

# 管材挤出生产线

## PIPE EXTRUSION LINE

www.bestextrusion.com



**广东巴斯特科技股份有限公司**  
GUANGDONG BAST EXTRUTECH CO., LTD

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2023.04

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If any change of this catalogue will not inform in advance, takes the object as standard!



微信公众号

## 公司简介 Company Profile

### 拼搏 学习 创新 梦想



广东巴斯特科技股份有限公司，成立于2008年，集技术研发、生产装配、销售服务为一体，核心团队均曾服务于行业内国际知名企业。公司产品定位高端，积极引进国外先进技术，制造最符合国内外市场需求的高端塑料机械设备！

#### 巴斯特核心价值观

我们的态度：不断进行自我革新，积极，主动，热情！

我们的管理：不断改进公司的一切作为：创意，品质与顾客满意度！

我们的愿景：推动行业进步，成为世界的巴斯特！

我们的文化：拼搏、学习、创新、梦想，成就最好的自己！

GUANGDONG BAST EXTRUTECH CO., LTD was established in 2008, with integrating technology R&D, production assembly, sales and service. Our core team has served the famous international enterprise in the industry. Our equipment's positioning is high-end, absorbing foreign advanced technology, and manufacturing the most suitable plastic extrusion equipment to meet the needs of domestic and international markets.

#### Core values of BAST EXTRUTECH

Our attitude: Continuous self-innovation, active, initiative, enthusiastic!

Our management: Continuously improve everything our company does: creativity, quality and customer satisfaction!

Our vision: To promote the progress of the industry and become the BAST of the world!

Our culture: Struggle, learn, innovate, dream, and achieve the best of ourselves!

## 我司现提供以下产品及服务

1. 聚烯烃实壁管材生产线，管线规格4-1600mm；
  2. HDPE/PPR/PERT高速挤出生产线，最高速度100m/min；
  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. 重袋FFS/冷拉伸套管膜/热收缩膜等吹膜生产线；
  6. 流延CPP/CPE/高阻隔膜（PA、EVOH）生产线&挤出涂覆（淋膜）生产线；
- 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. PO solid wall pipe production line, pipe size 4-1600mm;
  2. HDPE/PPR/PERT pipe high-speed production line, max. speed 100m/min;
  3. Multi-layer pipe production line;
  4. PVC profile and pipe production line;
  5. Heavy duty FFS / stretch hood film / shrink collation film blowing production line;
  6. CPP / CPE / High barrier (PA, EVOH) production line & coating (laminating) production line.
- 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:

- ◆ 采用螺旋喂料机筒与分离型螺杆设计相结合的技术，获得高塑化率的同时保证制品良好的熔体均匀度。
- ◆ 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和更长的使用寿命。
- ◆ 可选配奥地利B&R公司或者德国西门子的触摸屏、数据存储等高级功能的操作系统，以便观察、操作、维护保养
- ◆ 配备优质齿轮箱，保证长期高效运行，其稳定性、噪音及温升完全达到进口齿轮箱水平。
- ◆ 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。
- ◆ 所有通讯都采用以太网连接，满足工业4.0数据采集需求，后续可拓展可视化生产和远程监控
- ◆ 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 PLC operating system with touch screen for option, data storage and other advanced function features.
- ◆ Equipped with high quality gearbox, its stability, noise and temperature levels fully meet the imported gearbox performance even at high throughput rates.
- ◆ The communication signal is digital signal, which has strong anti-interference ability and ensure accurate control and feedback.
- ◆ The temperature control range is ±1 degree.
- ◆ Ethernet connection is adopted for all communications to meet the data acquisition requirements of Industry 4.0, visual production and remote monitoring can be expanded in the future.



◆ 单螺杆挤出机: CE60-36

### 技术参数/Technical Data

型号/Model	CE45-36	CE60-36	CE75-36	CE90-30	CE90-36	CE120-30	CE120-36	CE150-36
螺杆直径(mm) Screw diameter	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	150,L/D=36
电机功率(kw) Motor power	AC,45	AC,90	AC,185	AC,200	AC,250	AC,315	AC,355	AC,510
最高产量(kg/h) Max. output	160	320	680	800	900	1100	1250	1500

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

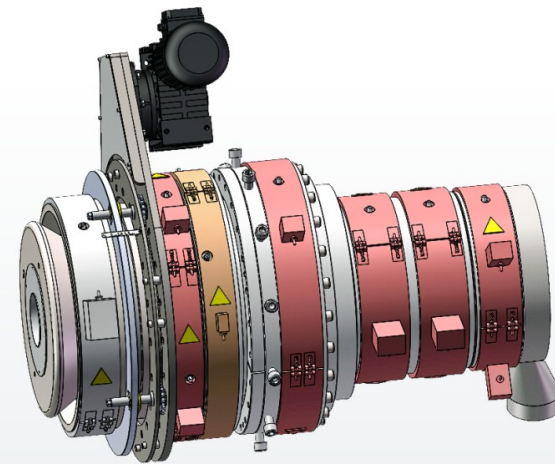
## 挤出模头 EXTRUSION DIE HEAD

### 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，冷却长度缩短30%、抑制熔垂，高效节能而且降低设备采购成本
- ◆ Modular designed spiral die, providing a wide range of options (such as color stripe, scratch resistance protective layer, etc.)
- ◆ Double spiral design with lower pressure.
- ◆ Excellent distribution of the raw material, good dispersion.
- ◆ Short flow channel, no dead corners, fast color changing.
- ◆ Equipped with Inner Pipe Cooling System (IPC), the cooling length will reduce 30%, suppression of sagging, energy saving, lower purchase cost.



螺旋挤出模具: M800S



变径模具: M630

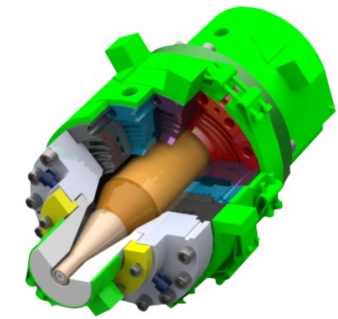
### 技术参数/Technical Data

型号/Model	M32S	M63S	M160S	M250S	M315S	M450S	M630S	M800S	M1200S	M1600S
管材直径 (mm) Pipe diameter	12-32	16-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200	710-1600
最高通过量(kg/h) Max. throughput	400	400	600	800	900	900	1100	1200	1800	2000

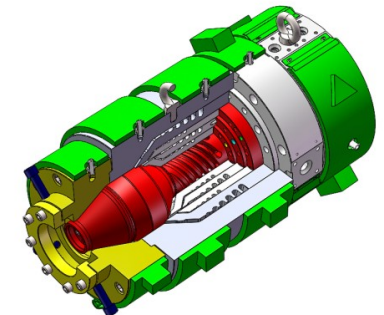
## 多层模头 MULTI-LAYER DIE HEAD

### 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
- ◆ 分层精度高，制品每层厚度均匀，胶层厚度0.03-0.05mm，阻氧层厚度0.05-0.08mm
- ◆ According to the specific demand, we can offer wide range co-extrusion multi layer die heads.
- ◆ High accuracy of layering ratio, uniform thickness of each layer of the die head, adhesive layer thickness is 0.03-0.05mm, and oxygen barrier layer thickness is 0.05-0.08mm.



平面螺旋 Plane spiral



叠加螺旋 Superposition spiral

## 定径套 CALIBRATING SLEEVE

### 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.



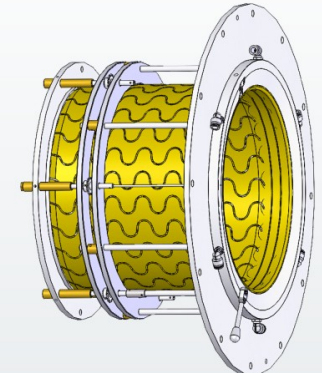
VII (专利产品)  
(Patented Product)



II



VKS



可调定径套  
VARIABLE DIAMETER  
CALIBRATING SLEEVE

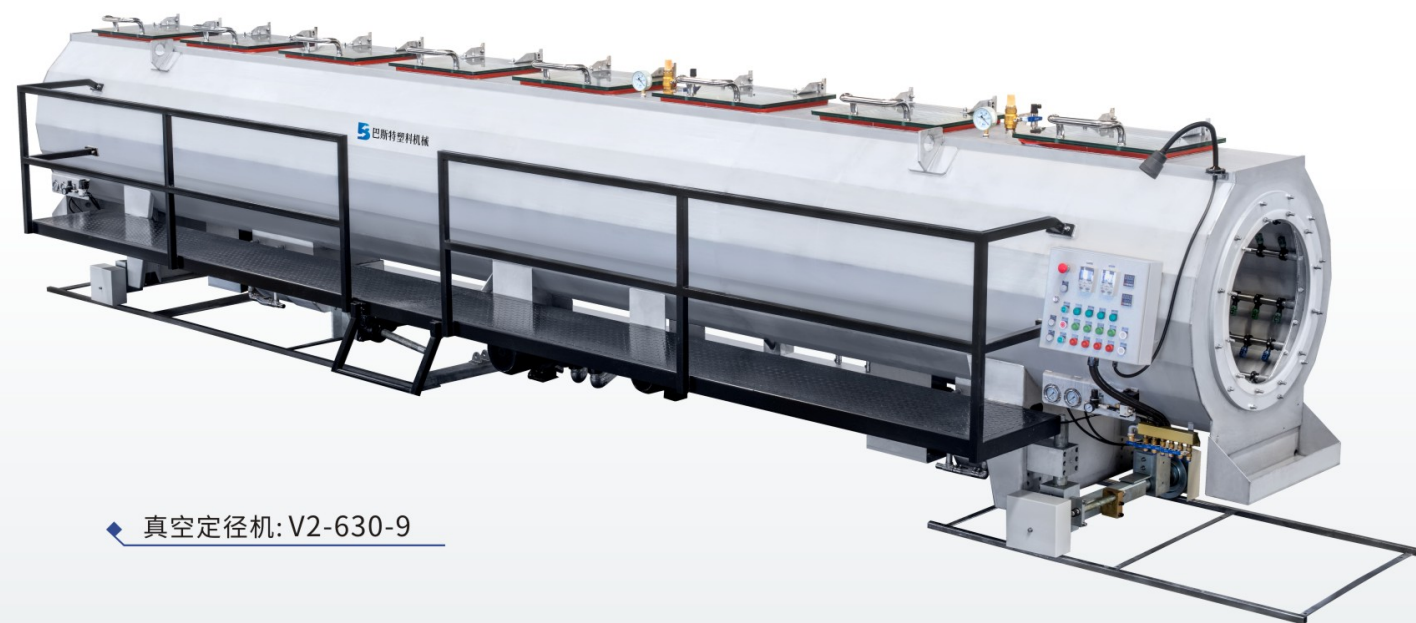
### 技术参数/Technical Data

型号/Model	VII	II	VKS	可调定径套
材料 Material	PPR,PERT,HDPE	PPR	HDPE	HDPE
管材直径(mm) Pipe diameter	16-32	32-110	40-1600	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 Used in cooperation with forced cooling ring of vacuum tank	干式导入和喷淋冷却 Dry inlet and spray cooling

## 真空定径机 VACUUM TANK

### 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，节约能耗
- ◆ 特殊密封胶条，快速起真空
- ◆ 钢化玻璃盖板
- ◆ The new layout of nozzle guarantees the pipe ovality even at the high output rate.
- ◆ Tank made of stainless steel 304 with long service life.
- ◆ Patented water level control device.
- ◆ Providing single or double chambers according to customer's need.
- ◆ Design for concentrated water supply and drainage.
- ◆ The vacuum tank uses frequency control with energy conservation.
- ◆ Special sealing stripe, for quick vacuum.
- ◆ Tempered glass cover plate.



真空定径机: V2-630-9

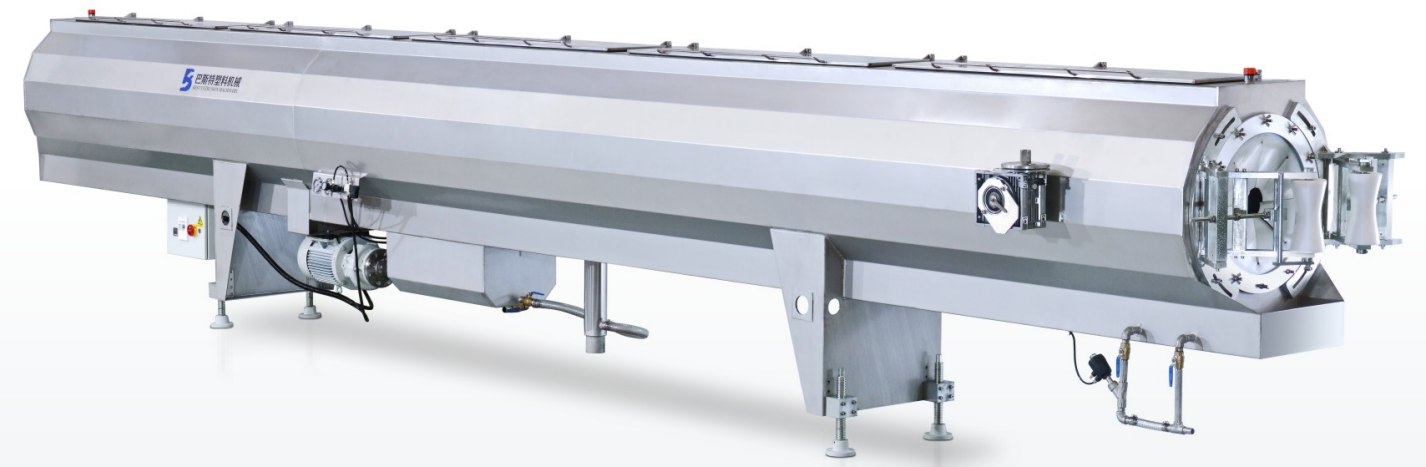
### 技术参数/Technical Data

型号/Model	V32-9	V63-9	V2-160-9	V2-250-9	V2-315-9	V2-450-9	V2-630-9	V2-800-9	V2-1200-12	V2-1600-12
管材直径(mm) Pipe diameter	12-32	12-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200	710-1600
长度(mm) Length	9000	9000	9000	9000	9000	9000	9000	9000	12000	12000

## 喷淋冷却箱 SPRAY COOLING TANK

### 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
- ◆ 全系列可采用集中给水和排水
- ◆ Tank made of stainless steel 304 with long service life.
- ◆ Optimized design for the atomizing nozzle, it can guarantee the cooling effect.
- ◆ Pipe supporting can be adjusted for different pipe diameters with self-locking function.
- ◆ The whole series adopt centralized water supply and drainage.



喷淋冷却箱: B315-9

### 技术参数/Technical Data

型号/Model	B63-18	B160-9	B250-9	B315-9	B450-9	B630-9	B800-9	B1200-6	B1600-6
管材直径(mm) Pipe diameter	16-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200	710-1600
长度(mm) Length	18000	9000	9000	9000	9000	9000	9000	6000	6000

## 牵引机 HAUL OFF

### 特点/Features:

- ◆ 超长的接触长度，在管材和皮带/胶块之间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；
- ◆ 每一条履带由单独的异步电机驱动，通过数字控制器保证各履带速度的精确同步；
- ◆ 三履带及以上牵引机标配进口伦茨电机，皮带牵引机标配德电机；
- ◆ 采用进口编码器，速度真实稳定反馈；
- ◆ 超大彩色触摸屏，报警状态显示和报警灯提示，便于维护

- ◆ Ultra long contact length ensures high traction even with low friction coefficient between pipe and belt/rubber blocks.
- ◆ The down caterpillars can be set mechanically/electrically to the pipe position, and the upper caterpillars/rubber blocks are pressed onto the pipe pneumatically.
- ◆ Each caterpillar is driven by a separate induction motor. Achieving synchronization control through the digital controller, can ensure that speed of all caterpillars is precisely synchronized.
- ◆ The haul-off with three caterpillars and above is equipped with the imported LENZE motor. The belt haul-off is equipped with NORD motor.
- ◆ The imported encoder will guarantee a real and stable speed feedback.
- ◆ Large color touch screen, alarm status display and alarm light prompt for easy maintenance.



◆ 皮带牵引机: H32



◆ 六履带牵引机: H800-6

### 技术参数/Technical Data

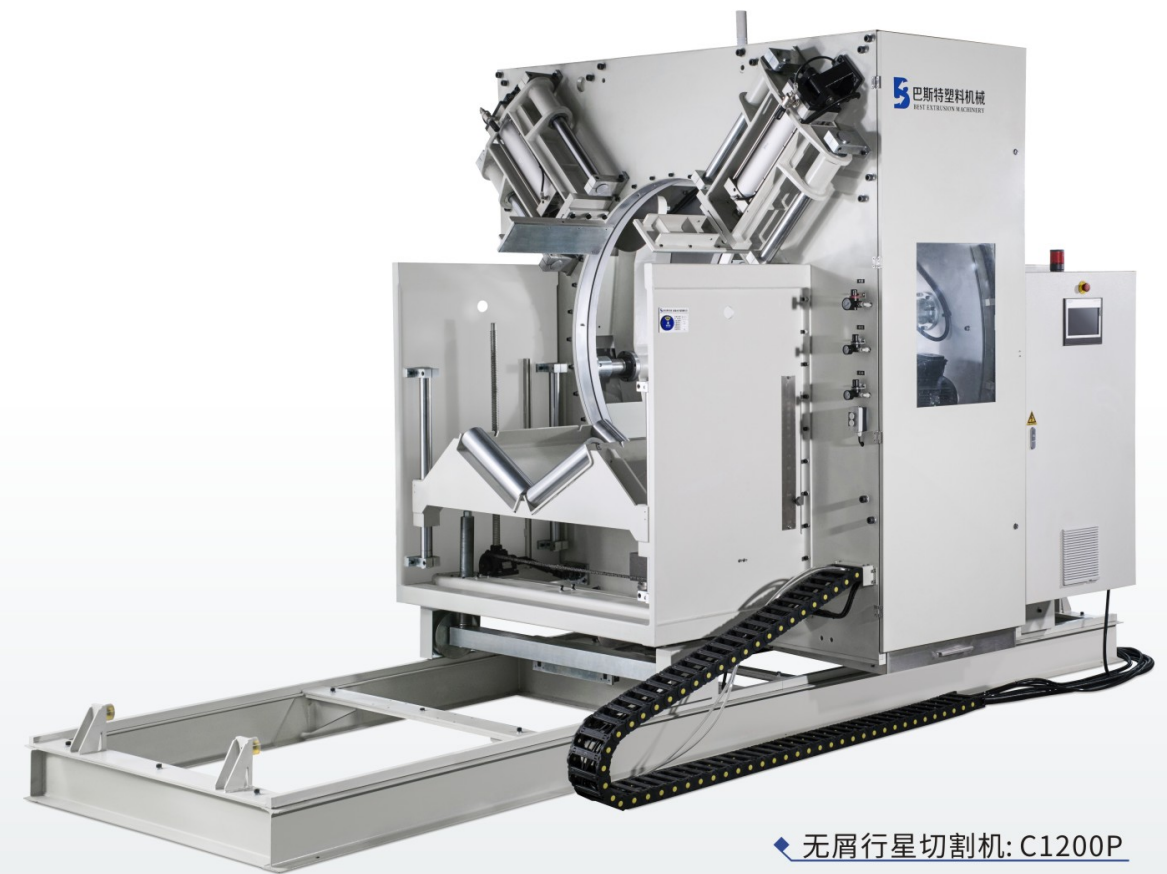
型号/Model	H32	H63	H160-3	H250-4	H315-4	H450-4	H630-6	H800-6	H1200-10	H1600-12
接触长度 (mm) Contact length	1000	1200	1600	1600	1600	1600	1600	1600	2000	2000
管径范围 (mm) Pipe range	10-32	10-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200	710-1600
最高牵引速度 (m/min) Max. hauling speed	1-70	1-45	0.5-20	0.2-10	0.1-5	0.1-2.2	0.05-1.25	0.02-1	0.01-1	0.01-0.5

## 无屑行星切割机 CHIPLESS PLANETARY CUTTER

### 特点/Features:

- ◆ 大口径PO管材切割
- ◆ 运行稳定，无屑无噪音切割
- ◆ 低成本，高效能
- ◆ 切割台由气缸驱动
- ◆ 进口液压单元
- ◆ 无屑与锯切两用

- ◆ For the cutting of large PO pipe
- ◆ Stable operation, chipless and noiseless cutting
- ◆ Low cost, high performance
- ◆ Cutting table is driven by cylinder
- ◆ Imported hydraulic unit
- ◆ Cutting mode: chipless and saw cutting for option



◆ 无屑行星切割机: C1200P

### 技术参数/Technical Data

型号/Model	C32F	C63F	C160RF	C250R	C315P	C450P	C630P	C800P	C1200P	C1600P
管材直径 (mm) Pipe diameter	10-32	16-63	20-160	50-250	75-315	90-450	200-630	315-800	630-1200	710-1600
最高切割速度 (m/min) Max. cutting speed	50	50	12	10	5	5	3	3	2.5	2
最大切割厚度 (mm) Max. cutting thickness	5.4	10.5	20.9	35	40	60	80	100	150	150

## 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

## 双工位切割机 DOUBLE STATIONS CUTTER

### 特点/Features:

- ◆ 双工位设计, 无屑切割, 适用范围大
- ◆ 切刀由线性导轨引导
- ◆ 切割台由伺服电机同步或气缸驱动
- ◆ Double working station design, chipless cutting, wide application range.
- ◆ Cutting blade is guided by linear guide.
- ◆ Cutting table is driven by synchronous servo motor or cylinder.

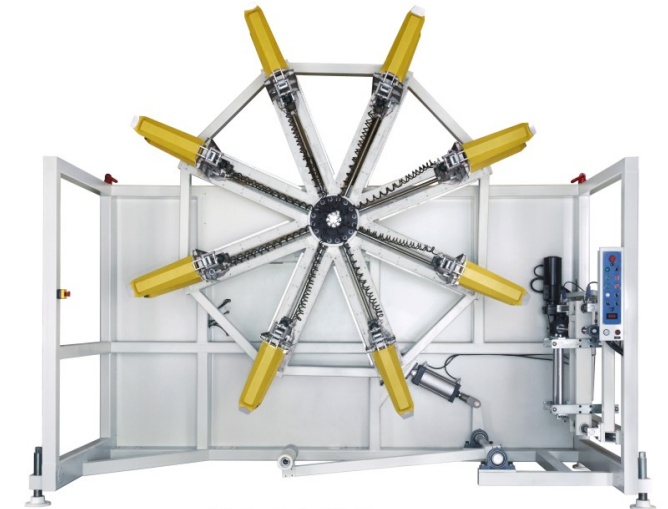


双工位切割机: C160RF

## 半自动盘卷机 SEMI-AUTOMATIC COILER



半自动盘卷机: W12-2



半自动盘卷机: W35

## 全自动盘卷机 AUTOMATIC COILER

### 特点/Features:

- ◆ 具有自动排线、切割、换卷、捆扎、卸料和在线称重功能
- ◆ 排线、收卷及换盘驱动均使用独立伺服电机, 通过数字编程精准控制
- ◆ 换盘、切割及夹紧自动完成, 避免管子缓存及再上卷的时间浪费及操作失误可能
- ◆ 送带导轨与卷盘一体化设计, 极大降低故障率
- ◆ With the function of automatic emissions wiring, cutting, roll-changing, strapping, unloading, online weighing.
- ◆ Through digital programming control, the emissions wiring, coiling and roll-changing are driven by separate servo motor.
- ◆ Roll-changing, cutting and clamping are completed automatically, avoiding time wasted for caching, rewinding and possible misoperation.
- ◆ The integrated design of feeding guide and reel greatly reduces the failure rate.



全自动盘卷机: WA11B

### 技术参数/Technical Data

型号/Model	WA8-2	WA11B	W12-2	W23	W27	W35
管材直径(mm) Pipe diameter	4-12	16-32	16-32	20-63	40-75	63-160
最高盘卷速度(m/min) Max. coiling speed	120	80	50	25	18	10
最大外径(mm) Max. outside diameter	800	1100	1200	2300	2700	3500

## 双管挤出 TWO-PIPE 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32mm以下管材的高速生产，管材稳定生产速度达到44m/min
- ◆ In the production of small pipes requiring high output, it can especially show the advantages of using two-pipe extrusion line. The feature of our two-pipe downstream equipment is with two sets of independent control loops. Speed of each line can be adjusted separately, 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 44m/min with stable operation.

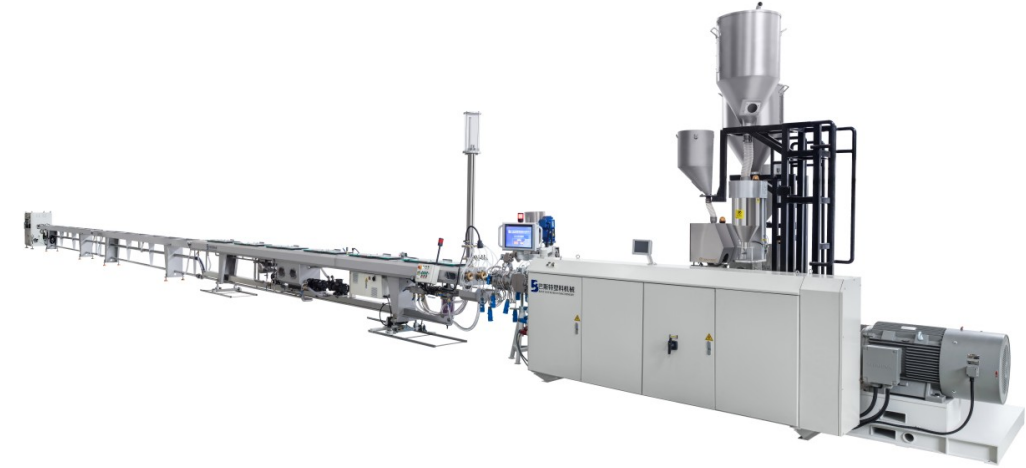


双牵引切割机: HCD32

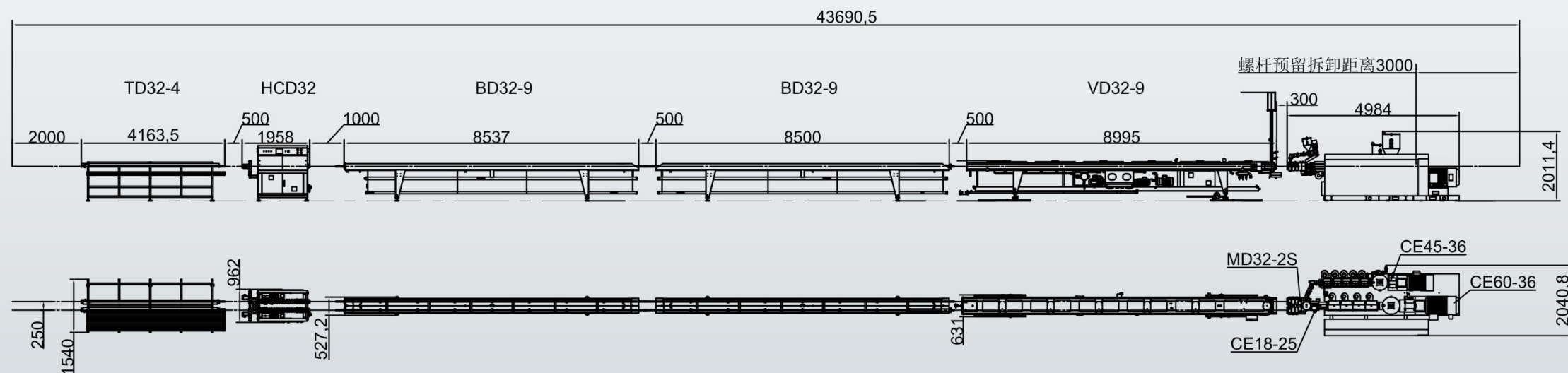
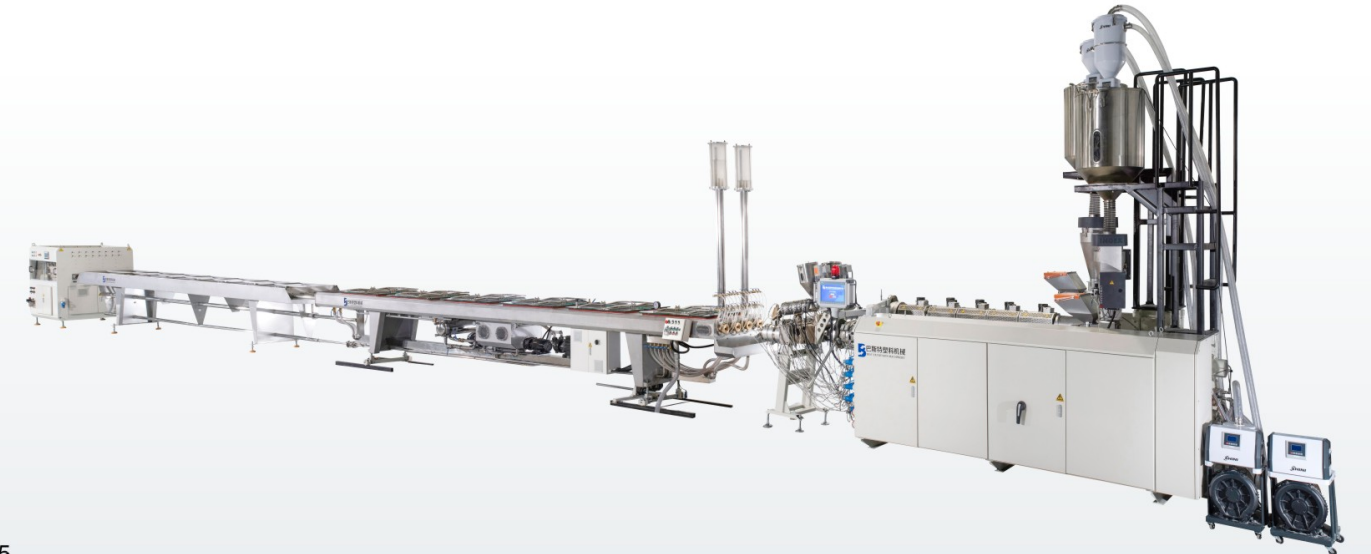


双管双层模具: MD32S

## PPR一出二双色管材生产线 PPR TWO-PIPE & TWO-COLOR HIGH SPEED EXTRUSION LINE



## PPR一出四双色管材生产线 PPR FOUR-PIPE & TWO-COLOR HIGH SPEED EXTRUSION LINE



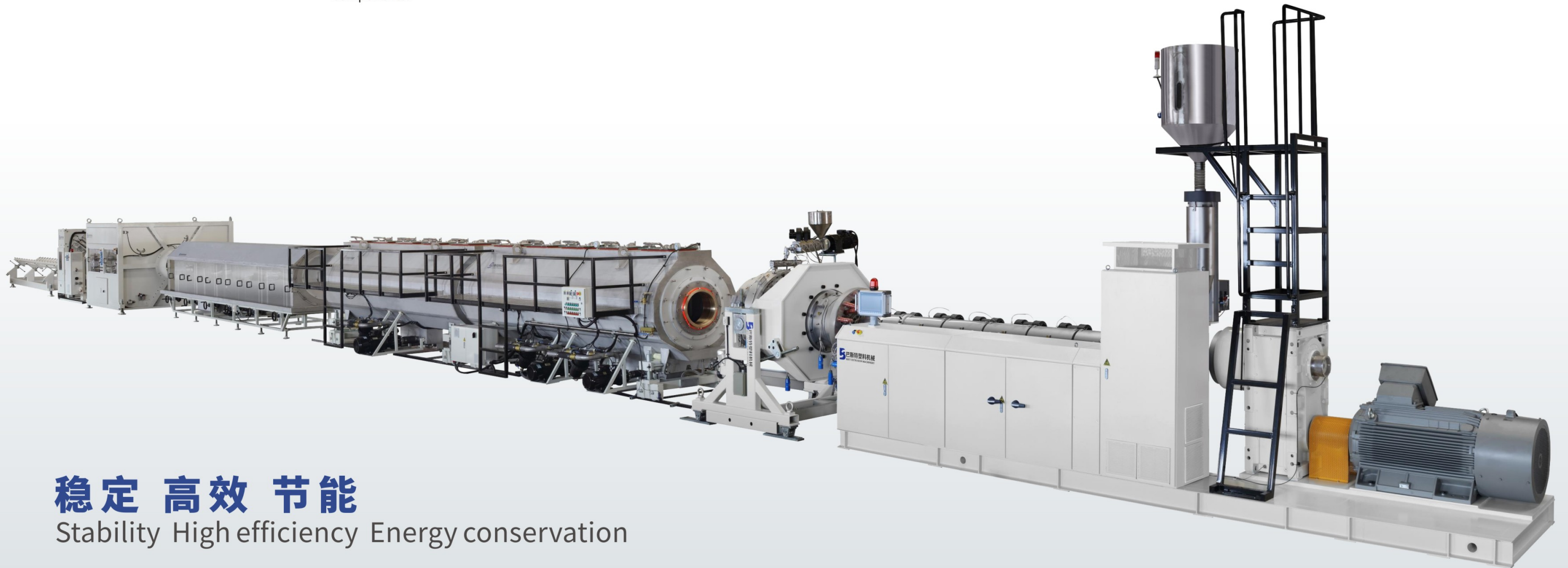
# HDPE 管材挤出生产线

## HDPE PIPE EXTRUSION LINE

### 特点/Features:

- ◆ 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
  - ◆ 螺杆优化设计，保证高转速时的塑化效果，实现高产低能耗
  - ◆ 模具内冷系统，提高冷却效果，减少冷却长度，降低生产成本，同时提高产量
  - ◆ 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 cooling length, save production costs, and also increase the output.
  - ◆ The extrusion line can achieve various control of downstream equipment by the extruder.
  - ◆ The extrusion line uses multiple internationally renowned brand components.

生产线 Extrusion line	挤出机型号 Extruder Model	挤出力 Output	吨能耗 Consumption per ton	生产线长度 Length of line	总装机功率 Total installed power
16-32mm	CE60-36	340kg/h	260kwh	42m	180kw
16-63mm	CE60-36	340kg/h	260kwh	42m	180kw
20-160mm	CE60-36	420kg/h	280kwh	50m	180kw
50-250mm	CE75-36	680kg/h	300kwh	57m	300kw
75-315mm	CE75-36	680kg/h	300kwh	57m	300kw
90-450mm	CE90-30	800kg/h	320kwh	60m	370kw
200-630mm	CE90-36	980kg/h	320kwh	63m	470kw
315-800mm	CE90-36/CE120-30	980-1100kg/h	320kwh	70m	510kw
630-1200mm	CE120-36	1250kg/h	320kwh	78m	580kw
710-1600mm	CE150-36	1500kg/h	320kwh	85m	690kw



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