Max.Capacity	最大操作压力 Max operating pressure	螺杆直径 Screw Size	螺杆长径比 ScrewL/DRatio	主电机功率 Main power
	kg/h	Mpa	mm	l/d	kw
50	70	35/60	50	12:1	11
75	180	35/60	75	12:1	30
90	320	35/60	90	10:1	55
120	550	35/60	120	10:1	90
150	1000	35/60	150	10:1	220
200	1500	35/60	200	10:1	315

型号 Model	加热冷却区 Heating/coolingzones	最大模具尺寸 Max. Die Size	切刀转速 (可变) Cutter speed (Variable)	重量精度(体积) Accuracy(by volume)	重量 Weight
		mm	r/min	%	kgs
50	4	73	0–400/–800	±1	2500
75	5	100	0–400/–800	±1	2950
90	5	190	0–400/–800	±1	4800
120	6	190	0–400/–800	±1	5500
150	6	190	0–400/–800	±1	6000
200	6	190	0–400/–800	±1	7500

相对传统预成型机,齿轮泵预成型机拥有连续不间断的生产能力,超高的产能,免去了在开炼机上预热橡胶的环节,操作更加便捷,节省劳动力。

Compared with the traditional preformer machine, gear pump preformer machine has continuously loading production capacity and ultrahigh production capacity, which eliminates the process of preheating rubber on the open mixing mill, making the operation more convenient and saving labor.

优点:

1、连续性生产,提高生产效率;

2、输出稳定,提升精度;

3、液压开夹抱哈式夹环,方便分离螺杆机与齿轮泵,方便清理,液压退模装置,方便取下尾料,减少劳动量。

Advantage:

1. Continuous production, improving production efficiency;
2. Stable output and improved accuracy;
3. Hydraulic open clamp clamp ring, convenient for separating screw machine and impeller pump, easy to clean, hydraulic demoulding device, easy to remove tailings, reducing labor

COLD FEEDING PREFORMER MACHINE

冷喂料系列预成型机

TECHNICAL DATA 技术参数

料筒及螺杆Barrel and screw	CP-50	CP-75	CP-90	CP-120
1 螺杆直径Screw diameter	50mm	75mm	90mm	120mm
2 长径比 L/D	L/D=12:1	L/D=12:1	L/D=12:1	L/D=12:1
齿轮箱Gearbox				
1 减速比reduction ratio	16:1	16:1	20:1	20:1
2 输入功率 conveying power	7.5kw-6P	30kw-6P	55kw-6P	90kw-6P
切刀系统Cutting system				
1 最大摸具直径Max. Die diameter	68mm	100mm	127mm	190mm
2 最大胶胚重量Max.Blanks weight	500g	1000g	2000g	2000g
3 最大产量/小时Output/hour	70kg	180kg	300kg	550kg
4 切刀转速 cutter speed	单刀每分钟 30-400(r/min)	单刀每分钟 30-400(r/min)	单刀每分钟 30-400(r/min)	单刀每分钟 30-400(r/min)
5 整机尺寸（长*宽*高）Machine sizes	3080*1050*1980	3900*1840*1850	3630*1290*1850	4570*2220*1900
6 重量Weight（kgs）	1100	2520	2660	4700

COLD FEEDING PREFORMER MACHINE

冷喂料系列预成型机

PRODUCT FEATURES

产品特征 ▶

冷喂料螺杆预成型机是一种高效率、高精度的胶胚生产设备。机器工作中将条状冷胶料经过螺杆的混炼、塑炼、传送、切割成固定大小和形状。适用于各种橡胶硅胶制品的胚料生产。

特点：

1、把常温下的条料连续不断的切成客户需要的形状和重量。

2、PLC控制，工艺参数存储，直接调用，操作简便。

3、电子秤闭路反馈，一键校准胶胚重量。

4、故障报警面板显示故障原因及故障位置，提醒工人检修。

5、机头、切刀等装置互锁，全方位防护，有效避免工伤出现。

6、挤出压力设定及显示采用数字化显示在触摸屏，为PLC运算提供参考数据，进一步简化操作流程。

Product features:Cold feeding screw preform machine is a high-efficiency and high-precision equipment for producing rubber preforms.During machine operation, the strip-shaped cold rubber material is mixed, plasticized, transported, and cut into a fixed size and shape through screws. Suitable for the production of raw materials forvarious rubber and silicone products.

characteristic:

1. Continuously cut the strip material at room temperature into the shape and weight required by the customer.
2. PLC control, process parameter storage, direct calling, easy operation.
3. Electronic scale closed-loop feedback, one click calibration of rubber embryo weight.
4. The fault alarm panel displays the cause and location of the fault, reminding workers to carry out maintenance.
5. The machine head, cutting blade and other devices are interlocked for comprehensive protection, effectively avoiding work-related injuries.
6. The extrusion pressure setting and display are digitally displayed on the touch screen, providing reference data for PLC calculations and further simplifying the operation process

ES STANDARD RUBBER PREFORMER

ES系列标准精密预成型机

ES-2P/ES-5P/ES-20P/ES-40P/ES-60P TECHNICAL DATA

ES-2P/ES-5P/ES-20P/ES-40P/ES-60P 技术参数 ▶

项目名称/Item	单位/Unit	ES-2P	ES-5P	ES-20P	ES-40P	ES-60P
料筒容积/Batch Size	L	2	5	20	60	80
标准挤出压力Standard Extruding Pressure	psi	3000	3000	3000	3000	3000
装料位置/Load position		前部/front	前部/front	前部/front	前部/front	前部/front
料桶直径/Barrel Diameter	mm	100	100	200	250	250
最大生产能力kg/小时Maximum Output/Hour	kg	50	75	270	450	650
最大模头尺寸mm/Maximum Die Diameter	mm	60	76	127	190	190
总功率/Total Power	kw	10	13	16	23	30
油箱储量/Oil Reservoir	L	50	60	200	200	250
供气流量/Air Supply	mpa			0.6–1.0	0.6–1.0	0.6–1.0
供水流量(25℃)/aterSupply(25℃)	L/min		15	20	35L	35L
重量/Weight	kgs	400	880	3200	4000	5000
外形尺寸 长*宽*高/Outline size L*W*H	mm	1900*683*1750	2900*920*1700	3800*1100*1750	4400*1100*1750	5800*1100*1750

产品优势 ▶

1、电子秤自动反馈胶坯重量　　2、7寸彩色触摸屏　　3、多种语言支持(如日语，英文)　　4、密码保护
5、触摸屏数据输入　　6、适合各种胶料并按硫化需求预成型　　7、刀头特殊平衡设计，运转安静稳定
8、设计简单，保养维修方便　　9、采用特殊油压回路,确保胶胚重量精度　　10、投资回报率高(省人工,省胶料)

ADVANTAGES ▶

1、Weigh scale feedback loop for blank weight control.　　2、7 Inch visible colour screen.
3、Multi-language available(e.g.apanese,English).　　4、Password level protection.　　5、Data input on Touch screen.
6、Suitable to preform all rubber material as vulcanizing required.　　7、Special balance design for cutter and runs stably
8、Simple design for ease of maintenance and service.
9、 Special logic hydraulic circuit with patent to ensure weight precision for rubber blanks.
10、Quick return on investment (labor&material saving)

ES RUBBER PREFORMER

ES系列预成型机

预成型机是一种高效高精度的胶胚生产设备,它的最大优势在于能在有限的时间内挤出各种精密的中、高硬度的环形、条形、立体型、复杂胶胚。此设备适合生产橡胶杂件、0型圈、气门嘴、油封、高尔夫球网球、汽车配件、鞋底产品等,它集抽真空、过滤、挤出、切割、称量、计数等多功能于一体,不仅满足了客户的各种需求,而且节省了人工成本,提高了生产效率。

Preformer can produce blanks with high efficiency and high accuracy. lts biggest advantage is to extrude accurately all kind of medium/high-hardness blanks with different shapes, like ring, bar, three dimension and so on. lt is used widely in Rubber industry, 0 Ring, Valves, Oil seal, Golf, Tennis Automotive, Footwear and other industries. lt integrates vaccuming, filtering, extruding, cutting with weighing and counting together. Not only can it meet needs of customers, but also it saves labor cost and enhances productivity.

STANDARD FEATURE OF RUBBER PREFORMER MACHINE

ES精密预成型机基本特性 ▶

- 预成型坯重量精度可达+1%
- 标准操作压力210bar (3000psi)
- 切刀最高可达400转/分(单刀)
- 交流变频切刀控制
- 液压控制系统带比列阀
- 电子秤自动反馈胶坯重量
- 定点长度切割(脉冲切)
- 闪存卡可存储350种产品参数
- 可手动或自动循环操作
- 输送带正反转
- Preform accuracy up to +/- 1% by volume
- Standard operating pressure of 210 bar (3,000psi)
- Speeds up to 400 cuts per minute (single blade)
- Variable AC inverter controlled cutter
- Powerpack hydraulics with proportional flow control
- Weigh scale feedback loop for blank weight control
- Cut to length (pulse cut) facility
- 350 kinds of data base on removable “Flash memory"
- Manual or automatic cycle
- Conveyor Forward and Reverse

OTHER OPTIONS

其他功能 ▶

- 240 bar (3500 psi) 或 380 bar (5500 psi)操作压力
- 后喂料
- 预成型过程中同步过滤
- 更换口模简单
- 可中心加长
- 双刀可达到800切/分
- 240 bar (3500 psi) or 380 bar (5500 psi) operating pressure
- Load Behind
- Simultaneous screening
- available during preforming Simple installation
- Extended centre
- Double cutters(800 cuts/min)

ES STANDARD RUBBER PREFORMER

ES系列标准精密预成型机

传统工艺 Traditional Production Process　　现代工艺 Modern Production Process

炼胶 → 滤胶 → 挤出 → 切割 → 称重 → 搭接 → 硫化 → 检验包装

可用预成型机过滤

用预成型机快速精确生产胶坯，无搭接口，无气泡

Mixing → Straining → Extruding → Cutting → Weighing → Jointing → Vulcanizing → Inspection & Packing

Straining with Preformer

Rubber blanks Preformed by Preformer are without Joint and air Bubble

INDUSTRIES SERVED

使用行业

- 挤压成型
- O型圈&油封
- 一般制品
- 汽车
- 鞋类
- 运动
- 休闲
- 农业
- 母料
- 医药
- TPE/EVA
- 建筑业

- Extrusion profiling
- O Ring & Oil Seal
- General goods
- Automotive
- Footwear
- Sports
- Leisure
- Agriculture
- Masterbatch
- Pharmaceutical
- TPE/EVA
- Construction

ES-320P RUBBER PREFORMER

ES-320P精密预成型机

ES-40PR (REAR LOADED)

ES-40PR(后喂料)

ES-320P/ES-40PR TECHNICAL DATA

ES-320P/ES-40PR 技术参数 ▸

项目名称 / Item	单位 / Unit	ES-320P	ES-40PR
料筒容积/Batch Size	L	60	80
标准挤出压力Standard Extruding Pressure	psi	3000	3000
装料位置/Load position		前部/front	后部/Rear
料桶直径/Barrel Diameter	mm	250	250
最大生产能力kg/小时Maximum Output/Hour	kg	550	650
最大模头尺寸mm/Maximum Die Diameter	mm	300	190
总功率/Total Power	kw	23	23
油箱储量/Oil Reservoir	L	200	240
供气流量/Air Supply	mpa	0.6–1.0	0.6–1.0
供水流量（25℃）/Water Supply（25℃）	L/min	35	35
重量/Weight	kgs	4500	5500
外形尺寸 长*宽*高/Outline size L*W*H	mm	4900*1100*1750	5900*1100*1750

ES SOLE PRECISION PREFORMER MACHINE

ES鞋底精密预成型机

INDUSTRIES SERVED

使用行业

鞋底模具
Shoe soles moulds

鞋底模具
Shoe soles moulds

鞋模机头
SH Head

鞋模机头
SH Head

PRODUCT FEATURES

产品特征 ▶

ES鞋底精密预成型机是一种高效率、高精度鞋底胚料生产设备， 代替传统的冲压工序直接将胶料成型为鞋底形状，相比之下生产效率大大提高且操作更为简便，更省胶料和人工，胚料精度可达土1%，配合冷却输送使用效果最佳，它集抽真空、过滤、挤出、切割、称重、计数等多功能于一体。

抽真空系统: 在挤切胶料之前先行抽真空，排除机筒、机头内部的空气和胶料中夹杂的气体，从而提高下工序硫化制品的质量。

加热系统:采用水循环加热方式，温度由数字式温控器控制和显示，保证机头、料筒的温度恒定。

ES Rubber Sole Precision Preformer is a manufacturing facitity for rubber blank of efficient and high accuracy. The manufacturing process directly forms the rubber to the sole shape instead of the traditional pressing process, which greatly improve the production effciency and save the manterial and labor cost. Moreover the blank accuracy can achievet 1%. It will be better equipped with cooling conveyer. The precise Preformer combines functions such as vacuum, filtration, squeezing, cutting, weighting and counting.

Vacuum system:Before cutting and squeezing the rubber material, we should vacuum in advance to exclude the air in cylinder, head and inside the rubber material, there by improving the quality of the vulcanized products.

Heating system:using the water cycle heating ways. The temperature is controlled and displayed by a digital temperature control machine to ensure the stable temperature.

ADVANTAGES

产品优势 ▶

- 采用PLC控制和触摸屏操作界面。彩色显示屏引导你方便地进行数据输入，密码保护。
- 可储存1000种产品的工艺数据，随时调用。
- 变频电机控制切刀无极变速。
- 电子屏闭路反馈，控制胶胚重量。
- 可靠的安全性，机头关闭，切刀旋转，柱塞前进和后退均有互锁装置。
- 故障点图标及文字显示。

- Adopt PLC control and touch-screen. The colorful display screen leads you to input data conveniently. Include password protection.
- Able to save the data of 1000 products, which can be used at any time.
- Variable frequency motor controls the IVT of the cutter.
- Electronic scale give closed loop feedback to control the blank weight.
- Reliable safety, closed draw head and revolved cutter. There is interlocking device both for ram moving forward and moving back.
- Icon and words display in the fault point.

ES HIGH PRESSURE RUBBER PREFORMER

ES 系列高压型精密预成型机

ES-15PH/ES-20PH/ES-40PH TECHNICAL DATA

ES-15PH/ES-20PH/ES-40PH 技术参数 ▶

项目名称/Item	单位/Unit	ES-15PH	ES-20PH	ES-40PH
料筒容积/Batch Size	L	15	20	60
标准挤出压力Standard Extruding Pressure	psi	5000	5000	5000
装料位置/Load position		前部/front	前部/front	前部/front
料桶直径/Barrel Diameter	mm	150	200	250
最大生产能力kg/小时Maximum Output/Hour	kg	180	270	650
最大模头尺寸mm/Maximum Die Diameter	mm	100	127	190
总功率/Total Power	kw	16	19	30
油箱储量/Oil Reservoir	L	200	200	240
供气流量/Air Supply	mpa	0.6–1.0	0.6–1.0	0.6–1.0
供水流量(25℃)/aterSupply(25℃)	L/min	20	35L	35L
重量/Weight	kgs	3000	4000	5000
外形尺寸 长*宽*高/Outline size L*W*H	mm	3750*1100*1750	4000*1100*1750	5200*1100*1750

ES HIGH PRESSURE RUBBER PREFORMER

ES 系列高压型精密预成型机

ES高压预成型机特性

预成型机高压(H)5000PSI系列机器的开发是为了满足橡胶行业不断增长的加工高硬橡胶或者特殊橡胶的需求,而ES标准预成型机是无法加工此种橡胶的。

高压机器比标准210BAR(3000PSI)的机器产量高达6倍

当橡胶要求必须过滤以减少污染物或者移除里面的杂质时,此种机型尤为必要。尽管ES所有机器都能做到过滤杂质,但标准机器有时候会大大的减少产量。而H系列机器可以是橡胶挤出压力达到5500PS1,毫无疑问满足了厂家的生产需求。

产量更大

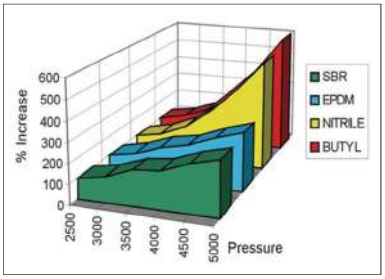
右边的图表显示了不同胶料产量的潜在增长率,产量的实际增长比率还需要在我们的机器上实验才能确定,并且模具尺寸及滤网的使用对此也有影响。

Feature of ES Preformer (High Pressure)

The H series (5500 PSI) of High Pressure Preformers have been developed to meet an increasing demand from the rubber industry for machines capable of processing tough or special materials at production rates that are not achievable with the standard range of ES Preformers.

Up to 6 times more output than a standard 210bar(3,000psi) machine.

This reguirement has become more important where screening or filtering of materials is essential to reduce or eliminate contamination and remove impurities within the material. Although screening or filtering of materials has always been possible with any ES machine, the effect of this was to reduce outputs to sometimes unacceptable levels. The H series, with its increased compound extrusion pressure up to 380 Bal (5.500psi) overcomes this restriction and allows production demands to be met without compromise.

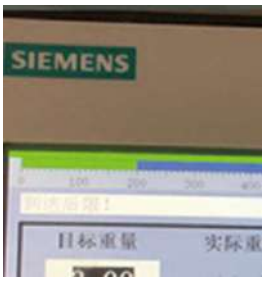


Higher Output

The chart indicates the potential increases for various materials,although actual rates for a specific product would need to be clearly defined through material testing on our demonstration machine and subject to die size and whether screening is applied or not.

OPTIONAL FUNCTIONS

选配功能说明



位移传感器
可以在触摸屏上很清楚地看到活塞杆移动的位置便于了解物料的结束时间

Position Sensor
By position sensor, the piston head position can be seen clearly from the touchscreen. People can understand when the material will finish.

伸缩性的输送带
设计了三档旋钮开关
输送带可以前中后三方位移动
便于区分重量校正前后的胶胚

Flexible conveyor belt
The flexible conveyor belt has three stops,former, middle, behind. It can differentiate the different stages of the blanks.

台达伺服电机系统
刀速0.5-800 转每分钟
可以切出更加精准的产品

Delta Servo motor
Cutter speed: 0.5-800 cuts/min
The blanks weight is more accurate

余料铲下装置
此设计方便将剩余的料头推下来
降低劳动强度 节省时间

Surplus shovel device
It can easily take down the balance material. Decrease the labor work and save the time

液压系统比例阀的设计
挤出压力更稳定 操作更简单

Hydraulic proportional valve system
The extruding pressure is more stable and the operation system is more simpler and advance

液压自动开关门
降低劳动强度 节约时间

Hydraulic automatic door opening and closing
Decrease the labor work and save the time

后喂料设计
喂料方式：后端直接开盖喂料，
无需打开前面机头门 节约时间
提高了生产效率

Rear loaded design
Loading methods: rear loaded, no need to open the machine door every time. It can save lots of time and improve productivity

双层输送带设计
很适合做长条状产品或者有胶料很软的客户产品不容易变型

Double conveyor belts design
It is designed so that some special shapes of blanks will not get distorted. Especially for long strips, or soft compounds.

RUBBER COOLING CONVEYOR

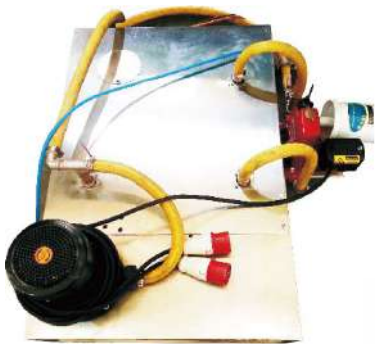
橡胶冷却输送机

BCC冷却输送机

——适合于所有的胶胚(包括鞋底冷却)

BCC Cooling Conveyor

——available for all kinds of blanks
(including the shoe sole)



PRODUCT FEATURES 产品特征 ▶

冷却输送机是为了完善ES系列预成型机而特别设计的，它与预成型同步操作，主要用来在生产热胶胚时对其进行冷却、分离、以及干燥。对FKM、NBR、CR、EPDM、造粒、轴承密封件、油封、O型圈及片状的胶料的效果更为突出。

Cooling conveyor is specially designed to refine series of ES Preformer. It works along with Preformer and is mainly used to cool, separate and dry the heat blank during the production.

ADVANTAGES 产品优势 ▶

- 冷却效果好,提高产品质量
- 为客户工厂节省占地空间
- 防止橡胶粘连
- 冷却的产品多样性
- Excellent cooling effect, Upgrade the product quality
- Save the space
- Avoid adhesion of materials
- Diversify the shape of products

GCCPRODUCT FEATURES
GCC产品特征 ▶

GCC冷却输送机是专为解决胶胚粘连、变形而设计的预成型机配套辅机，该机与胶料接触部位采用SUS304不锈钢材料，该机全身由PC亚克力板覆盖，避免胶胚受到尘土的污染。另外，全封闭的机身能促使风冷得到最大利用。

GCC cooling conveyor is designed to solve the rubber blanks adhesion, deformation. It is the ancillary equipment for Preformer. It is made in SUS304. This machine is covered by PC board, in case of pollution of rubber blanks by dust. In addition, the covered body can improve the fan cooling efficiency.

BCC TECHNICAL DATA　BCC / GCC 技术参数 ▶

项目名称 / Item	单位/Unit	BCC	GCC
入口高度/Entrance height	mm	320	320
输送长度/Conveying length	m	37	41
旋转槽层数/Rotating slot steps	steps	15	
行程宽度/Stroke width	mm	230	230
行程间距/Travel distance	mm	110	100
电机尺寸/The size of the motor	kw	2X0.75kw	2X0.75kw
震动速度/Vibration velocity	hz	30–60	30–60
空气冷却喷射/Air cooling injection		是/yes	是/yes
PC耐力板/PC Resistant Board		可选/Option	是/yes
外形尺寸 长*宽*高/Outline size L*W*H	mm	1000*2000*2650	1000*2000*2800

CHILLER TECHNICAL DATA
制冷柜技术参数 ▶

项目名称 / Item	单位 / Unit	
制冷量/Cooling power	kw/hr	28
风量/ Air Volumne	㎥/h	10000
压缩机功率/Compressor Power	kw	7.5
风机/Fan Power	kw	0.9
压缩机/Compressor		全封闭涡旋式/ All-sealed flexible Scroll
制冷剂/Coolant		R22
蒸发器/Evaporator		紫铜管套铝翅片式/ RVCES
冷凝器/Condenser		高效铜管套波纹型铝翅片/HECT
风机/Fan		低噪音离心式/Centrifugal with lower noise
节流方式/The throttling process		外平衡式热力膨胀阀/External equalizer style thermal expansion valve
电器控制/Electric control		触摸屏+PLC (中英文) /Touchscreen + PLC (Chinese+ English)
重量/W	kg	350
外形尺寸 长*宽*高/Outline size L*W*H	mm	1330*725*1330

ES-520 WATER COOLING CONVEYOR

ES-520水冷式冷却输送机

ES-520 TECHNICAL DATA 技术参数 ▶

项目名称 / Item	单位 / Unit	ES-520
斜面输送(全部采用不锈钢材料)/Sloping conveyer(adopt stainless steel)		
水箱尺寸(LxWxH) / Water tank dimension(LxWxH)	m	1.7x0.9x0.3
料坯浸水距离/Distanceof blank conveying (in water)	mm	1400
斜面输送宽度/Conveying width	mm	450
斜面输送速度/Conveying speed	m/min	5-10
斜面冷却风量/Volume of cooling wind	m3/h	4500
水平输送/Horizontal conveying		
水平输送宽度/Conveying width	mm	400
水平输送速度(可调)/Conveying speed (adjustable)	m/min	2~10
层次/Layer		3
水平冷却风A/Volume of cooling wind	m3/h	40000
总功率/Total power	kw	2.5
外形尺寸(LxWxH)/External dimension (LxWxH)	m	5.5x0.8x2
重量/Weight（kgs）	T	1.4

PRODUCT FEATURES 产品特征 ▶

水冷式冷却输送机，是通过冷却水或冷却溶液使胶胚降温,再经过风冷,使胶胚变得干燥,稳定。此机专为解决胶胚粘连,变形而设计的预成型机配套辅机。

- 机身与胶料接触部位均采用不锈钢材料。
- 适用于水冷或使用液体隔离剂的产品,以及较大尺寸的产品。
- 水槽部分使用杠杆原理,方便对水箱提升分离,以便实现更换胶料时对水箱的快速清理。
- 全程调节水平不锈钢网带调控运行速度,配合预成型机的所有切割速度。

The water cooling conveyor, after cooling down with water or other cooling solutions,then withforcible cooling wind, makes rubber blanks become dry and stable. It is an auxiliary machine ofrubber precision preformer machine to avoid stickiness and deformation of the rubber blanks.

- The machine body which directly conveys rubber blanks is made of stainless steel.
- Suitable for water cooling or using the liquid release agent, or larger sizes of products.
- The sink part, with the lever principle, easily separates and lifts the tank, in order to cleanthe tank quickly when replacing compound.
- The running speed can be adjusted by the stainless steel conveyor chain duringthe whole process, to meet the cutting speed of the preformer machine.

因为专注 所以专业

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