智能管道装备系统解决商

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小口径聚烯烃高速复合管道挤出生产线

High Speed Plastic Pipe Extrusion Line

Zhejiang Shuanglin Environment Co.,Ltd.
Zhejiang Shuanglin Technology Co.,Ltd.

浙江双林环境股份有限公司
浙江双林机电科技有限公司
www.shuanglingroup.com

Mission 公司使命
做全球值得拥有的管道塑机！
Make The Worthy Owning Plastic Pipe Machine

Value 核心价值
创新为先，品质为重，以人为本，诚信为根！
Honesty consists of Specialized Innovation and Quality.

Corporate culture 企业文化
让留在公司的每一名员工成为最好的自己！
Make every employee who stays at the company to be the best of himself.

WELCOME TO SHUANGLIN COMPANY

Shuanglin company business covers plastic pipe and composite pipe machinery, plastic pipe, material trading, and new material technology innovation.

The main business of Shuanglin company specialized on plastic and composite pipe machinery . Since 1978, Shuanglin have been seeking new solutions for the plastic extrusion, extrusion moulding and multi layer pipe forming & welding. All the innovations are based on safer application, faster installation, easier production and less energy consumption. Thanks to the 400 employees, who makes Shuanglin pipe machinery reache 7500 sets all over the world. University and Chemical Institute cooperation helps Shuanglin pipe extrusion solutions fully certified and approved.

We follow the ISO9000 quality management system, and CE design standard, making the machinery high reliable quality and fast remote service. Meanwhile, Shuanglin service engineer goes all over the world to spread the know-how and skills, to help the pipe factory save energy and waste, improve pipe quality and efficiency.

浙江双林塑料机械有限公司是专业从事大直径塑料管道生产线、复合管道生产线等各种塑料机械成套装备研发、制造的国家级高新技术企业。标准厂房面积75000多平方米，年管道设备生产能力在1000套左右，独具优势的产品有铝塑复合管生产线、16-1600mmPE实壁管生产线、300-4000mm缠绕增强管生产线、节能高速PE-RT、PB管生产线、一模四出PVC管生产线。

现有职工600多人，其中，中、高级工程师及专业技术人员260多名，2008年成立杭州市企业技术中心。公司自成立以来不断地进行技术创新和产业升级，加入了余杭区“双百工程”、开展了与浙江大学机械研究所长期合作。截止到2012年3月，获得国家专利80余项，并承担了多项国家火炬计划项目。2008年12月，公司评定为国家高新技术企业，近几年获得多项国家创新基金；双林公司现在为国家重点支持领域的高新技术企业、中国驰名商标；2010年12月，双林产品评为“杭州名牌产品”；公司现已通过ISO9000质量体系、GB/T28001:2001职业健康安全体系、ISO14001:2004环境管理体系、欧盟CE等各项认证。

2009年公司在浙江省禹越工业区成立双林工业园，总投资2亿元，专注于塑料机械成套装备的研发、制造、培训。经过多年的潜心研究，公司在排水给水成套装备取得重大突破，其中大直径聚乙烯缠绕增强管生产线填补了国内空白，并已获得国家发明专利。

双木为林，聚木成森；协同共享，和衷共济。在全体员工的共同协作下，双林将努力打造成中国装备制造业的标杆企业！

双林愿景 —— 双木为林、聚木成森，努力将双林打造成中国装备制造业的标杆企业，为人类创造节能环保的品质生活。

双林使命 —— 用专业立身的理念为客户创造价值，以敢超敢为的精神为客户提供安全、高效、环保的生产设备。

双林价值观 —— 对内，以人为本；对外，诚信立业。

双林精神 —— 双木为林，聚木成森，协同共享，和衷共济。

On line One Step crosslinking PEX-a pipe production line
一步法红外交联PE-Xa管材生产线

Main technical charateristics
主要技术特点

The on line one step crosslinking PEX-a pipe production line manufactures the PEX-a pipe using the Organic Peroxide method by infrared oven heating, get the highest quality PEX pipes.

Add co-extruders and moulds, the SLPE-Xa series pipe extrusion line also manufacture PE-Xa pipes with EVOH oxygen barrier (3 or 5 layers) by adding EOVH that prevents the oxygen diffusion, in the condition .

Based on the 30 years experience of pipe machinery manufacturing, Shuanglin improves the PE-Xa processing devices to make the operation easier and less defective pipes.
The pipe extrusion line consists of high precision twin-screw extruder, multi-material gravimetric system, infrared ray heating and on line inspection system.
PE-Xa pipe is the most reliable heating pipe and plumbing pipe compare to other plastic pipes, easier installation, reliable connection and long life time, more and more welcomed by the high level market.

双林依托多年的塑料管道设备制造研发能力，参考学习国外同行的先进技术，消化吸收国外同类设备的基础上，自主研发拥有自主知识产权的一步法红外交联PE-Xa管生产线及生产工艺和专用原料，生产线综合性能达到国际领先，国内首创。

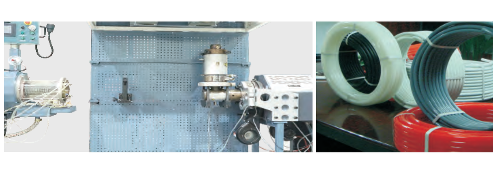
该生产线采用PE-Xa管专用双螺杆挤出机，PE-Xa多组分精确计量混配装置，结合PE-Xa管专用挤出模具及红外交联装置和智能化控制检测系统，确保管材高速稳定生产。该机只需增加部分设备单元，即可完成单层PE-Xa管、三层PE-Xa管和五层PE-Xa管材的生产。

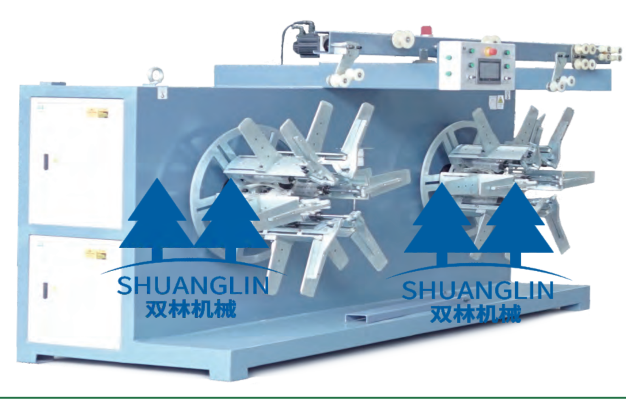
由于PE-Xa管的物理性能优越，连接可靠、安装操作简单，使用寿命长，非常适合用作高性能的辐射供暖供冷专用管道，在欧美发达国家得到广泛应用。

随着国产化一步法红外交联PE-Xa管生产线的推出，势必会加快高品质PE-Xa管在中国高端暖通管材市场的普及和应用。

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	最大挤出量 (kg/h) Max.Extrusion Capacity	生产线长度 (m) Total Length
SLPE-Xa32	Φ16-Φ32	20	130	45
SLPE-Xa63	Φ32-Φ63	10	200	40





Monosil High Speed PEX-b Pipe Extrusion Line
高速一步法交联聚乙烯(PE-Xb)管生产线

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	最大挤出量 (kg/h) Max.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度 (m) Total Length
PE-Xb32G	Φ16 ~ Φ32	40	300	160	60

Main technical charateristics
主要技术特点

Monosil PE-Xb high speed extrusion line innovated on the base of cooperation with Germany updated tech.

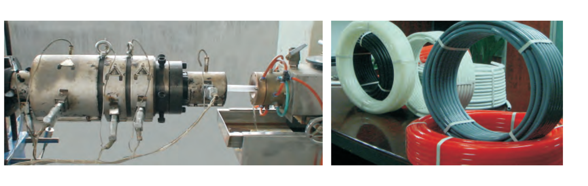
This machine adapts gravimeter dosing system, water temperature control system, makes sure the high quality and precision dosing on different kind of materials and master batches, especially saves Silone consumption.

It adopts PLC control system and HMI for whole extrusion line, synchronization function realized. It helps the group machine production management and quality control.

高速一步法PE-Xb管材生产线是本公司结合中外生产实际，自主开发研制的高速管材生产线。

该生产线结构新颖合理，外形美观，采用了自动称重配比供料装置、水温水位自动控制技术。

生产线采用PLC集成控制系统，人机对话界面，具有单机调整，全线联动，故障报警，自动储存记录工艺参数，操作简便，生产稳定可靠。



Five Layers Plastic EVOH Oxygen Barrier Pipe Co-extrusion Line
防渗氧(EVOH)聚烯烃复合管生产线

Main technical charateristics
主要技术特点

The EVOH layer compound into the middle of the two layer polymer, shows a high oxygen barrier features, no pollution to water, safe and easy for transportation and installation.
It adapts high precision extrusion tech equips with professional screw, specialized extrusion mould, high precision extrusion pump, stable vacuum calibration system, which guarantees the multi-layers even distribution. This line also produces the single layer poly pipe.

Five layer Poly-EVOH pipe is better than the three layer Poly-EVOH pipe on easier installation, no need to peel the outer layer EVOH, protecting the EVOH layer from damage.

The extrusion lines adapts PLC closed-loom control systems, HMI operation panel, intelligent distribution solutions, supports synchronization and independent control, multi alarm system of malfunctions, stable and reliable.

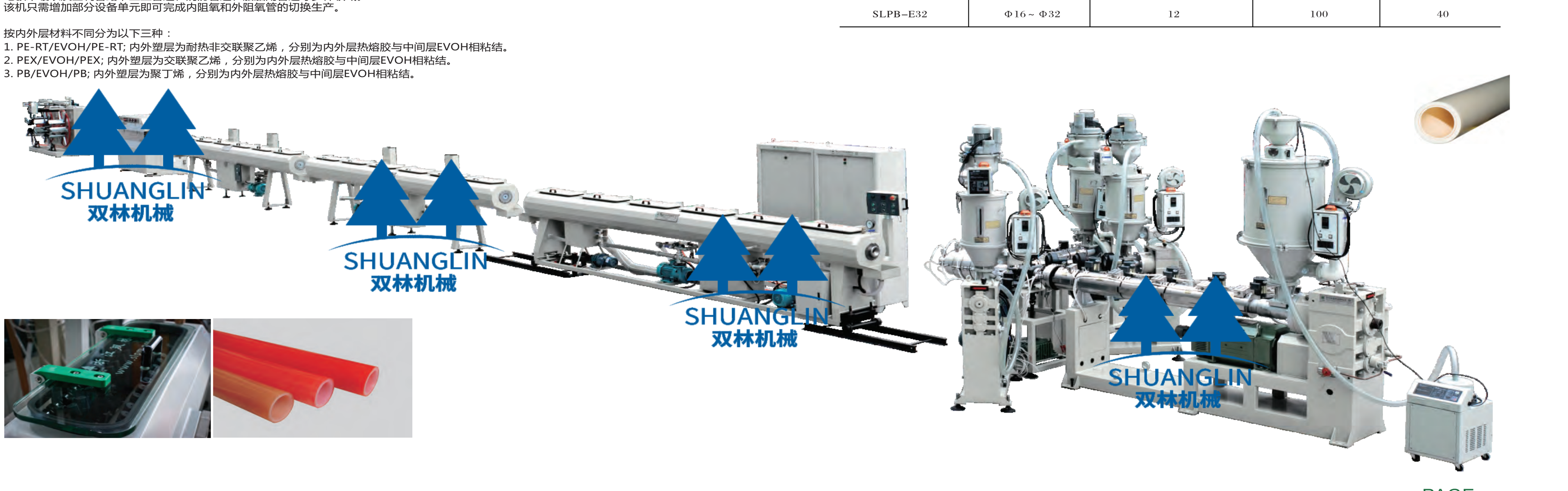
阻氧管解决了普通管材不能阻止氧气渗透，导致管道系统寿命缩短、安全性下降等问题，管材采用多层共挤的生产工艺，内、外层为塑料层（PE-RT、PEX、PB等），中间层为EVOH（乙烯/乙烯醇共聚物）阻氧层。
通过利用EVOH的阻隔特点来实现管材的阻氧性能。阻氧管以优异的性能广泛应用于散热器连接、冷热水、地板采暖以及空调管路，工业管道、消防管道、船舶用管道等多种领域。
该机只需增加部分设备单元即可完成内阻氧和外阻氧管的切换生产。

按内外层材料不同分为以下三种：
1. PE-RT/EVOH/PE-RT; 内外塑层为耐热非交联聚乙烯，分别为内外层热熔胶与中间层EVOH相粘结。
2. PEX/EVOH/PEX; 内外塑层为交联聚乙烯，分别为内外层热熔胶与中间层EVOH相粘结。
3. PB/EVOH/PB; 内外塑层为聚丁烯，分别为内外层热熔胶与中间层EVOH相粘结。

PB resin is a macromolecule polymer built up with atoms of carbon and hydrogen. It is easily to be processed, recycled and lower energy consumption during the whole life cycle It is really a kind of green and environment friendly material. From the structure side, PB is a linear, isotactic and semi-crystallization thermoplastic material. PB material can be re-melted when heated and has no toxic material emission during processing. It behaviors' a good high temperature resistance, long life time, stable, flexible, healthy, and low heat conductivity and less condensation at -30 ℃~110℃.

Main technical parameters
主要技术参数

型号 Type	管材规格（mm）Pipe Size	最高线速度（m/min）Max.Speed	总装机功率（kw）Total Power	生产线长度（m）Total Length
SLPEX-E32	Φ16 ~ Φ32	12	100	40
SLPERT-E32	Φ16 ~ Φ32	12	100	40
SLPB-E32	Φ16 ~ Φ32	12	100	40



High Speed PE-RT Pipe Extrusion Line
高速冷热水耐热聚乙烯(PE-RT)管生产线

Main technical charateristics
主要技术特点

This machine takes high efficiency PE-RT extrusion screw, energy saving vacuum calibration and cooling tank, disk style calibrators, servo-controlled high speed winding machine with linear reel, all of which performers a good function at 45m/min speed.

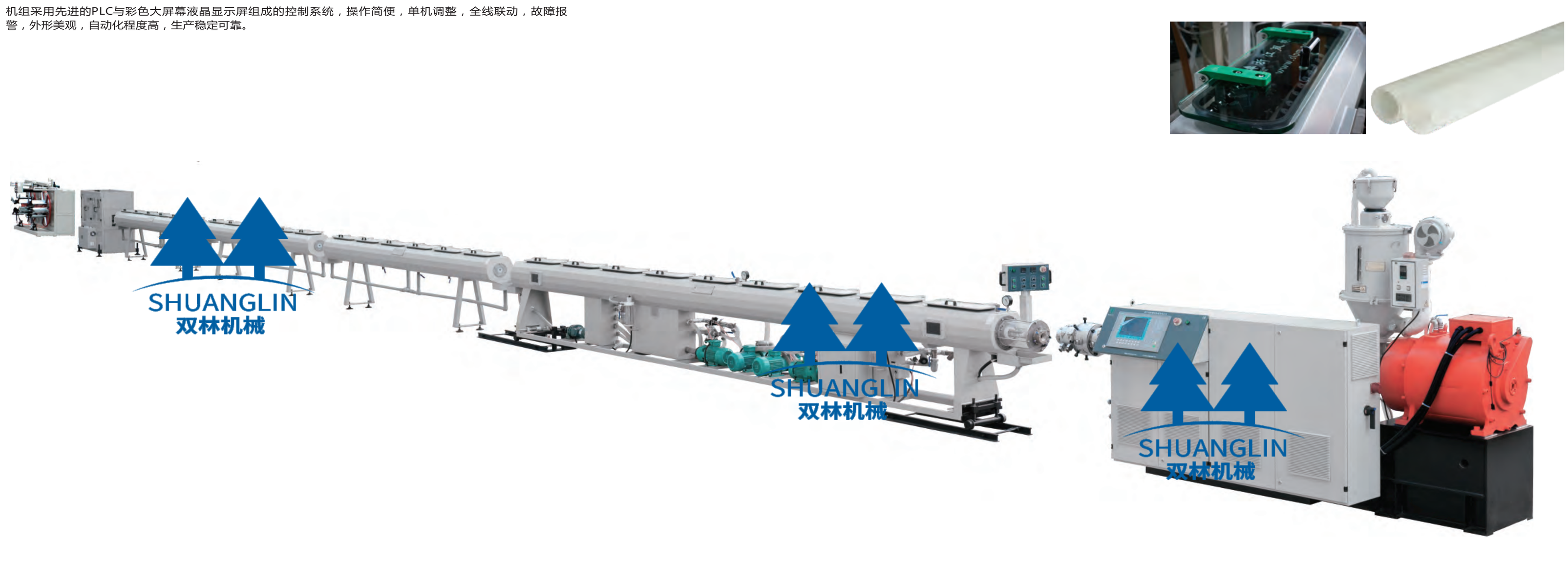
It adopts PLC control system and HMI for whole extrusion line, synchronization function realized. It helps the group machine production management and quality control.

该生产线主机采用高效精密PE-RT专用挤出机，节能型结构真空冷却箱，组合碟片式高速定径装置，配备伺服控制高速盘管机，生产速度高达45m/min。

机组采用先进的PLC与彩色大屏幕液晶显示屏组成的控制系统，操作简便，单机调整，全线联动，故障报警，外形美观，自动化程度高，生产稳定可靠。

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	最大挤出量 (kg/h) Max.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度 (m) Total Length
SLPE-RT32G	Φ16 ~ Φ32	45	250	130	55



High Speed PP-R Pipe Extrusion Line
高速冷热水聚丙烯(PP-R)管生产线

Main technical charateristics
主要技术特点

Shuanglin PP-R pipe extrusion line success on updated design, high speed and stable performance.

The machine compacts PE-RT or PE-Xb pipe extrusion only if change some parts.

It adopts PLC control system and HMI for whole extrusion line, synchronization function realized. It helps the group machine production management and quality control.

The Gearless High Efficiency Extruder is suggested to equip on this extrusion line, which performs many features such as high torque, energy saving, noiseless, stable, maintainless, closed loop control,etc.

我公司依据多年塑料机械开发设计生产经验，在引进国外先进技术并消化、吸收的基础上，研制出高速节能PP-R管材生产线。

该生产线经适当变换部分单元，即可实现PE-RT耐热聚乙烯管材和PE-Xb二步法交联聚乙烯管的生产。
可选用无齿轮高效精密挤出机，具有高扭矩、低噪音、高效率、低能耗、免维护、运转平稳、挤出稳定等特点。

生产线采用PLC集成控制系统，人机对话界面，具有单机调整，全线联动，故障报警，自动储存记录工艺参数，操作简便，生产稳定可靠。

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	最大挤出量 (kg/h) Max.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度 (m) Total Length
SLPPR-32G	Φ16 ~ Φ32	20	220	160	50
SLPPR-63	Φ16 ~ Φ63	15	120	100	35
SLPPR-110	Φ40 ~ Φ110	5	180	125	37
SLPPR-160	Φ75 ~ Φ160	5	280	180	40

PP-R 2 Cavity Double Layers Pipe Extrusion Line
冷热水聚丙烯双层双出(PP-R)管生产线

Main technical charateristics
主要技术特点

Shuanglin PP-R 2 cavity double layers pipe extrusion line on updated design, high speed and stable performance.

It adopts high efficient and energy saving single screw extruder equips with special mould, the output improve 30% and power save 20% than single pipe, reduce the manpower in the same time.

According to needs it can change die and core mould to produce two different size or pressure pipes simultaneously.

The machine compacts PE-RT or PE pipe extrusion only if change some parts.

It adopts advanced PLC and color LCD touch screen control system for whole extrusion line, single machine adjustment，synchronization function realized, failure warning，high degree automatization and stable and reliable production.

我公司依据多年塑料机械开发设计生产经验，研制出双林“高速一出二双层PP-R管材生产线”是“一出二PP-R管材挤出生产线”的升级产品。

该生产线采用高效节能单螺杆挤出机配合专用模具，生产效率比单管生产线提高一倍以上，能耗比降低20%以上，有效的减少设备数量投入，节省厂房地使用面积，同时有效的减少了人力成本。

可根据生产需要更换口模、芯模，同时生产两根不同口径或不同压力等级的管材。

生产线经适当变换部分单元，即可实现PP-R双层或单层管材挤出或PE-RT耐热聚乙烯管材和PE管材的生产。

该机采用PLC控制与彩色大屏幕液晶显示屏组成的控制系统，操作简便，全线联动，单机调整，故障自动报警，整线外形美观，生产稳定可靠。

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	最大挤出量 (kg/h) Max.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度 (m) Total Length
SLPPR-2-32	Φ20 ~ Φ32	18*2	240	150	38
SLPPR-2-63	Φ20 ~ Φ63	18*2	240	160	38
SLPE-RT-2-32	Φ20 ~ Φ32	20*2	280	150	38

Two Layer PP-R Pipe Four Cavity Extrusion Line
冷热水聚丙烯双层四出(PP-R)管生产线

Main technical charateristics
主要技术特点

Based on more than 30 years of pipe extrusion machinery manufacturing experience, Shuanglin company has developed "high speed four cavity two layer PP-R pipe production line as an upgraded line of two cavity one.

The production line uses high efficiency and energy saving single screw extruder with special die, the production efficiency is increased by more than 50% compared with the 2 cavity line, and the energy consumption ratio is reduced by more than 20%. It effectively reduces machinery coverage ,investment amount and labor cost.

The die can be replaced according to production requirements, as well as producing four different sizes or wall thickness pipes at the same time.

The control system composed of PLC control and large colorful LCD screen, which is easy to operate, both full line synchronization and single unit machine adjustment functions, automatic fault alarm, beautiful appearance, stable and reliable production.

我公司依据多年塑料机械开发设计生产经验，研制出双林“高速一出四双层PP-R管材生产线”是“一出二PP-R管材挤出生产线”的升级产品。

该生产线采用高效节能单螺杆挤出机配合专用模具，生产效率比双管生产线提高50%以上，能耗比降低20%以上，有效的减少设备数量投入，节省厂房地使用面积，同时有效的减少了人力成本。

可根据生产需要更换口模、芯模，同时生产四根不同口径或不同压力等级的管材。

该机采用PLC控制与彩色大屏幕液晶显示屏组成的控制系统，操作简便，全线联动，单机调整，故障自动报警，整线外形美观，生产稳定可靠。

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	最大挤出量 (kg/h) Max.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度 (m) Total Length
SLPPR-4-32	Φ20 ~ Φ32	18*4	540	300	38

One Step PE Foam Insulation Composite Pipe Production Line
聚乙烯在线发泡保温管生产线

Main technical charateristics
主要技术特点

One step PE Foam Insulation Pipe Production Line takes combines the core pipe extrusion, foam pipe on line coating and skin layer protection pipe extrusion on one machine to produce the insulation pipe continuously.
It is ideal pipe for cool &hot water, gas, air conditioner, etc.

The foam pipe takes Polyethylene based inert material, highly resistant to chemicals, environment friendly, free of chemical blowing agents, 100% recyclable, flexible low weight , easy to slip and install, low thermal conductivity, compatible with all sealing materials, fine round closed-cell cellular structure assures, negligent absorption and water permanbill.

The PE Foam Insulation Pipe Production Line produces the core PE-Xb/PE-RT/PAP/PP-R pipe and coating the PE Foam pipe and skin layer one step.

High efficiency extruder, specialized screw and screw barrel, two layers co-extrusion die head, foam agents is injected by high pressure high precision ram pump then physical foaming. Equips with on line air cooling fan, and pipe haul-off cutter, pipe ends cutting smooth and dust free.

On line core pipe production and foam pipe coating, a great improvement on the traditional repeated production and manually insert.

High production efficiency, tight core pipe coating, foam layer pipe wall thickness adjustable on line.
It adopts international top brand PLC control system and modularizing control solution, high compatibility and control precision with high reliability. Optional for local and remote control, flexible production functions, reliable production management.

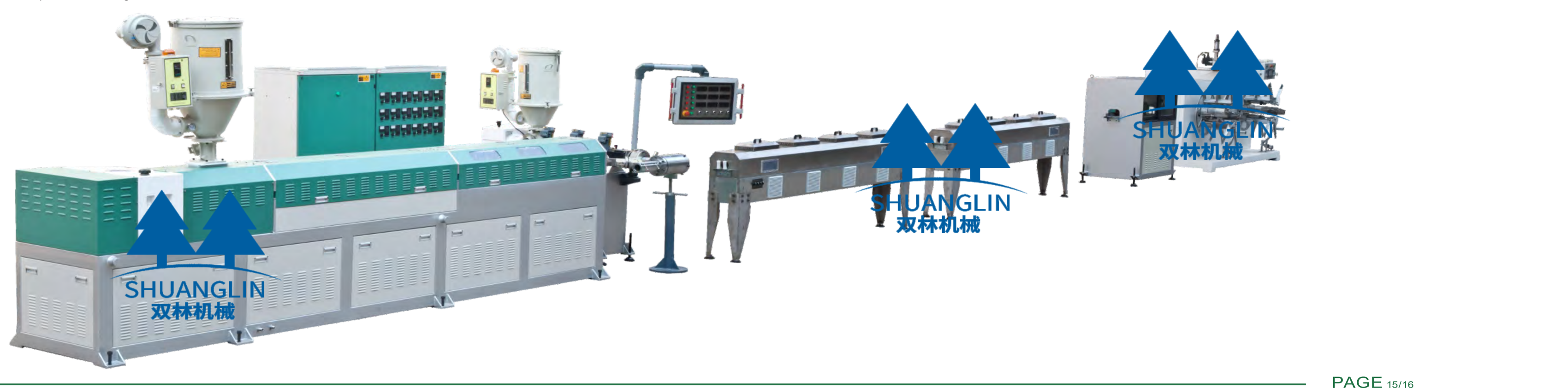
生产线由双林研发团队经过二年的开发，成功研制出PE在线共挤发泡成型工艺生产的发泡保温管，并且申请了多项专利。该产品生产的管材具有热传导低、质量轻、弹性好、耐腐蚀、零渗透、无污染、密封性好、施工易剥离、内壁包覆性能好、保温性能高、易收卷、无凝水等特点，是一种新型发泡管材的专用设备，主要应用于家装冷热水管，抗晒保温一体管，天然气管，酒店、学校、医院、工厂、空气能等工程专用保温管。

该设备采用新型高效发泡专用螺杆，两层共挤模具，通过高压高精度柱塞泵注入发泡剂后经物理发泡成型工艺。配备在线风箱冷却和管材牵引切割一体机，使制品切割平整、无毛刺。

设备控制系统采用智能分布式控制方案，可单机调整，全线同步联动，故障自动报警，自动化程度高，生产稳定可靠。

设备采用塑料管在线发泡涂覆成型工艺，打破以往先生产出发泡管材，然后通过人工离线二次套管生产制作工艺，大大提高生产效率和管材于发泡层的结合度。

该发泡设备生产效率高，内管包覆性能好，可根据使用需要调整发泡层厚度。

Main technical parameters
主要技术参数

型号 Type	管材规格 (mm) Pipe Size	最高线速度 (m/min) Max.Speed	总装机功率 (kw) Total Power	生产线长度 (m) Total Length
SLBWEPE-32	Φ16 ~ Φ32	8	65	25
SLBWEPE-63	Φ40 ~ Φ63	5	85	30