

# $\Phi 2.5-6\text{inch}$ PVC pipe production line



**Specification for  $\phi 2.5-2\text{inch}$  PVC PIPE PRODUCTION LINE**  
**SJZ-51/105 conical double screw extruder**



**Note :**

Due to keeping innovation,  
 the specification and  
 Machine pictures or color  
 are subject to alteration  
 without notice!

| Model                              | SJZ80/156                             |
|------------------------------------|---------------------------------------|
| Power                              | 55kw                                  |
| Output                             | 400kg/h                               |
| Center height                      | 1000mm                                |
| Screw shaft type                   | 80/156 conical twin                   |
| Screw diameter                     | One end 80mm, another end 156mm       |
| Length of screw shaft              | 1800mm                                |
| Screw rotating speed               | 0—35rpm                               |
| Hardness of screw surface          | HV850~950                             |
| Treatment of screw surface         | Nitriding                             |
| Screw Material                     | 38CrMoAlA                             |
| Material of barrel                 | 38CrMoAlA                             |
| Barrel type                        | Conical twin                          |
| Barrel inner diameter              | 80mm, 156mm                           |
| Treatment of barrel surface        | Nitriding                             |
| Hardness of barrel surface         | HV900~1040                            |
| Temperature control zone of barrel | 4                                     |
| Heating power                      | 32KW                                  |
| Heating method                     | Aluminum casting heater               |
| Cooling zone of barrel             | 4                                     |
| Cooling method                     | blow fan 0.38KW*4                     |
| Vacuum zone                        | 1 zone, two hole                      |
| Model of vacuum pump               | SZ-1                                  |
| Volume of pump                     | -0.06MP                               |
| Pump motor                         | 1.5KW                                 |
| Feeding Type                       | Forced feeding system                 |
| Hopper volume                      | 600*400mm                             |
| Hopper material                    | Polish of stainless steel             |
| Feeding motor                      | AC0.75KW                              |
| Ratio of gear box                  | 1: 36.5                               |
| Type of gear                       | Bevel wheel                           |
| Material of gear box               | forgeable cast iron                   |
| Material of axes                   | 40Cr                                  |
| Material of gear                   | 20CrMnTi                              |
| Speed adjusting method             | Motor speed adjustable                |
| Soakage method                     | oiliness bevel wheel lubricated       |
| Hardness of bevel wheel            | HRC54—62                              |
| Main motor connect type            | Coupling                              |
| Extruder structure                 | Welded by trough steel and plate, 8mm |
| Extruder steel                     | Q235                                  |
| Total weight of extruder           | Around 3200kg                         |
| Platinum resistance PT100          | 8 pcs                                 |
| Main motor adjusting               | HOLIP INVERTER                        |
| Feeding adjusting                  | HOLIP INVERTER                        |
| Temperature controller             | RKC                                   |
| Contactors                         | SIEMENS                               |
| Switch                             | DELIX                                 |

Adopt plug type connection wire for primary motor and electric control cabinet  
 Electrical part measure up to JB/T 5420-2001 Standard of Chinese Machinery Department