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**GUANGDONG LIANSU MACHINERY MANUFACTURING CO.,LTD**

Daba Industrial Area, Longjiang Town, Shunde Section, Foshan City, Guangdong, China  
 +86-757-2338 8569 / +86-757-2336 5136  
 [info@liansu.com](mailto:info@liansu.com)  
 @Liansu extrusion



**GUANGDONG LIANSU MACHINERY MANUFACTURING CO.,LTD**

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LIANSU MACHINERY  
MANUFACTURING



# COMPANY PROFILE

Guangdong Liansu Machinery Manufacturing Co., Ltd. is a high-tech enterprise engaged in the R&D, production, sales and service of plastic extrusion equipment and auxiliary automation equipment. Established in 1994, the company is located in Liansu Daba Industrial Zone, Longjiang Town, Shunde. Covering an area of more than 86,000 square meters, it currently has more than 400 employees. With years of experience and technology accumulated in the plastics industry and continuous investment in technology R&D, Liansu Machinery has made exploration, research and innovative development continuously. In reliance on its excellent product quality and powerful technical strength, it has built corporate brands, developed domestic and overseas markets, and established a number of marketing and service outlets at home and abroad. Its products are mainly sold in countries and regions in South America, Europe, South Africa, North Africa, Southeast Asia, Central Asia and the Middle East. And its customers spread all over the world. Its products cover three series: extrusion production line ; PVC powder and granular full-automatic feeding system; permanent magnet synchronous motor.

Liansu Machinery has acquired 221 patents, including 34 invention patents, 187 utility model patents, and 2 design patents, making improvements and innovations in technologies and improving product technology and quality levels.

For 30 years, Liansu Machinery has been committed to the overall green and energy-efficient production of plastic extrusion processing equipment, equipment automation research, development and promotion (upstream centralized supply of raw materials for plastic extrusion processing and downstream automatic packaging for plastic extrusion processing), and data collection and analysis of plastic extrusion processing. It has made overall layout of the entire ecological chain of equipment automation and informationization from upstream to downstream of plastic extrusion processing.

## 1999-2002

In 1999, The first developed aluminum plastic pipe production line equipment come out

In 1999, Yunan Liansu Machinery Co., Ltd founded

In 2000, domestic first developed PPR production line come out

DELAISIBAO (China) plastic machinery Co., Ltd (Sino German joint venture) founded in January 1st, 2001

Guangdong Liansu Machinery Company New address Liansu Industrial A zone founded in January, 2002



## 2004-2007

Company Passed the audit of quality, safety and environmental management system (QEO) in August 2004; and also honored as Europe CE certificate  
Liansu Machinery New address Liansu Industrial C zone founded in August, 2007

## Established in 1994

## 1994-1998

Guangdong Liansu Machinery Manufacture Co., Ltd founded in 1994

In 1998, First passed ISO9000 quality management system certification in the industry

In 1998, New product developed "Conical twin extruder" come out



## 2009-2011

In 2009, Company awarded as Guangdong Province equipment manufacturing industry 100 cultivate enterprise

In 2010, Honored as Guangdong Province machinery industry association standing council unit

In 2011, honored as National high-tech enterprises



## 2014-2021 ...

In 2014, 'Liansu injection molding machine' was awarded as a famous brand product in Guangdong Province. The project of 'Research and development and industrialization of high-performance numerical control equipment based on plastic processing process' was accepted in 2016.  
In 2019, passed the clean production audit of Guangdong Province.  
In 2019, PVC intelligent mixing and dosing flexible integrated system won the national award.  
In 2020, re-identified as a high-tech enterprise;  
Won the 'national high-tech enterprise'  
Awarded 280 patents in 2012-2022.

## FULL-DIRECTION SERVICE

## 2012

In 2012, honored as Guangdong Province work safety standardization three-level enterprise

Honored as Guangdong Province machinery industry association vice-chairman unit in 2012; Chinese Plastic machinery association council member Liansu Machinery New address Liansu Daba Industrial zone founded in October 2012





## HONORS & CERTIFICATES

- First passed ISO9000 quality management system certification in the industry in 1998.
- New product develop 'conical twin extruder' come out in 1998, on behalf of Liansu Machinery Manufacture Industry enter into conical twin era, Liansu Machinery leading the industry forefront.
- The first developed aluminum plastic pipe production line equipment come out in 1999.
- Domestic first developed PPR production line come out in 2000, marked Company product research and development technology higher. Research and development of PPR pipe extrusion production line is the only one honored by Construction Ministry as 'National advanced level' in the industry.
- Again passed ISO9001 quality management system certification in the industry in 2002.
- New product developed PC sunlight sheet production line in 2002, rely on its excellent working performance and leading technology level to win the favor of customers.
- Large diameter hollow wall spiral pipe production line developed by company in 2004, be honored as '2004 science and technology key project' by Construction Ministry; PE 1000 large diameter pipe production line won the 'national torch plan project'.
- Company passed the audit of quality, safety and environmental management system (QEO) in August 2004; and also honored as Europe CE certificate.
- Identified as 'Guangdong Province famous trademarks' in 2005.
- In 2006, research of PE spiral internal and external screw thread connection technology, won the Shunde zone major scientific and technical project fiance support.
- In 2007, LSP-1000PE pipe production line won the scientific-technical progress Third Place of Foshan City.
- In 2008, research of PEX/PERT and EVOH multi-layer co-extrusion plastic pipe processing complete equipment got the Shunde zone major scientific and technical project fiance support.
- In 2008, honored as Guangdong Province Brand product.
- In 2009, Company awarded as Guangdong Province equipment manufacturing industry 100 cultivate enterprise.
- In 2009, 'AC low-rotating speed high-torque motor drive high-yield screw extruder series technical transformation' won the Guangdong provincial financial support for the equipment manufacturing industry technical transformation project.
- In 2009, research of PEX/PERT and EVOH multi-layer co-extrusion plastic pipe processing complete equipment honored as science and technology second place of Foshan city.
- In 2010, won Shunde Zone plastic extrusion equipment engineering technology center construction project.
- In 2010, honored as Guangdong Province machinery industry association standing council unit.



- In 2010, honored as Shunde zone excellent enterprise growth project key supporting enterprise.
- In 2011, won the Annual Provincial Government Quality Award.
- In 2011, plastic extrusion equipment engineering center was established.
- In 2011, honored as National high-tech enterprises.
- Honored as Guangdong Province machinery industry association vice-chairman unit in 2012; Chinese plastic machinery industry association council member.
- 2013 provincial famous product: Multi-layer co-extrusion casting film production line.
- In 2013, won the First prize of the Shunde science and Technology: torque motor single screw extruder
- In 2014, rated ad the second-class enterprise of safety production standardization in Guangdong Province.
- In 2014, won the Third prize Foshan city science and Technology: torque motor single screw extruder.
- In 2014, 'single screw plastic extruder' won the Third prize of Guangdong Science and Technology Award.
- In 2014, 'single screw plastic extruder' won the Third prize of Foshan city Science and Technology Award.
- In 2014, 'Liansu injection molding machine' was awarded as a famous brand product in Guangdong Province.
- Pass the 2015 creative application demonstration project inspection of first-generation numerical control mechanical products of Guangdong province.
- In 2015, rated as hundred intelligent manufacturing project pilot demonstration enterprises.
- The project of 'Research and development and industrialization of high-performance numerical control equipment based on plastic processing process' was accepted in 2016.
- In 2016, 'LSCPE-2500 high-speed Wide-width Breathable Film production line' won the provincial 'research and development and using of the first set with major technical equipment'.
- In 2016, leading casting equipment won the first unit (set) award of Guangdong province.
- In 2017, 'PVC intelligent mixing and integration system' won the provincial 'research and development and using of the first set with major technical equipment'.
- In 2017, re-identified as a high-tech enterprise;
- In 2019, passed the clean production audit of Guangdong Province.
- In 2019, PVC intelligent mixing and dosing flexible integrated system won the national award.
- In 2020, re-identified as a high-tech enterprise;
- Won the 'national high-tech enterprise
- Awarded 280 patents in 2012-2022.



## PIPE EXTRUSION SERIES

- 01 LS-PVC Four Pipe Production Line
- 03 LS-PVC Double Pipe Production Line
- 05 LS-UPVC Pipe Production Line
- 07 LS-PPR Pipe Production Line
- 09 LS-PPR Double-Pipe Production Line
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- 35 Standard
- 37 LS-Mixer
- 38 LS-PVC Granulating Production Line
- 39 LS-PE/PPR Granulating Production Line



# LS-PVC Conduit

## Four Pipe Production line

### MAIN FEATURES

- The main machine is equipped with conical twin-screw extruder, and equipped with special permanent magnet synchronous servo motor for extruder, with high output and energy saving
- Equipped with on-line automatic packing mechanism, efficient and manpower saving.
- Production data acquisition and analysis system can be selected to realize transparent production management.



### HAULING+CUTTING+PACKING COMBO

- Hauling+cutting+packing three in one design, saving space, stable.
- Simple and reliable swarfless cutting, stable performance.
- Vacuum alarm and automatic removal of waste pipe.
- Unique bundling & bagging design, stable pipe packing performance.

### VACUUM

- The vacuum of each tank is controlled independently, which can save energy and reduce noise. Vacuum alarm and send signal to automatically cut the waste pipe.



### MOULD

- Suitable for electric cable duct production, reasonable flow channel design, large compression ratio, ensure plasticizing effect.



STACKER

HAUL OFF & CUTTING UNIT

VACUUM TANK

HEAD

EXTRUDER

### EXTRUDER

- Provides conical twin screw extruder, high output and energy-saving. Realize online pigment addition and flexible color change.

### SOCKET ONLINE BAGGING

- Optional four pipe on-line socket machine.
- Double station, heating and socketing design.



### MAIN TECHNICAL PARAMETER

| MODEL      | EXTRUDER MODEL | MAX HAULING SPEED (m/min) | MAX OUTPUT (kg/h) | TOTAL INSTALLED POWER (kw) | PRODUCTION LINE LENGTH (m) |
|------------|----------------|---------------------------|-------------------|----------------------------|----------------------------|
| LSFP-32PVC | LSE-80         | 18                        | 450               | 165                        | 25                         |
| LSFP-32PVC | LSE-65         | 18                        | 280               | 110                        | 23                         |



# LS-PVC

## Double Pipe Production line

### MAIN FEATURES

- The main machine is equipped with large L/D ratio parallel double screw and conical double screw extruder, and equipped with special permanent magnet synchronous servo motor for extruder, with high output and energy saving.
- The vacuum adopts frequency conversion closed-loop control, which is energy-saving and stable.
- Equipped with on-line automatic packing mechanism, efficient and manpower saving.
- Production data acquisition and analysis system can be selected to realize transparent production management.



### CUTTER

- Double station cutting independent control, using swarfless cutting, clean and smooth incision.



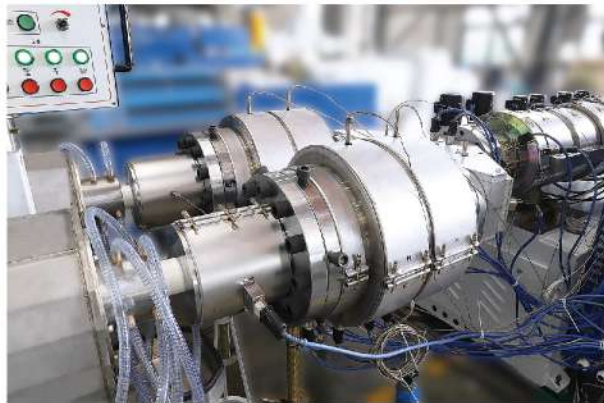
### HAUL-OFF UNIT

- Each hauling station is controlled independently and adopts servo control to ensure large speed regulation range.



### VACUUM

- Double tank body vacuum independent control, adopts variable frequency closed-loop control, great energy saving and reduces noise.



### MOULD

- Reasonable runner design ensures large extrusion and compression ratio of mould.
- The mould structure is convenient for quick installation and disassembly.



### EXTRUDER

- Provides high output conical twin screw extruder and parallel twin screw extruder for selection, high output and energy-saving. Realize online pigment feeding and flexible color change.



### MAIN TECHNICAL PARAMETER

| MODEL       | PIPE RANGE (m) | EXTRUDER MODEL | MAX HAULING SPEED (m/min) | MAX OUTPUT (kg/h) | TOTAL INSTALLED POWER (kw) | PRODUCTION LINE LENGTH (m) |
|-------------|----------------|----------------|---------------------------|-------------------|----------------------------|----------------------------|
| LSDP-63PVC  | Ø16-Ø63        | LSE-65/132     | 25x2                      | 280               | 110                        | 25                         |
| LSDP-75PVC  | Ø16-Ø75        | LSE-80/156     | 25x2                      | 450               | 160                        | 26                         |
| LSDP-110PVC | Ø75-Ø110       | LSE-80/156     | 14x2                      | 450               | 200                        | 26                         |
| LSDP-110PVC | Ø75-Ø110       | LSE-95/191     | 14x2                      | 1000              | 390                        | 36                         |



# LS-UPVC

## Pipe Production Line

### MAIN FEATURES

- The main machine is equipped with large L/D ratio parallel double screw and conical double screw extruder, and equipped with special permanent magnet synchronous servo motor for extruder, with high output and energy saving.
- The vacuum adopts frequency conversion closed-loop control, which is energy-saving and stable.
- Equipped with on-line automatic packing mechanism, efficient and manpower saving.
- Production data acquisition and analysis system can be selected to realize transparent production management.
- With online socket machine.

### PIPE WEIGHING STACKER

- Stacker with weighing and data acquisition function, open source data integration.



### CUTTING MACHINE

- Planetary cutting adopts multi-point clamping structure, lens type sealing, self balancing counterweight and automatic profiling structure to ensure uniform chamfering and good dust collecting effect.



### VACUUM

- Adopts inverter drive closed-loop control, great energy saving and reduces noise.



### EXTRUDER

- High output and energy-saving. Realize online pigment feeding flexible online color change.



STACKER

CUTTER

HAUL - OFF UNIT

VACUUM TANK

VACUUM TANK

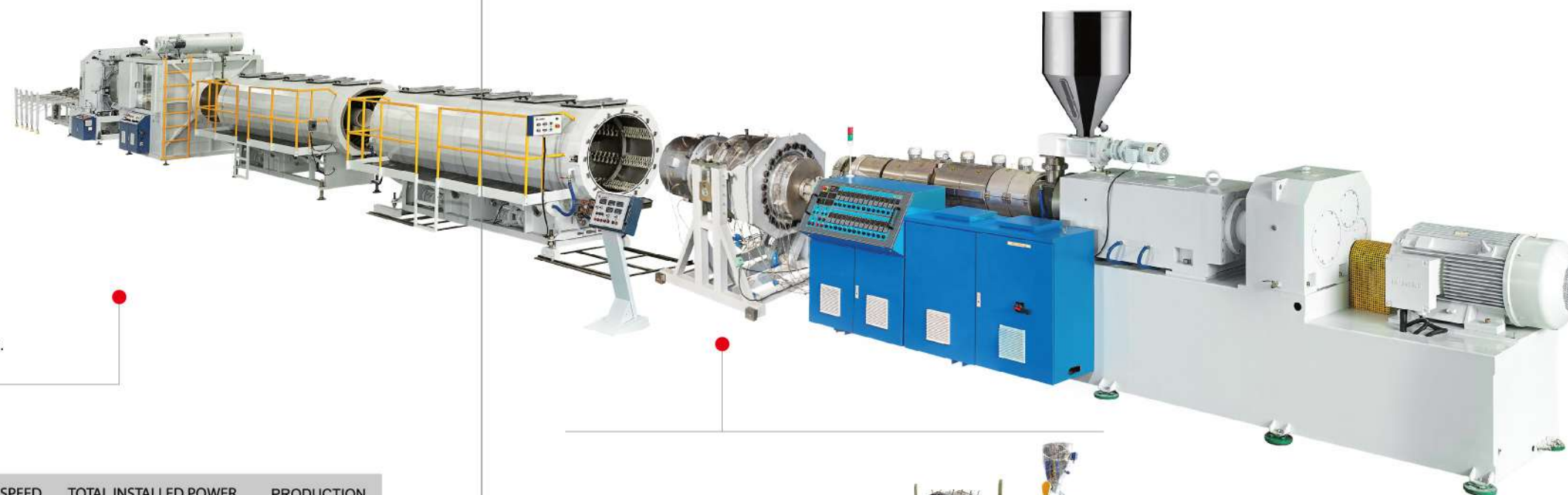
DIE HEAD

EXTRUDER



### HAUL-OFF UNIT

- Synchronous servo drive scheme is adopted for hauling and winch device to ensure more than 50 times of stable large speed regulation range, stable speed and reduce waste products.



### MAIN TECHNICAL PARAMETER

| MODEL         | PIPE RANGE (m) | EXTRUDER MODEL | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) | PRODUCTION LINE LENGTH (M) |
|---------------|----------------|----------------|-------------------|---------------------------|----------------------------|----------------------------|
| LSP-63PVC     | Ø16-Ø63        | LSE-55         | 180-230           | 25                        | 90                         | 24                         |
| LSP-110PVC-I  | Ø20-Ø110       | LSE-65         | 280-350           | 15                        | 110                        | 24                         |
| LSP-110PVC-II | Ø40-Ø110       | LSE-80         | 450-550           | 12                        | 180                        | 25                         |
| LSP-160PVC    | Ø63-Ø160       | LSE-80         | 450-550           | 8                         | 175                        | 25                         |
| LSP-250PVC-II | Ø63-Ø250       | LSE-80         | 450-550           | 6.5                       | 195                        | 25                         |
| LSP-400PVC    | Ø110-Ø400      | LSE-92         | 750-820           | 2.4                       | 290                        | 32                         |
| LSP-630PVC    | Ø160-Ø630      | LSE-92         | 750-820           | 1.6                       | 330                        | 33                         |
| LSP-800PVC    | Ø280-Ø800      | LSE-95         | 1000-1050         | 1.6                       | 380                        | 46                         |
| LSP-1000PVC   | Ø630-Ø1000     | LSE-95         | 1000-1050         | 0.6                       | 540                        | 50                         |

### MOULD

- Reasonable design of flow channel ensures large extrusion and residence time of melt in mould.
- The mould structure is convenient for quick installation and disassembly.



### SOCKET MACHINE

- Double-layer heating inside and outside the pipe, double heating furnace to ensure the quality and efficiency of socket.



# LS-PPR

## Pipe Production Line

### MAIN FEATURES

- The extruder adopts large L/D ratio screw, equipped with dedicated permanent magnet synchronous servo motor to realize high output and energy saving.
- The vacuum adopts frequency conversion closed-loop control, which is energy-saving and stable.
- Haul off adopts servo control to ensure stable production in large speed regulation range.
- Equipped with online straight pipe, coil pipe automatic packing mechanism, efficient and save labor.
- Production data acquisition and analysis system can be selected to realize transparent production management.



### CUTTER

- Using flying knife swarfless cutting, cutting stable, fixed length accurate



### HAUL-OFF

- The hauling adopts servo control to ensure more than 50 times of stable speed regulation range, high speed and stable hauling.



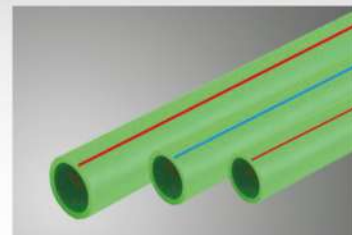
CUTTER



HAUL - OFF UNIT



SPRAY TANK



### MAIN TECHNICAL PARAMETER

| MODEL      | PIPE RANGE (mm) | EXTRUDER MODEL | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) | LINE LENGTH (m) |
|------------|-----------------|----------------|-------------------|---------------------------|----------------------------|-----------------|
| LSP-63PPR  | Ø16-Ø63         | LSS-50-40      | 250               | 25                        | 165                        | 53              |
| LSP-110PPR | Ø20-Ø110        | LSS-50-40      | 250               | 18                        | 215                        | 53              |
| LSP-160PPR | Ø32-Ø160        | LSS-65-40      | 300               | 12                        | 225                        | 53              |

### CO-EXTRUDING FOR COLOR STRIP

- The co-extruder adopts back structure to save space.



### PACKING

- Automatic packing online to reduce labor cost.

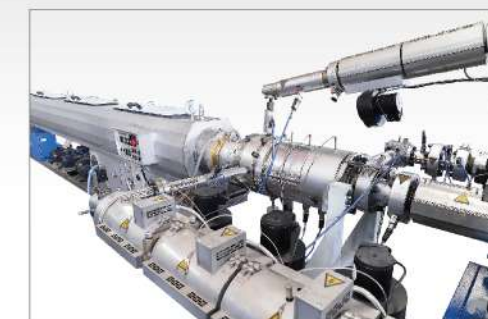
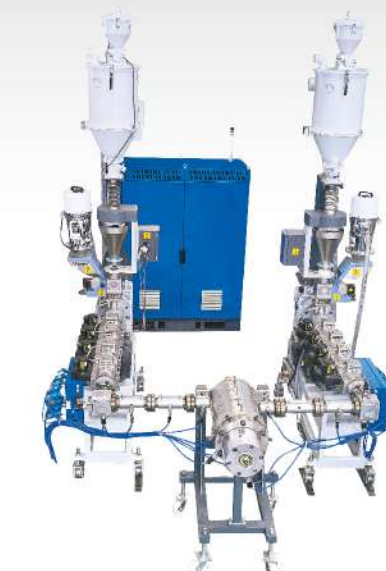


### VACUUM

- Vacuum adopts negative pressure closed loop to automatically adjust vacuum degree, improve pipe production quality and reduce noise.
- Vacuum alarm, and send signal to cut the waste pipe automatically.

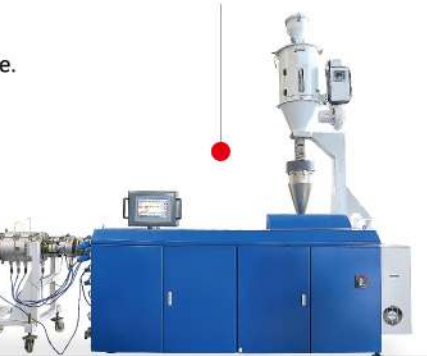
### EXTRUDER

- The extruder adopts 40 L/D ratio high-output screw, energy saving and low noise.



### MOULD

- Spiral die head structure, uniform wall thickness.
- The setting die adopts sleeve structure, with forced water cooling at the inlet, which is stable at high speed.



DIE HEAD

EXTRUDER

VACUUM TANK



# LS-PPR

## Dual Pipe production line

### MAIN FEATURES

- The extruder adopts large L/D ratio screw, equipped with dedicated permanent magnet synchronous servo motor to realize high output and energy saving.
- The vacuum adopts frequency conversion closed-loop control, which is energy-saving and stable.
- Hauling adopts servo control to ensure stable production in large speed regulation range.
- Equipped with online straight pipe, coil pipe automatic packing mechanism, efficient and save labor.
- Production data acquisition and analysis system can be selected to realize transparent production management.

### HAUL-OFF

- The hauling adopts servo control to ensure more than 50 times of stable speed regulation range, high speed and stable hauling.



### BATH TANK

### CUTTER

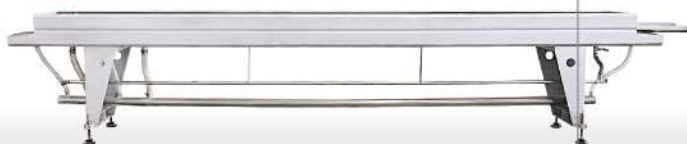
- Double station independent control, using large inertia flying knife servo motor, fixed length using "PLC free control", simple & reliable



CUTTER



HAUL-OFF UNIT

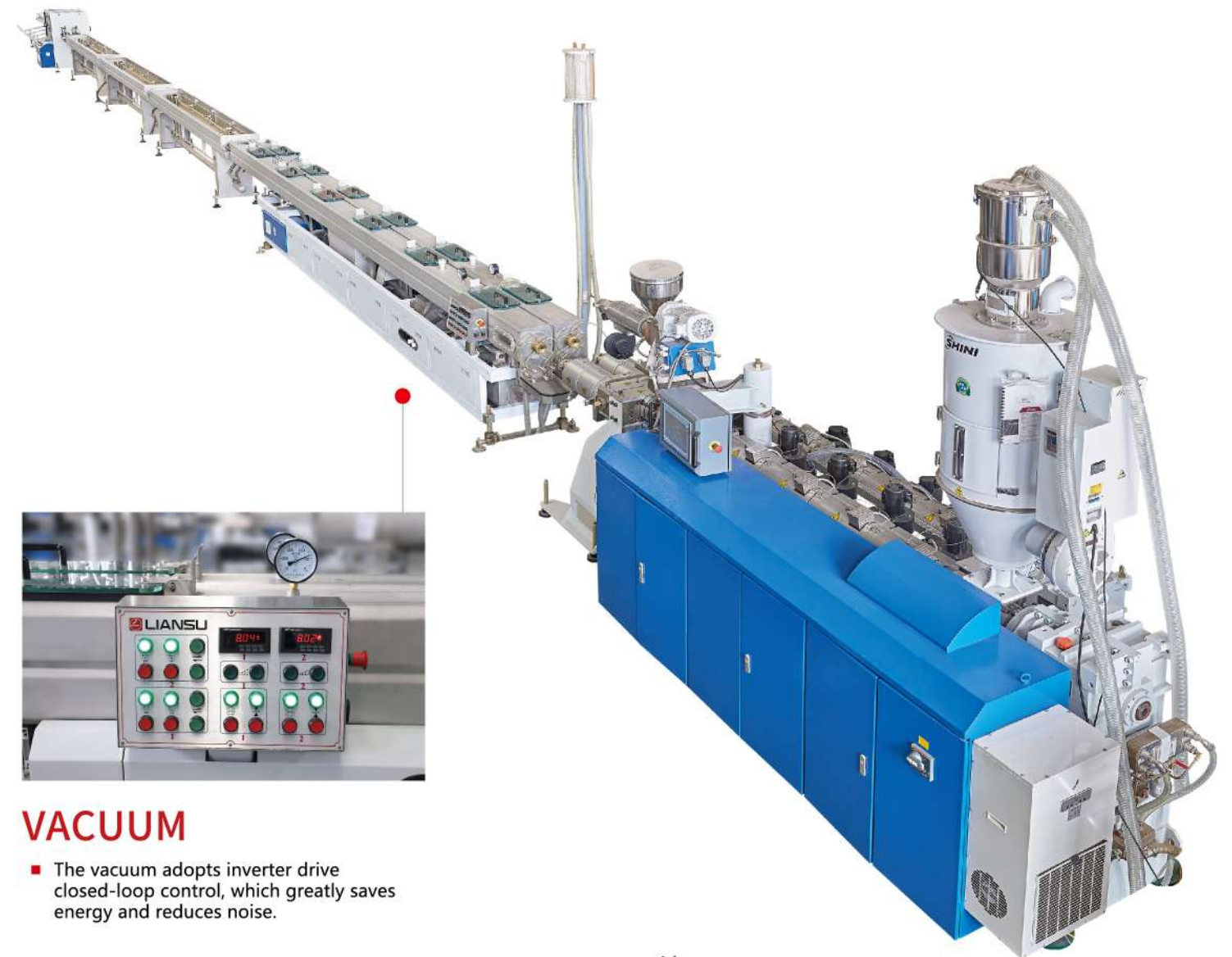


BATH TANK



### MAIN TECHNICAL PARAMETER

| MODEL      | PIPE RANGE (mm) | EXTRUDER MODEL      | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) | LINE LENGTH (m) |
|------------|-----------------|---------------------|-------------------|---------------------------|----------------------------|-----------------|
| LSDP-32PPR | Ø16-Ø32         | LSS50-40 / LSS65-40 | 160+300           | 40                        | 260                        | 50              |



### VACUUM

- The vacuum adopts inverter drive closed-loop control, which greatly saves energy and reduces noise.



VACUUM TANK



DIE HEAD

EXTRUDER



### MOULD

- Single or multi spiral die head structure, single or multi-layer structure can be provided, uniform wall thickness.
- The setting die adopts sleeve structure, with forced water cooling at the inlet, which is stable at high speed.

### EXTRUDER

- The extruder adopts 40 L/D ratio high-output screw, energy saving and low noise.
- Matching online color masterbatch addition, flexible production of single layer and double layer PPR pipes.



# LS-HDPE

## Pressure and Gas Pipe Production Line

### MAIN FEATURES

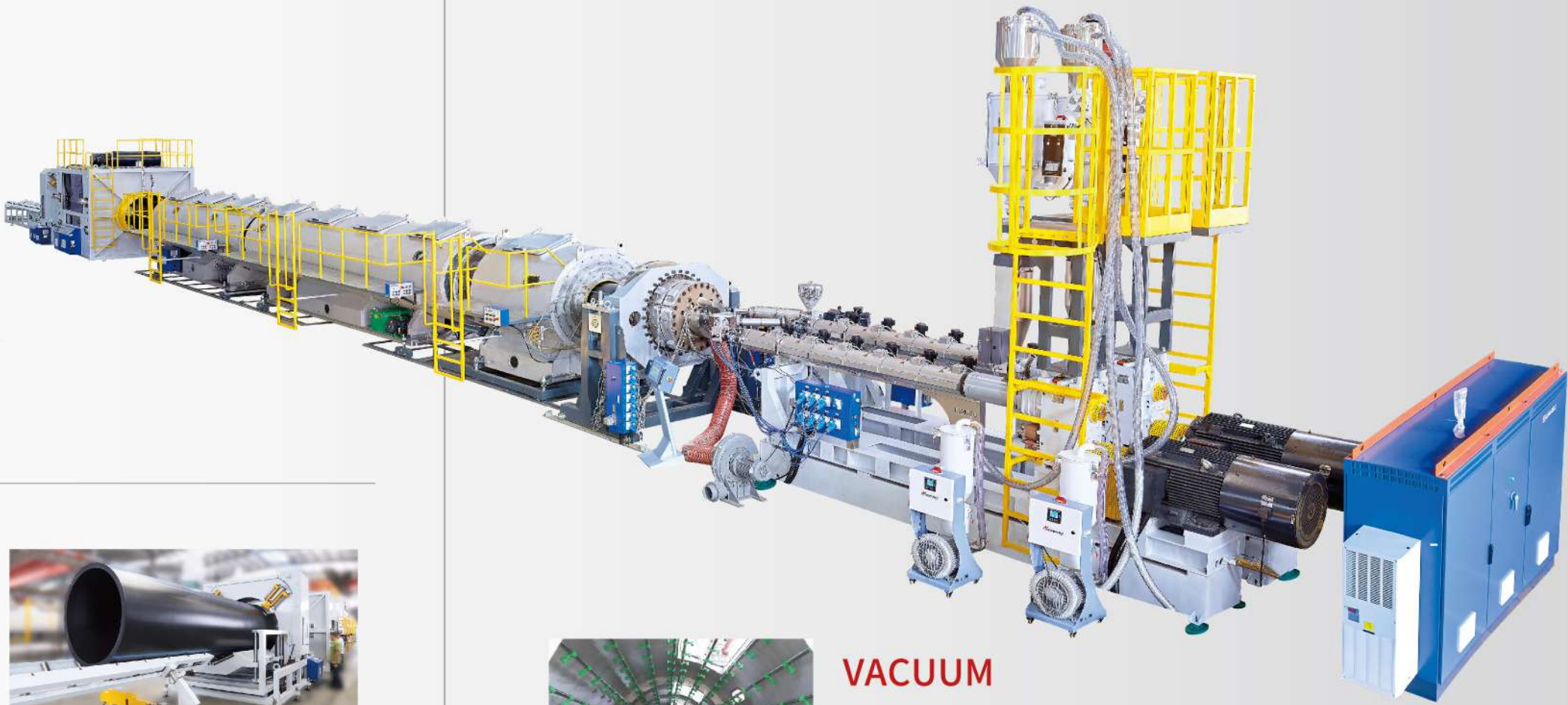
- The extruder is equipped with special permanent magnet synchronous servo motor to achieve high output and energy saving.
- The die body adopts spiral structure and equipped with exhaust mechanism to ensure stable melt temperature under high output and reduce cooling length.
- The vacuum adopts frequency conversion closed-loop control, which is energy-saving and stable.
- Hauling adopts servo control to ensure stable production in large speed regulation range.
- Adopt swarfless cutting mechanism, accurate fixed length, beautiful incision.
- Production data acquisition and analysis system can be selected to realize transparent production management.

### HAUL-OFF UNIT

- Synchronous servo drive scheme is adopted for hauling and pipe leading device to ensure more than 50 times of stable large speed regulation range, stable speed and reduce waste products.

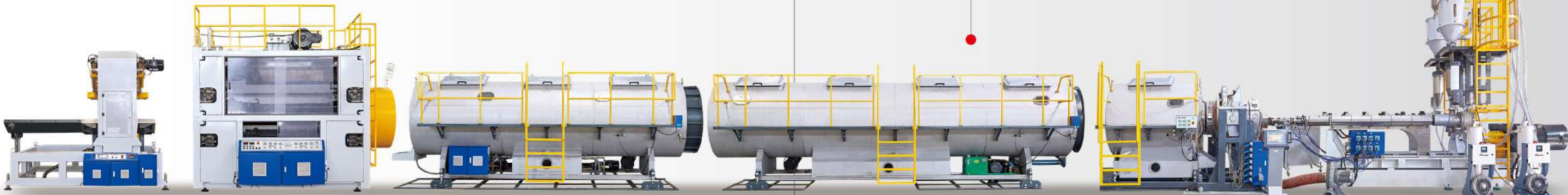
### SWARFLESS CUTTER

- Fully automatic one button change diameter ,simple,efficiency



### VACUUM

- The vacuum adopts negative pressure closed loop to automatically adjust the vacuum degree, which can stabilize the pressure, improve the quality of pipe production, greatly save energy and reduce noise.



CUTTER

HAUL OFF

VACUUM TANK

HEAD

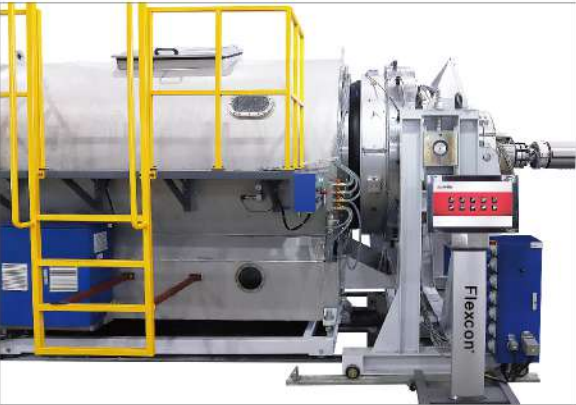
EXTRUDER

### MAIN TECHNICAL PARAMETER

| MODEL       | PIPE RANGE (mm) | EXTRUDER MODEL | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) | PRODUCTION LINE LENGTH (m) |
|-------------|-----------------|----------------|-------------------|---------------------------|----------------------------|----------------------------|
| LSP-63PE    | Ø16-Ø63         | LSS50-40       | 300               | 25                        | 165                        | 53                         |
| LSP-110PE   | Ø20-Ø110        | LSS50-40       | 300               | 18                        | 180                        | 55                         |
| LSP-160PE-I | Ø40-Ø160        | LSS65-40       | 600               | 12                        | 240                        | 59                         |
| LSP-250PE   | Ø50-Ø250        | LSS65-40       | 600               | 6.5                       | 250                        | 52                         |
| LSP-450PE   | Ø110-Ø450       | LSS80-40       | 820               | 4.5                       | 375                        | 63                         |
| LSP-630PE   | Ø160-Ø630       | LSS100-40      | 1150              | 1.6                       | 515                        | 73                         |
| LSP-800PE   | Ø280-Ø800       | LSS100-40      | 1150              | 1                         | 535                        | 66                         |
| LSP-1000PE  | Ø400-Ø1000      | LSS80-40x2     | 1600              | 0.8                       | 675                        | 70                         |
| LSP-1200PE  | Ø500-Ø1200      | LSS80-40x2     | 1600              | 0.6                       | 685                        | 71                         |
| LSP-1600PE  | Ø800-Ø1600      | LSS120-40      | 1400              |                           | 940                        | 71                         |

### MOULD

- The die body adopts spiral structure, which is suitable for pipe extrusion in various pressure ranges. The large die body adopts internal air-cooled die to save cooling length.



### EXTRUDER

- The extruder adopts 40 L/D ratio high output screw, energy saving and low noise.





# LS-Multi Layer

## Pipe Co-Extrusion Line

### MAIN FEATURES

- The extruder is equipped with special permanent magnet synchronous servo motor to achieve high output and energy saving.
- The mould body adopts the independent screw mechanism of each layer to ensure the uniformity of each layer.
- The vacuum adopts frequency conversion closed-loop control, which is energy-saving and stable.
- Hauling adopts servo control to ensure stable production in large speed regulation range.
- Adopt automatic size free swarfless cutting mechanism which is easy to adjustment and fixed length accuracy and the incision is beautiful.
- Equipped with online straight pipe, coil pipe automatic packing mechanism, efficient and save labor.
- Production data acquisition and analysis system can be selected to realize transparent production management.
- Single layer/multi-layer pipe production line with pipe diameter of 20-1200mm can be selected;



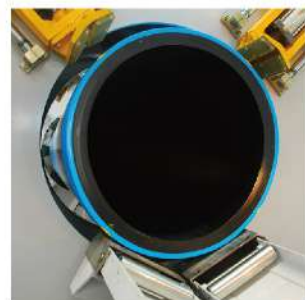
**CUTTING MACHINE**



**HAUL-OFF UNIT**

- Synchronous servo drive scheme is adopted for hauling and pipe leading device to ensure more than 50 times of stable large speed regulation range, stable speed and reduce waste products.

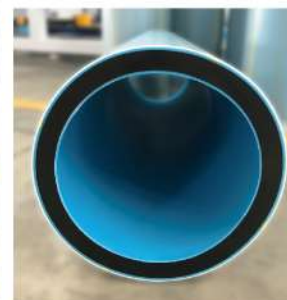
### PRODUCTS



Two-layer HDPE pipe



Three-layer HDPE co-extruding pipe



Four-layer HDPE co-extruding pipe

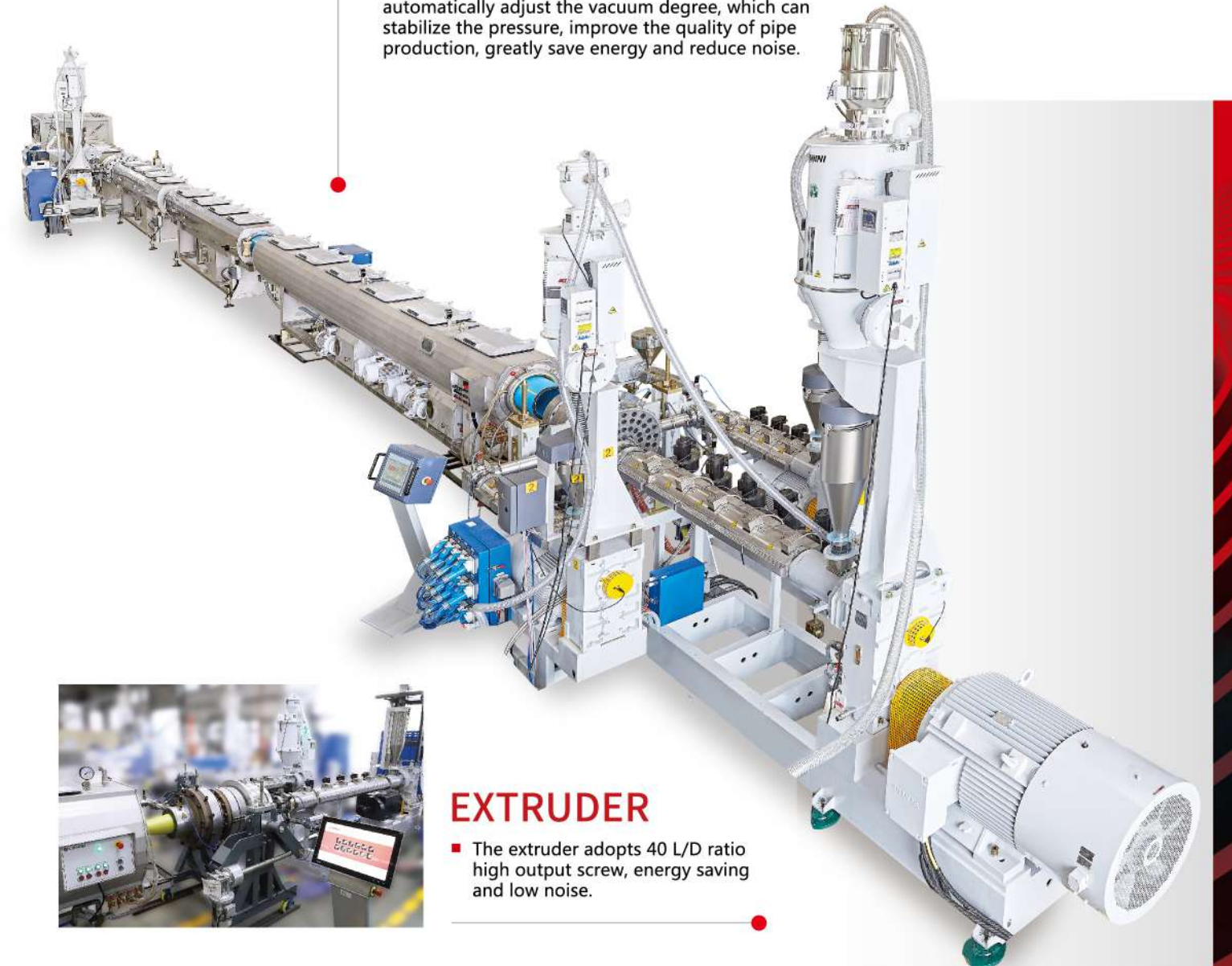


Ø800Five-layer PERT thermal insulating pipe



### VACUUM

- The vacuum adopts negative pressure closed loop to automatically adjust the vacuum degree, which can stabilize the pressure, improve the quality of pipe production, greatly save energy and reduce noise.

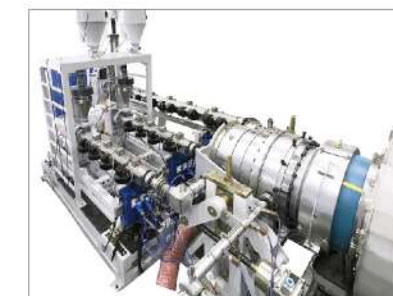


### EXTRUDER

- The extruder adopts 40 L/D ratio high output screw, energy saving and low noise.



- **MOULD** Adopt spiral basket structure, easy maintenance, accurate thickness of each layer.



### EXTERNAL LAYER CO-EXTRUSION



# LSP-PERT

## Multilayer Pipe Line

### MAIN FEATURES

- Dedicated PERT screw design.
- The high speed design of the whole line can meet the production speed of 40m/min.
- Suitable for single layer, multi-layers PERT pipe extrusion production line.



### COILER

- Automatic winding integrates automatic strapping and discharging, high degree of automation.



COILER

CUTTER

HAUL-OFF UNIT

SPRAY TANK



### CUTTER

- Fly cutting, smooth incision, servo reset, accurate length counting.



### HAUL-OFF UNIT

- The haul-off unit adopts permanent magnet synchronous motor to ensure more than 50 times of stable speed range and realize the stable hauling of pipes.



### EXTRUDER

- The extruder adopts 40 L/D ratio high output screw, energy saving and low noise.
- The co-extruder adopts back structure to save space.

### MAIN TECHNICAL PARAMETER

| MODEL                  | PIPE DIAMETER RANG<br>(mm) | EXTRUDER MODEL        | MAX OUTPUT<br>(kg/h) | MAX HAULING SPEED<br>(m/min) | TOTAL INSTALLED POWER<br>(kw) | LINE LENGTH<br>(m) |
|------------------------|----------------------------|-----------------------|----------------------|------------------------------|-------------------------------|--------------------|
| LSP-32PERT-EVOHØ16-Ø32 |                            | LSS65-34x1 LSS40-30x2 | 280                  | 35                           | 140                           | 36                 |
| LSP-32PERT-EVOHØ16-Ø32 |                            | LSS65-34x1 LSS40-30x1 | 280                  | 40                           | 140                           | 36                 |



VACUUM TANK

DIE HEAD

EXTRUDER



### VACUUM

- Vacuum adopts negative pressure closed loop to automatically adjust vacuum degree, stable pressure, improve pipe production quality, low noise and energy saving.



### MOULD

- Adopt spiral structure, simple maintenance, accurate thickness of each layer.
- The setting die adopts sleeve structure, with forced water cooling at the inlet, which is stable at high speed.



# LS-Pex

## Aluminum Plastic Composite Pipe Production Line

### MAIN FEATURES

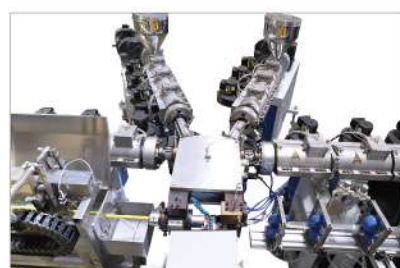
- Unique co-extrusion technique, ensure stable and high quality extrusion
- High quality ultrasonic welding machine guarantees stable performance, perfect welding quality.
- Supplied with aluminum sheet feeding device to ensure continuous and stable production
- Double station winder with automatic winding displacement, tension control, to achieve compact and nice coils of pipe.
- Supplied with Siemens Profibus central control system to achieve good synchronization and stable production.



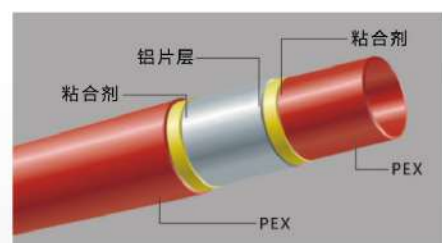
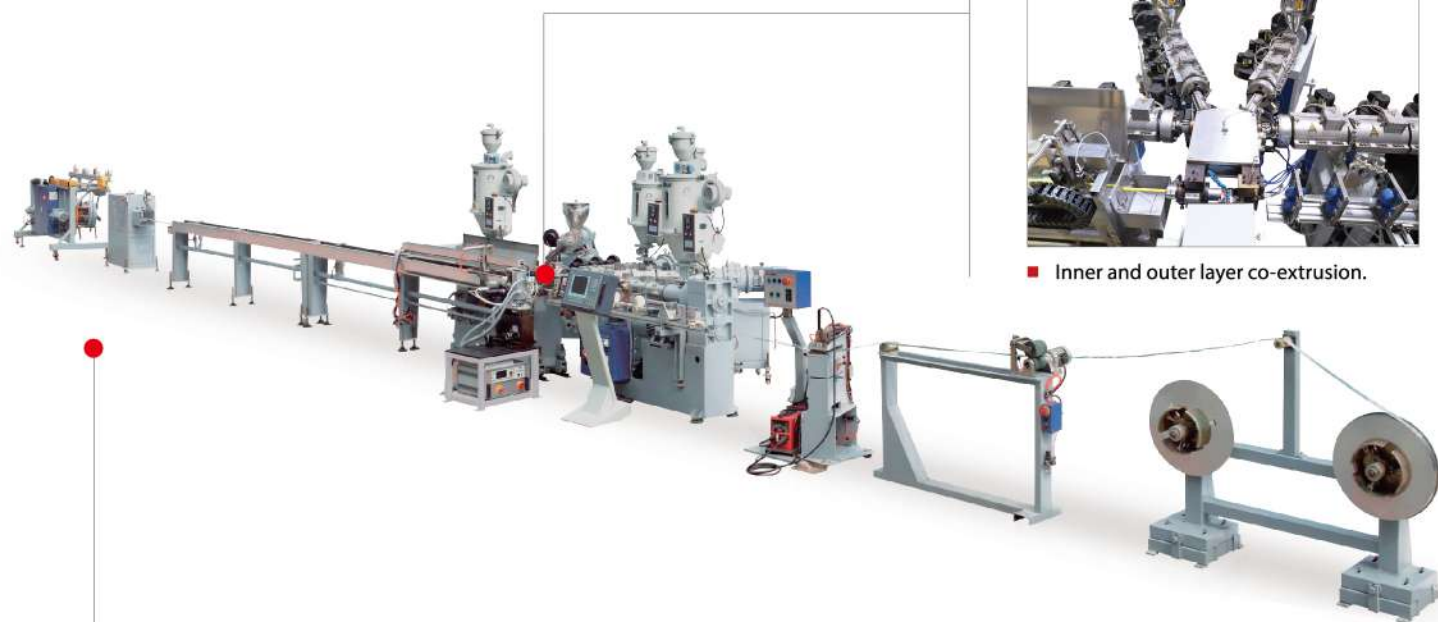
■ PE-Aluminum-PPR Composite Pipe



■ Calibrating rollers of aluminum sheet



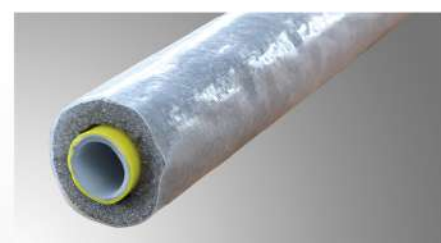
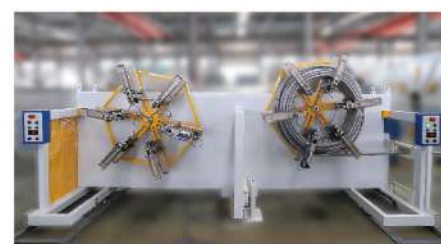
■ Inner and outer layer co-extrusion.



■ structure diagram of polyethylene-aluminum composite pipeline /PAP pipe.



■ PPR fiberglass pipe.



### MAIN TECHNICAL PARAMETER

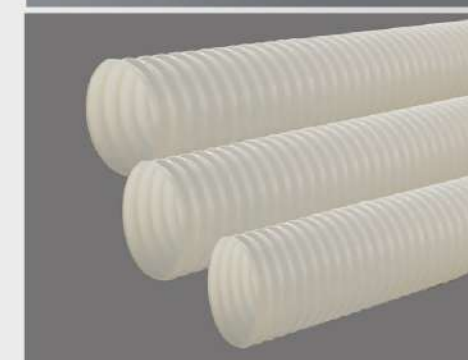
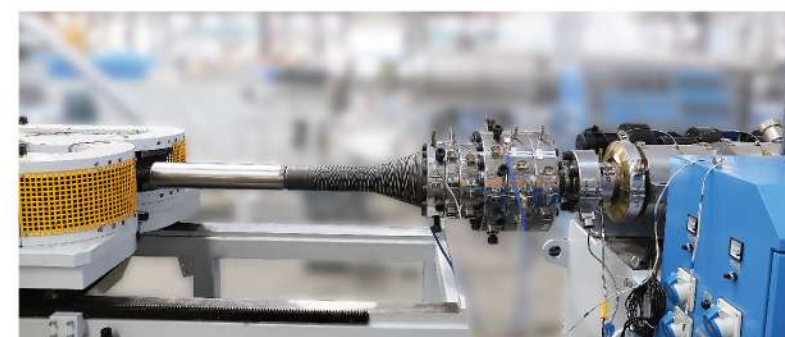
| MODEL   | PIPE DIAMETER RANG (mm) | EXTRUDER MODEL                 | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) |
|---------|-------------------------|--------------------------------|-------------------|---------------------------|----------------------------|
| LSAP-32 | Ø16-Ø32                 | LSS45-34 2set<br>LSS40-25 2set | 200               | 9                         | 130                        |

# LS-Single Wall

## Corrugated Pipe Extrusion Line

### MAIN FEATURES

- Enclosed track design and no chain connected between mold blocks to facilitate the replacement of mold block.
- Mold block is through 40Cr nitrogen treatment, more wear-resistant, durable.
- Pipe is forming by air pressure.
- Corrugator is with protection device for power cut off and axis broke off, the corrugator with auto set back to disconnect the mold block and machine head function.
- Equipped with double-station winder.



### MAIN TECHNICAL PARAMETER

| MODEL      | PIPE DIAMETER RANG (mm) | EXTRUDER MODEL | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) | LINE LENGTH (m) |
|------------|-------------------------|----------------|-------------------|---------------------------|----------------------------|-----------------|
| LSBP-50PE  | Ø16-Ø50                 | LSS65-30       | 120               | 25                        | 75                         | 25              |
| LSBP-50PVC | Ø16-Ø50                 | LSE-55         | 180               | 25                        | 70                         | 25              |



# LS-Double Wall

## Corrugated Pipe Extrusion Line

### MAIN FEATURES

- Shuttle drive design, vacuum forming system, adopts Siemens control system, more accurate control.
- Pipe vacuum forming.
- The forming mould block adopts water cooling with good cooling effect.
- The water jacket is made of aluminum alloy electroplating,better heat transfer performance.



CUTTING MACHINE



SPRAY TANK

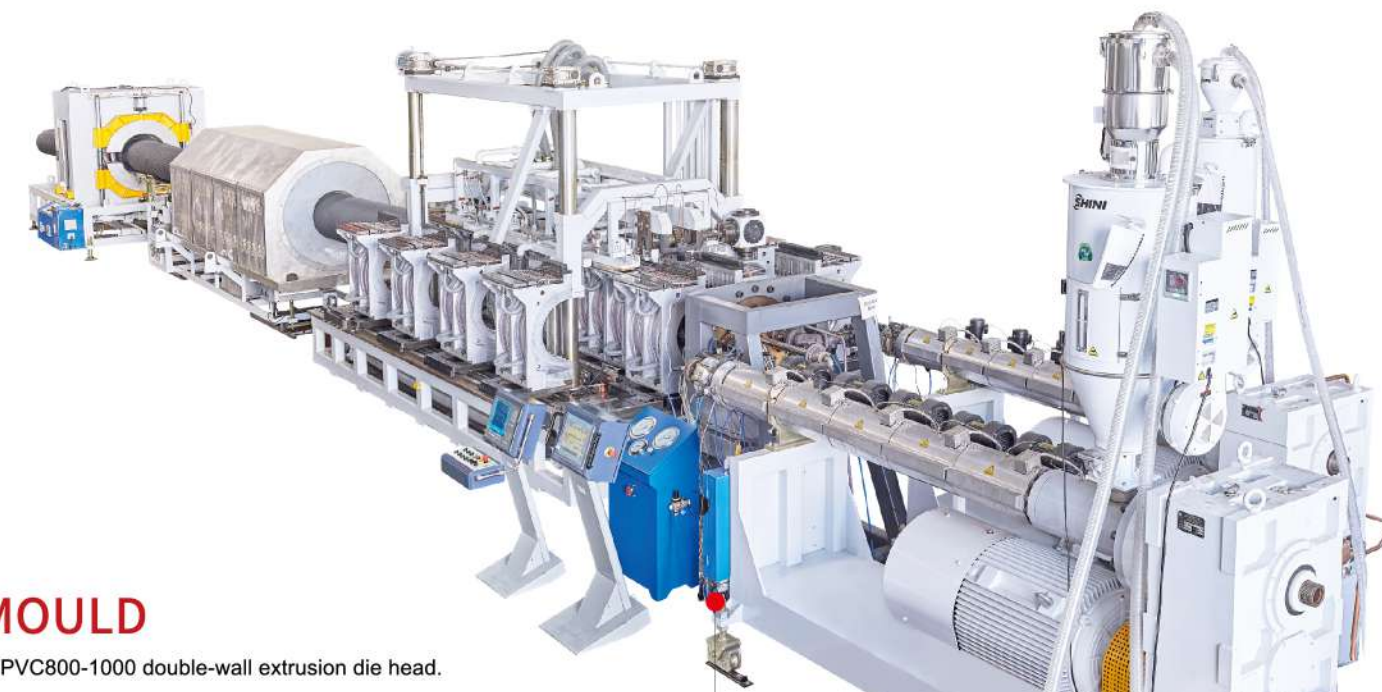


CUTTER

COOLING TANK

### MAIN TECHNICAL PARAMETER

| MODEL        | PRODUCT SERIES (mm) | EXTRUDER MODEL           | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | TOTAL INSTALLED POWER (kw) | LINE LENGTH (m) |
|--------------|---------------------|--------------------------|-------------------|---------------------------|----------------------------|-----------------|
| LSBP-250PE   | Ø75 - Ø 250         | LSS-80-34<br>LSS-65-34   | 670               | 5                         | 380                        | 25              |
| LSBP-500PE   | Ø160-Ø 500          | LSS-100-34<br>LSS-80-34  | 1170              | 3.5                       | 530                        | 28              |
| LSBP-800PE   | Ø400-Ø 800          | LSS-100-34<br>LSS-80-34  | 1170              | 2.5                       | 650                        | 40              |
| LSBP-1000PE  | Ø500-Ø 1000         | LSS-150-34<br>LSS-100-34 | 2050              | 1.5                       | 830                        | 40              |
| LSBP-160PVC  | Ø110-Ø160           | LSE-65                   | 280               | 5                         | 140                        | 30              |
| LSBP-500PVC  | Ø200-Ø500           | LSE-92                   | 750               | 4.5                       | 300                        | 30              |
| LSBP-1000PVC | Ø630-Ø1000          | LSE-95                   | 1000              | 1                         | 485                        | 36              |



### MOULD

- PVC800-1000 double-wall extrusion die head.



CORRUGATOR

DIE HEAD

EXTRUDER

### ONLINE INJECTION SOCKET





# LS-PVC Soft

## Hose Extrusion Line



### MAIN FEATURES

- Simplified structure and convenient operation.
- The produced hose is in high grade of transparent, with bright surface.
- Liansu offers transparent hose, garden net pipe, gas hose, water hose, reinforced hose and steel spiral hose.

### COOLING



### CO-EXTRUSION



### PRODUCTS



# LS-HDPE

## Spiral Cable Duct Production Line



### MAIN FEATURES

- Separate type and mixing head screw structure make better plastication and mixing effect.
- Inner layer is silicon co-extrusion, so anti-electromagnetic interference for the pipe is available.
- External pipe single-wall spiral structure makes the pipe anti-bending and compression resistant.



### MAIN TECHNICAL PARAMETER

| MODEL     | EXTRUDER MODEL                 | MAX OUTPUT<br>(kg/h) | TOTAL INSTALLED POWER<br>(kw) | LINE LENGTH<br>(m) |
|-----------|--------------------------------|----------------------|-------------------------------|--------------------|
| LSP110-PE | LSS65-34 2set<br>LSS45-30 1set | 400-500              | 260                           | 45X8X4             |



# LS-Double Wall

## Spiral Pipe Production Line

### MAIN FEATURES

- Easier exchange of spiral head.
- Spiral head actuated by distribution gearbox connecting with universal joint, with more stable transmission effect.
- Cutting device with internal and external thread cutting, so that the production of the pipe connection is more convenient, meanwhile to enlarge the forming unit's production span; accurate synchronization counting to ensure accurate automatic synchronization cutting.



### MAIN TECHNICAL PARAMETER

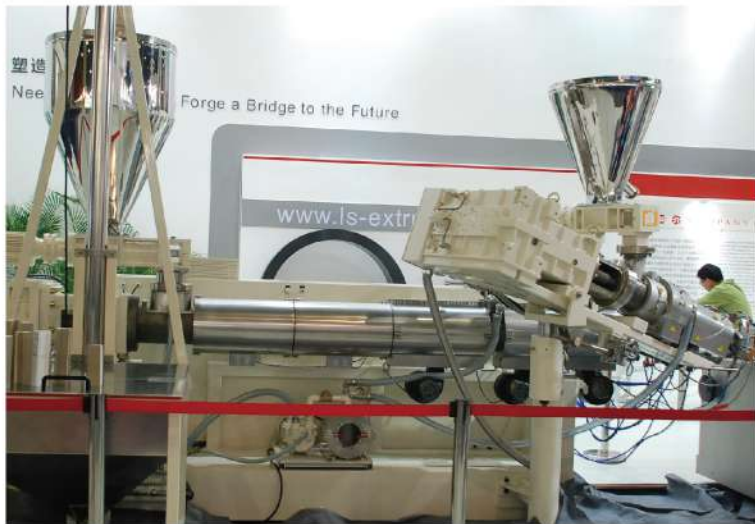
| MODEL     | PIPE DIAMETER RANG (m) | EXTRUDER MODEL        | TOTAL INSTALLED POWER (kw) | MAX OUTPUT (kg/h) |
|-----------|------------------------|-----------------------|----------------------------|-------------------|
| LSWP-800  | Ø200-Ø800              | LSS-65X35, LSS-65X30  | 250                        | 470               |
| LSWP-1200 | Ø400-Ø1200             | LSS-80X34, LSS-65X30  | 300                        | 540               |
| LSWP-1800 | Ø800-Ø1800             | LSS-100X34, LSS-65X34 | 450                        | 1000              |
| LSWP-2400 | Ø1400-Ø2400            | LSS-100X34, LSS-65X34 | 470                        | 1000              |
| LSWP-3000 | Ø2000-Ø3000            | LSS-120X34, LSS-80X34 | 580                        | 1420              |

# LS-Conical

## Twin Screw Extruder

### MAIN FEATURES

- Available material:PVC compound
- Optimized screw design, high output, good plasticization, suitable for different formulations of PVC mixture extrusion, extruder is equipped with permanent magnet servo motor, energy saving and efficient.
- It can be matched with the color mixing mechanism of online weight-loss balance to facilitate the switching of different color materials.
- PLC or PLC+data acquisition and analysis system can be selected as control system.



### MAIN TECHNICAL PARAMETER

| MODEL     | MOTOR POWER (kw) | TOTAL INSTALLED POWER (kw) | PVC OUTPUT (kg/h) |
|-----------|------------------|----------------------------|-------------------|
| LSE45/97  | 18.5             | 36                         | 120               |
| LSE55/110 | 30               | 62                         | 230               |
| LSE65/132 | 37               | 75                         | 350               |
| LSE80/156 | 75               | 128                        | 550               |
| LSE80/172 | 75               | 128                        | 600               |
| LSE92/188 | 110              | 193                        | 820               |
| LSE95/191 | 132              | 215                        | 1050              |



# LS-Parallel

## Twin-Screw Extruder

### MAIN FEATURES

- For different products, different L/D ratio screw can be selected. The screw with large 36 L/D ratio is suitable for the production of national standard pipes and profiles. The extruder is equipped with permanent magnet servo motor, which is energy-saving and efficient.
- It can be matched with the pigment mixing mechanism of online weight-loss balance to facilitate the switching of different color materials.
- PLC or PLC+data acquisition and analysis system can be selected as control system.



### MAIN TECHNICAL PARAMETER

| MODEL      | MOTOR POWER (kw) | TOTAL POWER (kw) | LARGEST PRODUCTION (kg/h) | PIPE DEDICATED |
|------------|------------------|------------------|---------------------------|----------------|
| LSPD75-32  | 45               | 78               | 350                       |                |
| LSPD75-36  | 55               | 95               | 500                       |                |
| LSPD93-32  | 55               | 125              | 500                       |                |
| LSPD93-36  | 75               | 135              | 750                       |                |
| LSPD114-32 | 108              | 108              | 1000-1200                 |                |



# LS-Single

## Screw Extruder

### MAIN FEATURES

- Available material: PP/PPR, HDPE, PC, granular PVC.
- Different specifications and L/D ratio match the extrusion production demand of different output and materials
- Screw large 40 L/D ratio series extruder, high output, stable melt temperature, equipped with permanent magnet servo motor, energy saving.
- PLC or PLC+data acquisition and analysis system can be selected as control system.



40D Single Screw Extruder

### MAIN TECHNICAL PARAMETER

| MODEL     | HDPE OUTPUT (kg/h) | MOTOR POWER (kw) |
|-----------|--------------------|------------------|
| LSS30-25  | 1.5                | 1.1              |
| LSS30-25B | 4.5                | 2.2              |
| LSS45-30  | 30~40              | 15               |
| LSS65-30  | 120                | 37               |
| LSS65-34  | 250                | 75               |
| LSS65-35  | 350                | 90               |
| LSS80-34  | 420                | 110              |
| LSS80-35  | 540                | 132              |
| LSS100-34 | 750                | 200              |
| LSS120-33 | 1000               | 250              |
| LSS150-34 | 1200               | 355              |

| MODEL     | HDPE OUTPUT (kg/h) | MOTOR POWER (kw) |
|-----------|--------------------|------------------|
| LSS50-40  | 300~340            | 75               |
| LSS65-40  | 520~550            | 132              |
| LSS80-40  | 820~870            | 200              |
| LSS100-40 | 1150~1200          | 280              |
| LSS120-40 | 1300~1400          | 355              |





# LS-PVC

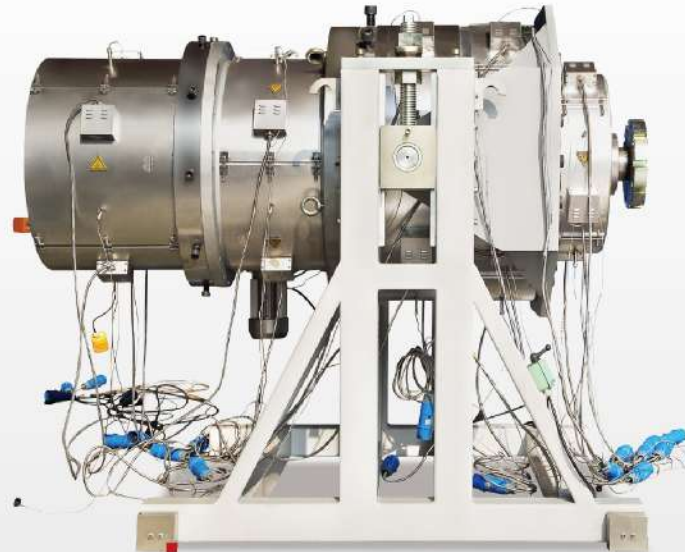
## Pipe Head

### MAIN FEATURES

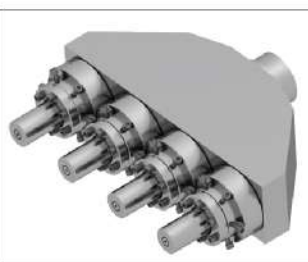
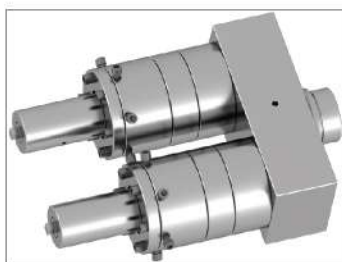
- Liansu develops PVC single layer and multilayer pipe heads, Max die head upto.Ø1000mm PVC single layer pipe , .Reasonable compression ratio design guarantees good plasticizing effect.
- Easy dismounting and mounting of the die head structure , guarantees the efficiency production.
- Communication calole duct mould.
- Different kinds of profile mould.



Ø1000PVC die head



PVC-800

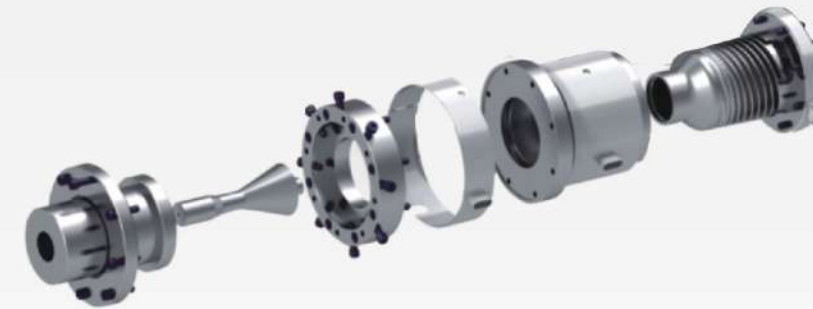


# LS-HDPE

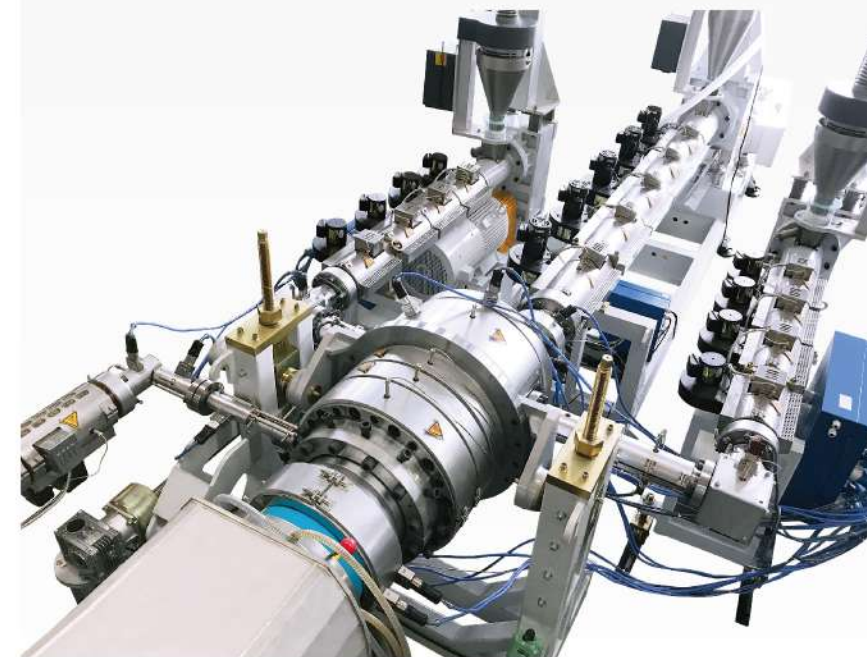
## Single layer & Multilayer Pipe Head

### MAIN FEATURES

- Based on the spiral distributing principle, the PE pipe die head can meet the pipe of different O.D. and wall thickness from 10 to 1600mm. Adopting special spiral distributor design and melt flow, which can effectively protect the features of the raw material during processing while shortening the cleaning time of the die head.



Single layer pipe die head structure



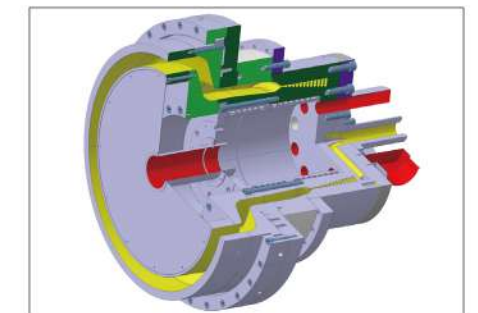
Structure of coextrusion die head for multi-layer pipe

Base on the market requirement, Liansu offer the extrusion mould as below:

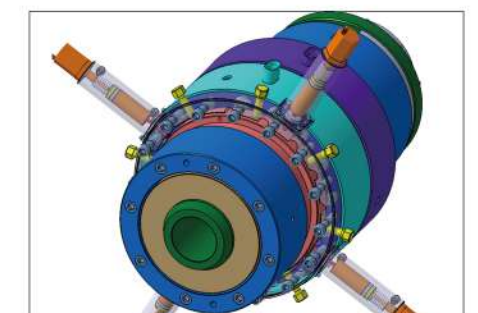
- Ø16- Ø1600 pressure sewage solid pipe mould.
- Ø63-Ø1200 double wall corrugated pipe mould.
- Ø16-Ø250 single-wall corrugated pipe mould.



MOLD-PE-SPRICAL HEAD



SINGLE-LAYER MOLD



PE-MULTI-LAYER-HEAD



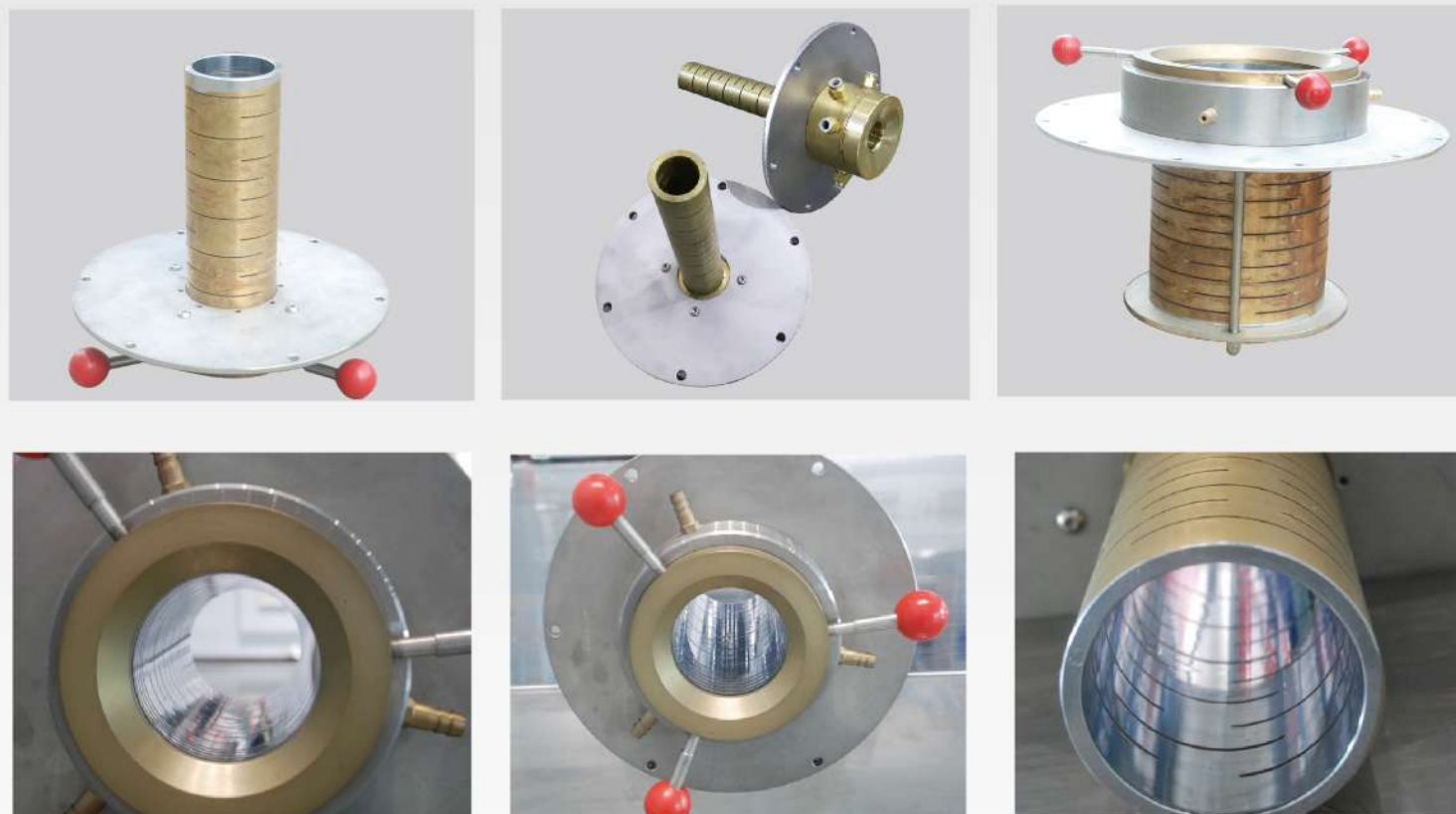
Pipe head with sensor



# Calibrating

## MAIN FEATURES

- The vacuum calibration system, which is developed by Liansu, allows the extrusion of pipes with dimensions in accordance with the international standard. The vacuum calibrator that transmits the heat excellently as the sleeve is highly wear-resistant.

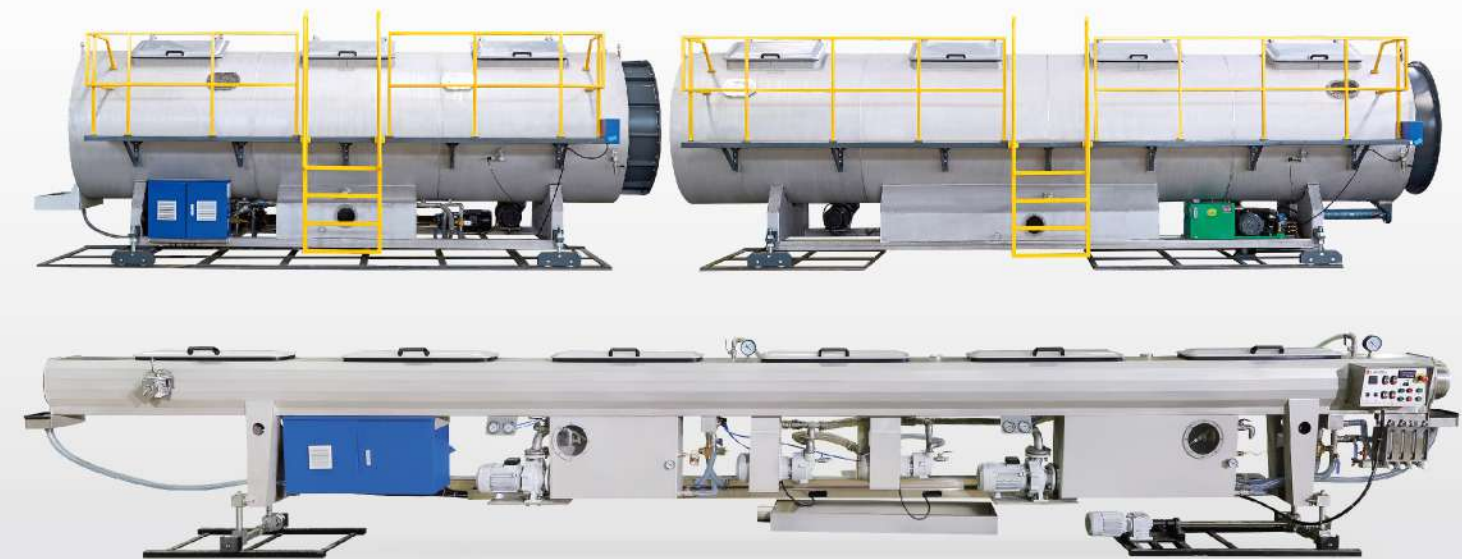


# LS-Tank

Vacuum Energy Saving Control

## MAIN FEATURES

- The whole tank is made of stainless steel 304, durable and reliable, and can be moved forward and backward by electric control.
- Large capacity filter screen to ensure the cleanliness of spray water.
- Vacuum adopts negative pressure closed loop to automatically adjust vacuum degree, improve pipe production quality, reduce noise by more than 30dB, save energy by 30~85%.
- The pipeline is welded with stainless steel elbow to reduce the pressure loss of water pump.



## VACUUM AUTOMATIC CONTROL

- It adopts vacuum negative pressure closed-loop control, HMI sets the pressure required for pipe sizing, starts the vacuum pump to send signals to inverter through the negative pressure sensor, automatically adjusts the speed of the vacuum pump, quickly achieves the constant negative pressure without manual pressure relief, achieves the energy-saving effect and improves the production stability.

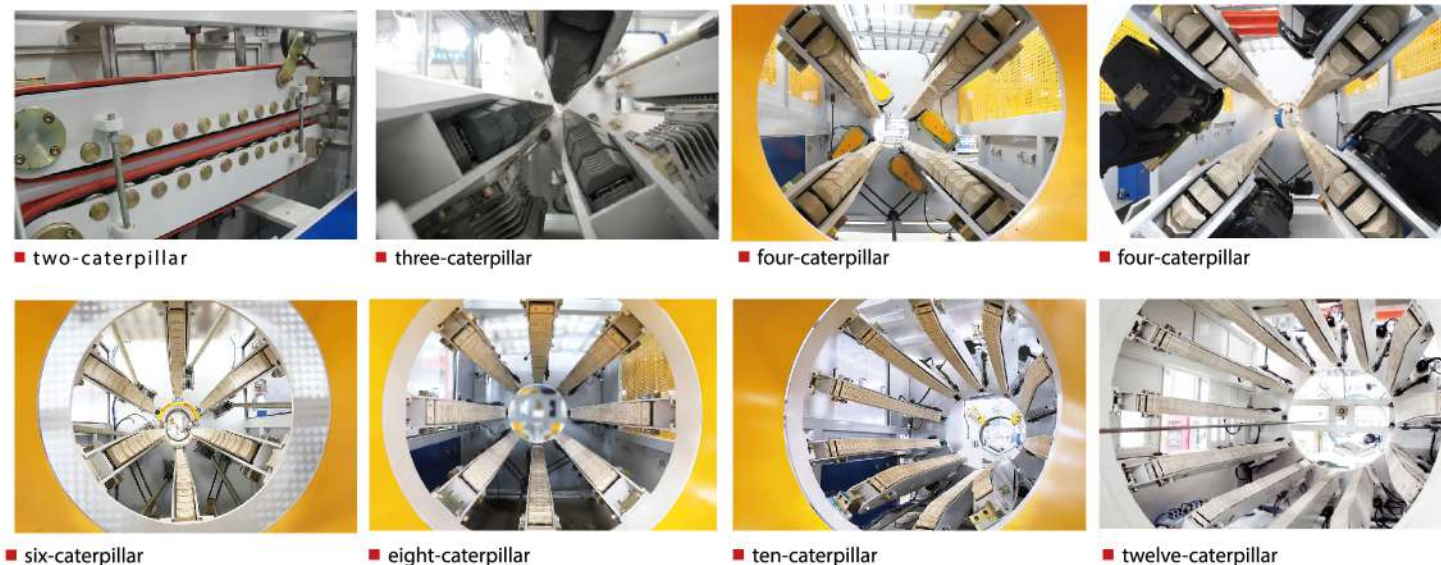




# LS-Haul Off Unit

## MAIN FEATURES

- According to the pipe of different sizes and speed requirements, we have also developed multi caterpillar and large speed ratio hauling mechanism, such as two-caterpillar haul-off unit, three-caterpillar haul-off unit, four-caterpillar haul-off unit, six-caterpillar haul-off unit, eight-caterpillar haul-off unit and ten-caterpillar haul-off unit.
- The whole series of haul-off unit adopt the scheme of "one pull more" each caterpillar independent permanent magnet synchronous servo motor, which can ensure more than 50 times of stable large speed regulation range, and can meet the fast hauling of small-sized pipe and slow hauling of large-sized thick wall pipe at the same time, with stable speed and strict synchronization of each caterpillar.
- Optional pre hauling device (winch).



■ two-caterpillar

■ three-caterpillar

■ four-caterpillar

■ four-caterpillar

■ six-caterpillar

■ eight-caterpillar

■ ten-caterpillar

■ twelve-caterpillar

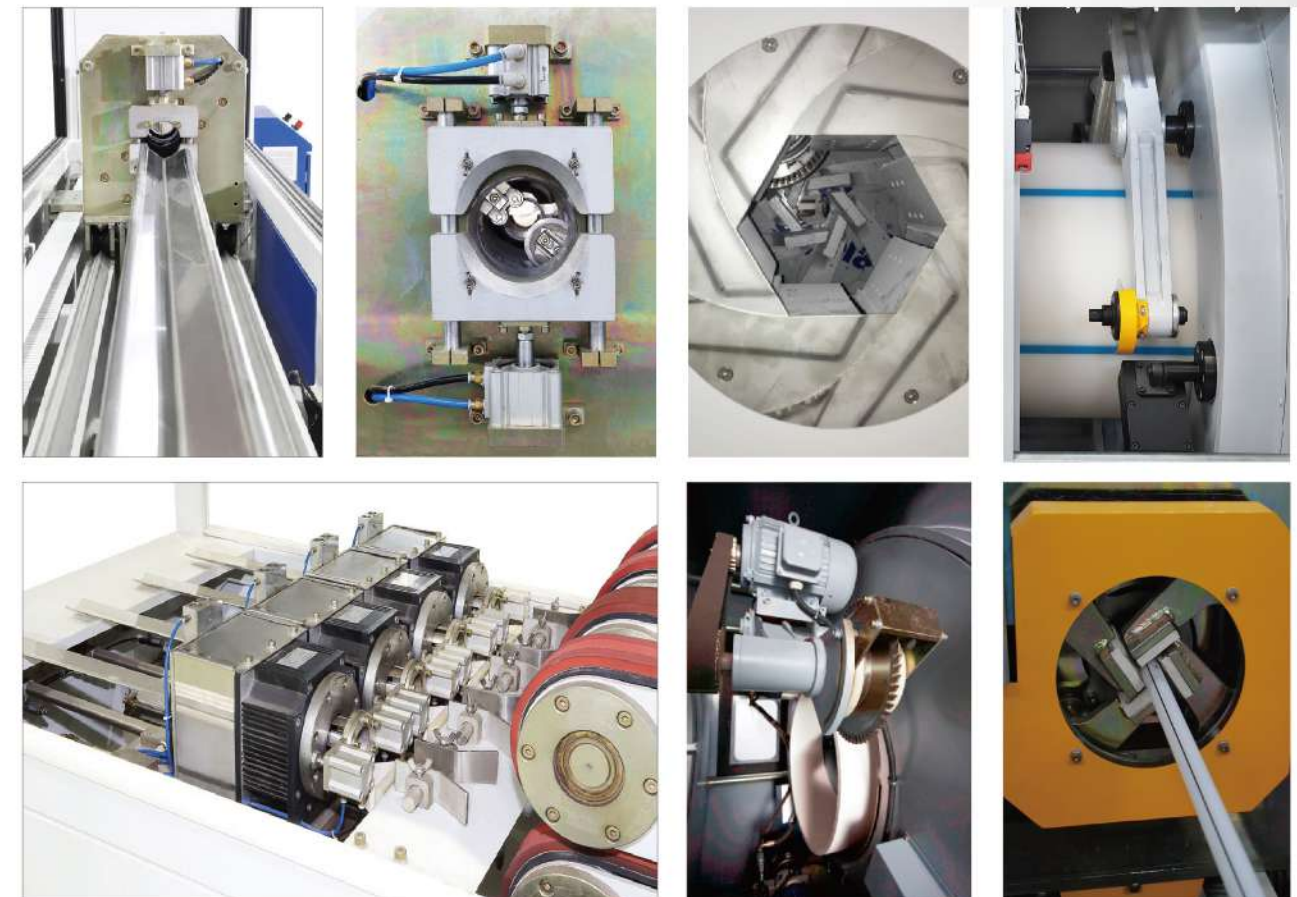
# LS-Cutting

## MAIN FEATURES

- HDPE pipe specification from 20-1200MM are all adopt full automatic swarfless cutting mechanism which can full-automatic variable diameter. If change the specification ,just need set the 'pipe diameter' and 'pipe wall thickness' on the touchable screen, that is 'one key' to adjusting automatically; cutting blade position, 'feeding depth', 'pipe center' and other position are foolproof operation. Bid farewell to the traditional specifications of many complex adjustments, improve the adjusting time for specifications, improve the service life of cutting tools!

### Features:

- Adopt the double blade structure which is the 'circular blade'+ 'sharp blade' combination, to realize the perfect cutting of the pipe wall thickness exceed the 100mm with the smooth, no inside and outside flanging and swarfless!





# LS-Coiler

## MAIN FEATURES

- It can provide a variety of winding schemes according to the different speed of the production line.
- The winding and displacement of the whole series of winders adopt servo drive scheme, with good displacement effect and stable tension control.
- PP belt automatic packing and automatic discharging, high degree of automation, production speed up to 50m/min.
- Reliable tension control automatically matches different line speed.



■ PE Automatic coiler with on line strapping

## MAIN TECHNICAL PARAMETER

| MODEL      | PRODUCT SERIES (mm) | COILER ID (mm) | COILER THICKNESS(mm) | COILER WIDTH (mm) | POWER OF MAIN MOTOR (kw) |
|------------|---------------------|----------------|----------------------|-------------------|--------------------------|
| LSPJ32BPE  | Ø16-Ø32             | Ø400-Ø650      | 230                  | 300               | 2.9X2                    |
| LSPJ-63DPE | Ø16-Ø63             | Ø700-Ø1800     | 400                  | 510               | 5.5                      |
| LSPJ-110PE | Ø63-Ø110            | Ø840-Ø2600     | 550                  | 700               | 10.5X2                   |
| LSPJ-160PE | Ø50-Ø160            | Ø1000-Ø3200    | 480                  | 600               | 10.5                     |

# LS-Socketing Machine

## MAIN FEATURES

- Socket machine series, from diameter 16 to diameter 1000 PVC pipe socket machine has been mature in the market.
- The whole series of socket machine can be adapted online and offline, and there are many types to choose from: flat socket, U-shaped socket, rectangular socket and rubber ring socket.
- Diameter 16~32 small pipe socket machine series, there are 2 stations, 4 stations and 10 stations can be selected, and can be equipped with packing machine for automatic online expanding and packing.







# Standard

ASTM standard ASTM D1784-D1785, ASTM D2265.

| Nominalsizeinch | Outsidediameter<br>(mm) |        | Wallthickness(mm)          |       |                         |       |                                |      |
|-----------------|-------------------------|--------|----------------------------|-------|-------------------------|-------|--------------------------------|------|
|                 |                         |        | ASTM D 1784/85 schedule 40 |       | ASTM D 1785 schedule 80 |       | ASTM D2665(drain, waste, vent) |      |
|                 | Min                     | Max    | Min                        | Max   | Min                     | Max   | Min                            | Max  |
| 1⁄2             | 21.24                   | 21.44  | 2.77                       | 3.28  | 3.73                    | 4.24  |                                |      |
| 3⁄4             | 26.57                   | 26.77  | 2.87                       | 3.38  | 3.91                    | 4.42  |                                |      |
| 1               | 33.27                   | 33.53  | 3.38                       | 3.89  | 4.55                    | 5.08  |                                |      |
| 1 1⁄4           | 42.03                   | 42.29  | 3.56                       | 4.07  | 4.85                    | 5.43  | 3.56                           | 4.07 |
| 1 1⁄2           | 48.11                   | 48.41  | 3.68                       | 4.19  | 5.08                    | 5.69  | 3.68                           | 4.19 |
| 2               | 60.17                   | 60.47  | 3.91                       | 4.42  | 5.54                    | 6.20  | 3.91                           | 4.42 |
| 2 1⁄2           | 72.84                   | 73.20  | 5.16                       | 5.77  | 7.01                    | 7.85  |                                |      |
| 3               | 88.70                   | 89.10  | 5.49                       | 6.15  | 7.62                    | 8.53  | 5.49                           | 6.15 |
| 4               | 114.07                  | 114.53 | 6.02                       | 6.73  | 8.56                    | 9.58  | 6.02                           | 6.73 |
| 5               | 141.05                  | 141.55 | 6.55                       | 7.34  | 9.52                    | 10.66 |                                |      |
| 6               | 168.00                  | 168.56 | 7.11                       | 7.97  |                         |       |                                |      |
| 8               | 218.70                  | 219.46 | 8.18                       | 9.17  |                         |       |                                |      |
| 10              |                         |        | 9.27                       | 10.39 |                         |       |                                |      |

UPVC pipes according to SAS 14-15/1998 and DIN8062 standards.

| Nominal<br>O.D.<br>mm | Tolerance<br>on O.D.<br>(mm) | Class 1<br>2.5 bar           |                           | Class 2<br>4 bar             |                           | Class 3<br>6 bar             |                           | Class 4<br>10 bar            |                           | Class 5<br>16 bar            |                           |
|-----------------------|------------------------------|------------------------------|---------------------------|------------------------------|---------------------------|------------------------------|---------------------------|------------------------------|---------------------------|------------------------------|---------------------------|
|                       |                              | Nominal<br>thickness<br>(mm) | Nominal<br>weight<br>(mm) | Nominal<br>thickness<br>(mm) | Nominal<br>weight<br>(mm) | Nominal<br>thickness<br>(mm) | Nominal<br>weight<br>(mm) | Nominal<br>thickness<br>(mm) | Nominal<br>weight<br>(mm) | Nominal<br>thickness<br>(mm) | Nominal<br>weight<br>(mm) |
| 16                    | +0.2                         |                              |                           |                              |                           |                              |                           |                              |                           | 1.2                          | 0.09                      |
| 20                    | +0.2                         |                              |                           |                              |                           |                              |                           |                              |                           | 1.5                          | 0.137                     |
| 25                    | +0.2                         |                              |                           |                              |                           |                              |                           | 1.5                          | 0.174                     | 1.9                          | 0.212                     |
| 32                    | +0.2                         |                              |                           |                              |                           |                              |                           | 1.8                          | 0.264                     | 2.4                          | 0.342                     |
| 40                    | +0.2                         |                              |                           |                              |                           | 1.8                          | 0.344                     | 1.9                          | 0.350                     | 3.0                          | 0.525                     |
| 50                    | +0.2                         |                              |                           |                              |                           | 1.8                          | 0.422                     | 2.4                          | 0.552                     | 3.7                          | 0.809                     |
| 63                    | +0.2                         |                              |                           |                              |                           | 1.9                          | 0.562                     | 3.0                          | 0.854                     | 4.7                          | 1.29                      |
| 75                    | +0.3                         |                              |                           | 1.8                          | 0.642                     | 2.2                          | 0.782                     | 3.6                          | 1.22                      | 5.6                          | 1.82                      |
| 90                    | +0.3                         |                              |                           | 1.8                          | 0.774                     | 2.7                          | 1.13                      | 4.3                          | 1.75                      | 6.7                          | 2.61                      |
| 110                   | +0.3                         | 1.8                          | 0.950                     | 2.2                          | 1.16                      | 3.2                          | 1.64                      | 5.3                          | 2.61                      | 8.2                          | 3.90                      |
| 125                   | +0.3                         | 1.8                          | 1.08                      | 2.5                          | 1.48                      | 3.7                          | 2.13                      | 6.0                          | 3.34                      | 9.3                          | 5.01                      |
| 140                   | +0.4                         | 1.8                          | 1.21                      | 2.8                          | 1.84                      | 4.1                          | 2.65                      | 6.7                          | 4.18                      | 10.4                         | 6.27                      |
| 160                   | +0.4                         | 1.8                          | 1.39                      | 3.2                          | 2.41                      | 4.7                          | 3.44                      | 7.7                          | 5.47                      | 11.9                         | 8.17                      |
| 200                   | +0.4                         | 1.8                          | 1.74                      | 4.0                          | 3.70                      | 5.9                          | 5.37                      | 9.6                          | 8.51                      | 14.9                         | 12.8                      |
| 225                   | +0.5                         | 1.8                          | 1.96                      | 4.5                          | 470                       | 6.6                          | 6.76                      | 10.8                         | 10.8                      | 16.7                         | 16.1                      |
| 250                   | +0.5                         | 2.0                          | 2.40                      | 4.9                          | 565                       | 7.3                          | 8.31                      | 11.9                         | 13.2                      | 18.6                         | 19.9                      |
| 280                   | +0.6                         | 2.3                          | 3.11                      | 5.5                          | 711                       | 8.2                          | 10.40                     | 13.40                        | 16.60                     | 20.8                         | 24.9                      |
| 315                   | +0.6                         | 205                          | 3.78                      | 6.2                          | 9.02                      | 9.2                          | 13.2                      | 15.0                         | 20.9                      | 23.4                         | 31.5                      |
| 400                   | +0.7                         | 3.2                          | 6.10                      | 7.9                          | 145                       | 11.7                         | 21.1                      | 19.1                         | 33.7                      | 29.7                         | 50.8                      |

GB/T 10002.1-2006 PVC-U plastic pipe.

| OD  | OD tolerance |        | Thickness   |            |            |             |            |            |            |  |
|-----|--------------|--------|-------------|------------|------------|-------------|------------|------------|------------|--|
|     | (mm)         |        | (mm)        |            |            |             |            |            |            |  |
|     | Max          | Min    | 0.63<br>MPa | 0.8<br>MPa | 1.0<br>MPa | 1.25<br>MPa | 1.6<br>MPa | 2.0<br>MPa | 2.5<br>MPa |  |
| 20  | 20.10        | 20.25  |             |            |            |             |            | 2.0        | 2.3        |  |
| 25  | 25.10        | 25.25  |             |            |            |             | 2.0        | 2.3        | 2.8        |  |
| 32  | 32.10        | 32.25  |             |            |            | 2.0         | 2.4        | 2.9        | 3.6        |  |
| 40  | 40.10        | 40.25  |             |            | 2.0        | 2.4         | 3.0        | 3.7        | 4.5        |  |
| 50  | 50.10        | 50.25  |             | 2.0        | 2.4        | 3.0         | 3.7        | 4.6        | 5.6        |  |
| 63  | 63.10        | 63.25  | 2.0         | 2.5        | 3.0        | 3.8         | 4.7        | 5.8        | 7.1        |  |
| 75  | 75.10        | 75.25  | 2.3         | 2.9        | 3.6        | 4.5         | 5.6        | 6.9        | 8.4        |  |
| 90  | 90.10        | 90.25  | 2.8         | 3.5        | 4.3        | 5.4         | 6.7        | 8.2        | 10.1       |  |
| 110 | 110.10       | 110.30 | 2.7         | 3.4        | 4.2        | 5.3         | 6.6        | 8.1        | 10.0       |  |
| 125 | 125.10       | 125.30 | 3.1         | 3.9        | 4.8        | 6.0         | 7.4        | 9.2        | 11.4       |  |
| 140 | 140.10       | 140.30 | 3.5         | 4.3        | 5.4        | 6.7         | 8.3        | 10.3       | 12.7       |  |
| 160 | 160.15       | 160.40 | 4.0         | 4.9        | 6.2        | 7.7         | 9.5        | 11.8       | 14.6       |  |
| 200 | 200.15       | 200.40 | 4.9         | 6.2        | 7.7        | 9.6         | 11.9       | 14.7       | 18.2       |  |
| 225 | 225.15       | 225.50 | 5.5         | 6.9        | 8.6        | 10.8        | 13.4       | 16.6       |            |  |
| 250 | 250.15       | 250.60 | 6.2         | 7.7        | 9.6        | 11.9        | 14.8       | 18.4       |            |  |
| 315 | 315.15       | 315.70 | 7.7         | 9.7        | 12.1       | 15.0        | 18.7       | 23.2       |            |  |
| 355 | 355.15       | 355.70 | 8.7         | 10.9       | 13.6       | 16.9        | 21.1       | 26.1       |            |  |
| 400 | 400.15       | 400.80 | 9.8         | 12.3       | 15.3       | 19.1        | 23.7       | 29.4       |            |  |
| 500 | 500.15       | 501.00 | 12.3        | 15.3       | 19.1       | 23.9        | 29.7       | 36.8       |            |  |
| 630 | 630.15       | 631.20 | 15.4        | 19.3       | 24.1       | 30.0        |            |            |            |  |

Polyethylen(PE)-PE 63,PE 80,PE 100,PE HD(wall thickness and mass).

Dimensions in millimetres

|              | Pipe series                             |                  |                   |                  |                   |                  |                  |                  |                  |                  |
|--------------|---|------------------|-------------------|------------------|-------------------|------------------|------------------|------------------|------------------|------------------|
|              | SDR 17,6<br>S 8,3                       |                  | SDR 21<br>S 10    |                  | SDR 26<br>S 12,5  |                  | SDR 33<br>S 16   |                  | SDR 41<br>S 20   |                  |
|              | Nominal pressure,PN <sup>a</sup> in bar |                  |                   |                  |                   |                  |                  |                  |                  |                  |
| PE40         | -                                       |                  | PN 3,2            |                  | PN 2,5            |                  | -                |                  | -                |                  |
| PE63         | PN 6                                    |                  | PN 5              |                  | PN 4              |                  | PN 3,2           |                  | PN 2,5           |                  |
| PE80         | -                                       |                  | PN 6 <sup>c</sup> |                  | PN 5              |                  | PN 4             |                  | PN 3,2           |                  |
| PE100        | -                                       |                  | PN 8              |                  | PN 6 <sup>c</sup> |                  | PN 5             |                  | PN 4             |                  |
| Nom.<br>size | Wall thicknesses <sup>b</sup>           |                  |                   |                  |                   |                  |                  |                  |                  |                  |
|              | e <sub>min</sub>                        | e <sub>max</sub> | e <sub>min</sub>  | e <sub>max</sub> | e <sub>min</sub>  | e <sub>max</sub> | e <sub>min</sub> | e <sub>max</sub> | e <sub>min</sub> | e <sub>max</sub> |
| 16           | -                                       | -                | -                 | -                | -                 | -                | -                | -                | -                | -                |
| 20           | -                                       | -                | -                 | -                | -                 | -                | -                | -                | -                | -                |
| 25           | -                                       | -                | -                 | -                | -                 | -                | -                | -                | -                | -                |
| 32           | 2,0 <sup>d</sup>                        | 2,3              | -                 | -                | -                 | -                | -                | -                | -                | -                |
| 40           | 2,3                                     | 2,7              | 2,0 <sup>d</sup>  | 2,3              | -                 | -                | -                | -                | -                | -                |
| 50           | 2,9                                     | 3,3              | 2,4               | 2,8              | 2,0               | 2,3              | -                | -                | -                | -                |
| 63           | 3,6                                     | 4,1              | 3,0               | 3,4              | 2,5               | 2,9              | -                | -                | -                | -                |
| 75           | 4,3                                     | 4,9              | 3,6               | 4,1              | 2,9               | 3,3              | -                | -                | -                | -                |
| 160          | 9,1                                     | 10,2             | 7,7               | 8,6              | 6,2               | 7,0              | -                | -                | -                | -                |
| 180          | 10,2                                    | 11,4             | 8,6               | 9,6              | 6,9               | 7,7              | -                | -                | -                | -                |
| 200          | 11,4                                    | 12,7             | 9,6               | 10,7             | 7,7               | 8,6              | -                | -                | -                | -                |
| 225          | 12,8                                    | 14,2             | 10,8              | 12,0             | 8,6               | 9,6              | -                | -                | -                | -                |
| 250          | 14,2                                    | 15,8             | 11,9              | 13,2             | 9,6               | 10,7             | -                | -                | -                | -                |
| 280          | 15,9                                    | 17,6             | 13,4              | 14,9             | 10,7              | 11,9             | -                | -                | -                | -                |
| 315          | 17,9                                    | 19,8             | 15,0              | 16,6             | 12,1              | 13,5             | 9,7              | 10,8             | 7,7              | 8,6              |
| 355          | 20,1                                    | 22,3             | 16,9              | 18,7             | 13,6              | 15,1             | 10,9             | 12,1             | 8,7              | 9,7              |
| 400          | 22,7                                    | 25,1             | 19,1              | 21,2             | 15,3              | 17,0             | 12,3             | 13,7             | 9,8              | 10,9             |
| 450          | 25,5                                    | 28,2             | 21,5              | 23,8             | 17,2              | 19,1             | 13,8             | 15,3             | 11,0             | 12,2             |
| 500          | 28,3                                    | 31,3             | 23,9              | 26,4             | 19,1              | 21,2             | 15,3             | 17,0             | 12,3             | 13,7             |
| 560          | 31,7                                    | 35,0             | 26,7              | 29,5             | 21,4              | 23,7             | 17,2             | 19,1             | 13,7             | 15,2             |
| 630          | 35,7                                    | 39,4             | 30,0              | 33,1             | 24,1              | 26,7             | 19,3             | 21,4             | 15,4             | 17,1             |
| 710          | 40,2                                    | 44,4             | 33,9              | 37,4             | 27,2              | 30,1             | 21,8             | 24,1             | 17,4             | 19,3             |
| 800          | 45,3                                    | 50,0             | 38,1              | 42,1             | 30,6              | 33,8             | 24,5             | 27,1             | 19,6             | 21,7             |
| 900          | 51,0                                    | 56,2             | 42,9              | 47,3             | 34,4              | 38,3             | 27,6             | 30,5             | 22,0             | 24,3             |
| 1000         | 56,6                                    | 62,4             | 47,7              | 52,6             | 38,2              | 42,2             | 30,6             | 33,5             | 24,5             | 27,1             |
| 1200         | -                                       | -                | 57,2              | 63,1             | 45,9              | 50,6             | 36,7             | 40,5             | 29,4             | 32,5             |
| 1400         | -                                       | -                | -                 | -                | 53,5              | 59,0             | 42,9             | 47,3             | 34,3             | 37,9             |
| 1600         | -                                       | -                | -                 | -                | 61,2              | 67,5             | 49,0             | 54,0             | 39,2             | 43,3             |

a PN values are based on C=1,25.  
b Tolerances in accordance with grade V of ISO 11922-1:1997[1].  
c Actual calculated values are 6,4 bar for PE100 and 6,3 bar for PE80.  
d The calculated value of e<sub>min</sub> (ISO 4065[2]) is rounded up to the nearest value of either 2,0,2,3 or 3,0.This is to satisfy certain national requirements.

|              | Pipe series                             |                  |                  |                  |                  |                  |                  |                  |                   |                  |                  |                  |
|--------------|---|------------------|------------------|------------------|------------------|------------------|------------------|------------------|-------------------|------------------|------------------|------------------|
|              | SDR 6<br>S 2,5                          |                  | SDR 7,4<br>S 3,2 |                  | SDR 9<br>S 4     |                  | SDR 11<br>S 5    |                  | SDR 13,6<br>S 6,3 |                  | SDR 17<br>S 8    |                  |
|              | Nominal pressure,PN <sup>a</sup> in bar |                  |                  |                  |                  |                  |                  |                  |                   |                  |                  |                  |
| PE40         | -                                       |                  | PN 10            |                  | PN 8             |                  | -                |                  | PN 5              |                  | PN 4             |                  |
| PE63         | -                                       |                  | -                |                  | -                |                  | PN 10            |                  | PN 8              |                  | -                |                  |
| PE80         | PN 25                                   |                  | PN 20            |                  | PN 16            |                  | PN 12,5          |                  | PN 10             |                  | PN 8             |                  |
| PE100        | -                                       |                  | PN 25            |                  | PN 20            |                  | PN 16            |                  | PN 12,5           |                  | PN 10            |                  |
| Nom.<br>size | Wall thicknesses <sup>b</sup>           |                  |                  |                  |                  |                  |                  |                  |                   |                  |                  |                  |
|              | e <sub>min</sub>                        | e <sub>max</sub> | e <sub>min</sub> | e <sub>max</sub> | e <sub>min</sub> | e <sub>max</sub> | e <sub>min</sub> | e <sub>max</sub> | e <sub>min</sub>  | e <sub>max</sub> | e <sub>min</sub> | e <sub>max</sub> |
| 16           | 3,0 <sup>c</sup>                        | 3,4              | 2,3 <sup>c</sup> | 2,7              | 2,0 <sup>c</sup> | 2,3              | -                | -                | -                 | -                | -                | -                |
| 20           | 3,4                                     | 3,9              | 3,0 <sup>c</sup> | 3,4              | 2,3              | 2,7              | 2,0 <sup>c</sup> | 2,3              | -                 | -                | -                | -                |
| 25           | 4,2                                     | 4,8              | 2,5              | 4,0              | 3,0 <sup>c</sup> | 3,4              | 2,3              | 2,7              | 2,0 <sup>c</sup>  | 2,3              | -                | -                |
| 32           | 5,4                                     | 6,1              | 4,4              | 5,0              | 3,6              | 4,1              | 3,0 <sup>c</sup> | 3,4              | 2,4               | 2,8              | 2,0 <sup>c</sup> | 2,3              |
| 40           | 6,7                                     | 7,5              | 5,5              | 6,2              | 4,5              | 5,1              | 3,7              | 4,2              | 3,0               | 3,5              | 2,4              | 2,8              |
| 50           | 8,3                                     | 9,3              | 6,9              | 7,7              | 5,6              | 6,3              | 4,6              | 5,2              | 3,7               | 4,2              | 3,0              | 3,4              |
| 63           | 10,5                                    | 11,7             | 8,6              | 9,6              | 7,1              | 8,0              | 5,8              | 6,5              | 4,7               | 5,3              | 3,8              | 4,3              |
| 75           | 12,5                                    | 13,9             | 10,3             | 11,5             | ,8,4             | 9,4              | 6,8              | 7,6              | 5,6               | 6,3              | 4,5              | 5,1              |
| 90           | 15,0                                    | 16,7             | 12,3             | 13,7             | 10,1             | 11,3             | 8,2              | 9,2              | 6,7               | 7,5              | 5,4              | 6,1              |
| 110          | 18,3                                    | 20,3             | 15,1             | 16,8             | 12,3             | 13,7             | 10,0             | 11,1             | 8,1               | 9,1              | 6,6              | 7,4              |
| 125          | 20,8                                    | 23,0             | 17,1             | 19,0             | 14,0             | 15,6             | 11,4             | 12,7             | 9,2               | 10,3             | 7,4              | 8,3              |
| 140          | 23,3                                    | 25,8             | 19,2             | 21,3             | 15,7             | 17,4             | 12,7             | 14,1             | 10,3              | 11,5             | 8,3              | 9,3              |
| 160          | 26,6                                    | 29,4             | 21,9             | 24,2             | 17,9             | 19,8             | 14,6             | 16,2             | 11,8              | 13,1             | 9,5              | 10,6             |
| 180          | 29,9                                    | 33,0             | 24,6             | 27,2             | 20,1             | 22,3             | 16,4             | 18,2             | 13,3              | 14,8             | 10,7             | 11,9             |
| 200          | 33,2                                    | 36,7             | 27,4             | 30,3             | 22,4             | 24,8             | 18,2             | 20,2             | 14,7              | 16,3             | 11,9             | 13,2             |
| 225          | 37,4                                    | 41,3             | 30,8             | 34,0             | 25,2             | 27,9             | 20,5             | 22,7             | 16,6              | 18,4             | 13,4             | 14,9             |
| 250          | 41,5                                    | 45,8             | 34,2             | 37,8             | 27,9             | 30,8             | 22,7             | 25,1             | 18,4              | 20,4             | 14,8             | 16,4             |
| 280          | 46,5                                    | 51,3             | 38,3             | 42,3             | 31,3             | 34,6             | 25,4             | 28,1             | 20,6              | 22,8             | 16,6             | 18,4             |
| 315          | 52,3                                    | 57,7             | 43,1             | 47,6             | 35,2             | 38,9             | 28,6             | 31,6             | 23,2              | 25,7             | 18,7             | 20,7             |
| 355          | 59,0                                    | 65,0             | 48,5             | 53,5             | 39,7             | 43,8             | 32,2             | 35,6             | 26,1              | 28,9             | 21,1             | 23,4             |
| 400          | -                                       | -                | 54,7             | 60,3             | 44,7             | 49,3             | 36,3             | 40,1             | 29,4              | 32,5             | 23,7             | 26,2             |
| 450          | -                                       | -                | 61,5             | 67,8             | 50,3             | 55,5             | 40,9             | 45,1             | 33,1              | 36,6             | 26,7             | 29,5             |
| 500          | -                                       | -                | -                | -                | 55,8             | 61,5             | 45,4             | 50,1             | 36,8              | 40,6             | 29,7             | 32,8             |
| 560          | -                                       | -                | -                | -                | -                | -                | 50,8             | 56,0             | 41,2              | 45,5             | 33,2             | 36,7             |
| 630          | -                                       | -                | -                | -                | -                | -                | 57,2             | 63,1             | 46,3              | 51,1             | 37,4             | 41,3             |
| 710          | -                                       | -                | -                | -                | -                | -                | -                | -                | 52,2              | 57,6             | 42,1             | 46,5             |
| 800          | -                                       | -                | -                | -                | -                | -                | -                | -                | 58,8              | 64,8             | 47,4             | 52,3             |
| 900          | -                                       | -                | -                | -                | -                | -                | -                | -                | -                 | -                | 53,3             | 58,8             |
| 1000         | -                                       | -                | -                | -                | -                | -                | -                | -                | -                 | -                | 59,3             | 65,4             |
| 1200         | -                                       | -                | -                | -                | -                | -                | -                | -                | -                 | -                | -                | -                |
| 1400         | -                                       | -                | -                | -                | -                | -                | -                | -                | -                 | -                | -                | -                |
| 1600         | -                                       | -                | -                | -                | -                | -                | -                | -                | -                 | -                | -                | -                |



# LS-Mixer

## MAIN FEATURES

- High torque, super high efficiency permanent magnet synchronous motor is used in hot mixing, with high energy saving rate, large torque and high overload capacity.
- The hot mixing blades are made of wear-resistant material with long service life and good mixing effect.
- The comprehensive energy saving rate of the mixer is 10~20% compared with the conventional asynchronous motor drive.
- Large area of water ring cooling, forced internal cooling circulation system, high cooling efficiency.



## MAIN TECHNICAL PARAMETER

| MODEL           | MOTOR POWER FOR HOTMIXER (kw) | MOTOR POWER COOLING MIXER (kw) | CAPACITY PER BATCH (kg) | PRODUCTION CAPACITY PER HOUR kg/h |
|-----------------|-------------------------------|--------------------------------|-------------------------|-----------------------------------|
| GRH-500/LH1500  | 99                            | 22                             | 200                     | 1700~2500                         |
| GRH-1000/LH3000 | 160                           | 37                             | 400                     | 2900~4200                         |

# LS-PVC

## Granulating production line

## MAIN FEATURES

- Optimized screw design, large output, good mixing effe.
- Simple die structure and stable flow avert of the material remaining in the die.
- Open-type flange makes the screen changing quicker and more convenient, completing the screen changing process by manual within 2 minutes.
- Cooling air tank is stainless steel material,rust corrosion resistance.



SPIRAL COOLING

VIBRATING COOLING

DIE HEAD

EXTRUDER

## MAIN TECHNICAL PARAMETER

| MODEL     | OUTPUT (kg/h) | TOTAL INSTALLED POWER (kw) | EXTRUDER | GRANULATING TYPE |
|-----------|---------------|----------------------------|----------|------------------|
| LSE-65PVC | 280           | 88                         | LSE-65   | Heat cutting     |
| LSE-80PVC | 450           | 170                        | LSE-80   | Heat cutting     |
| LSE-92PVC | 800           | 250                        | LSE-92   | Heat cutting     |

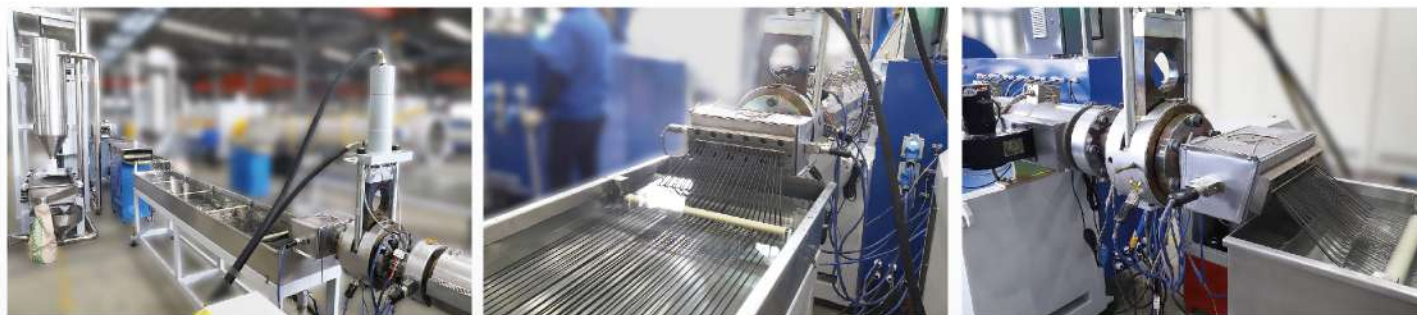


# LS-PE/PPR

## Granulating production line

### MAIN FEATURES

- Large L/D ratio screw design, high output, good energy saving effect
- Configuration of double station filter structure
- The die head is simple in structure and easy to clean
- Optional online separate bag filling mechanism



SEWING TYPE PACKING

STORAGE HOPPER

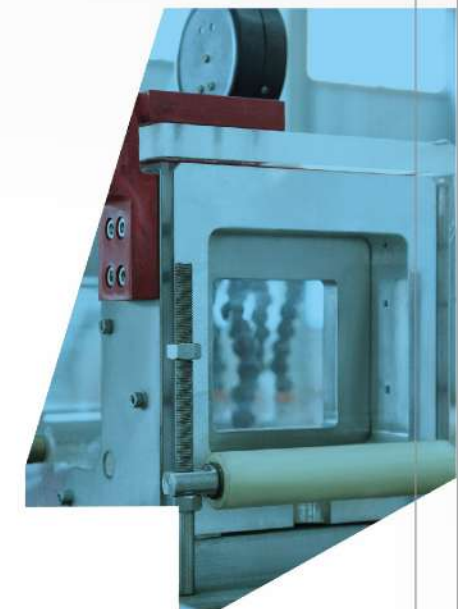
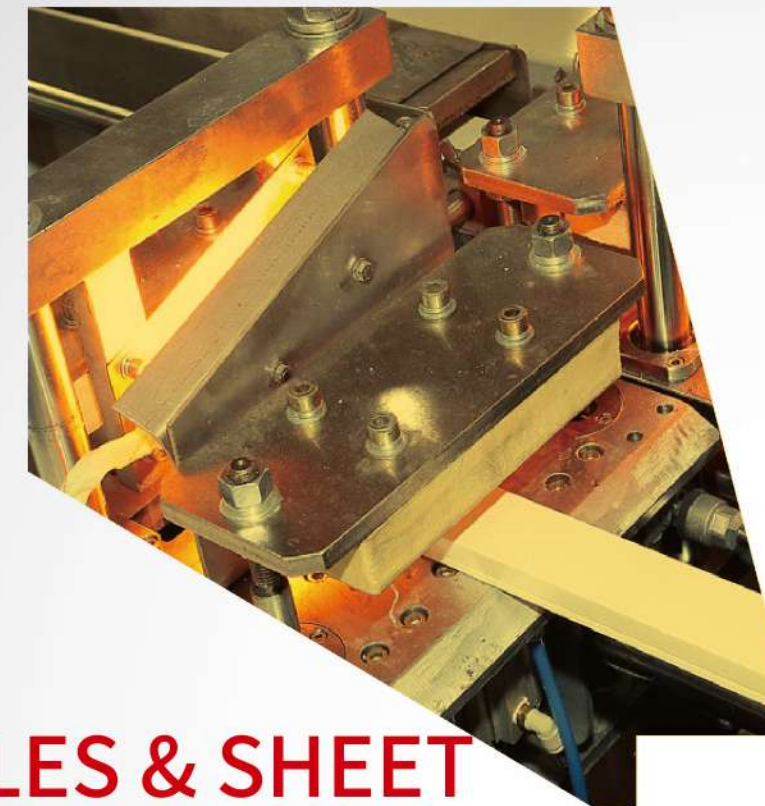
COOLING WATER TANK

DIE HEAD

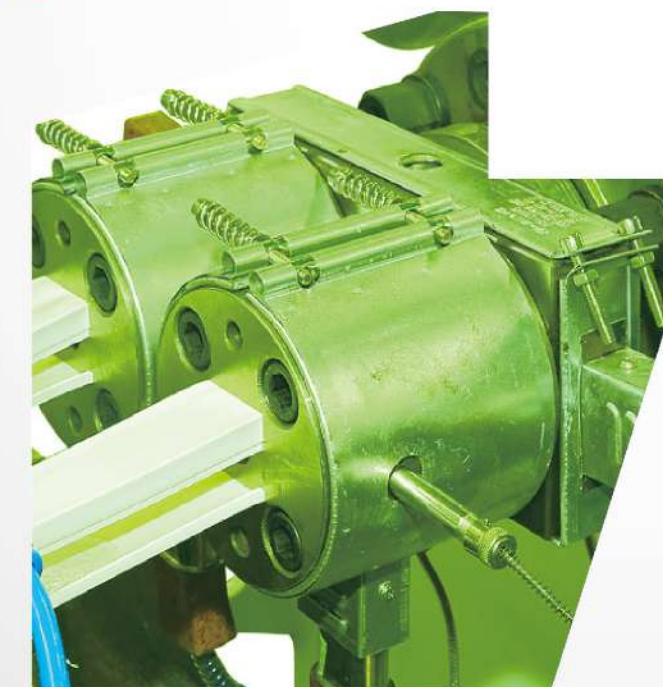
EXTRUDER

### MAIN TECHNICAL PARAMETER

| MODEL      | OUTPUT<br>(kg/h) | GRANULE SIZE | TOTAL INSTALLED POWER<br>(kw) | EXTRUDER | GRANULATING TYPE |
|------------|------------------|--------------|-------------------------------|----------|------------------|
| LSZL-65PPR | 280              | Ø3           | 88                            | LSE-65   | Cool cutting     |
| LSZL-80PE  | 450              | Ø3           | 170                           | LSE-80   | Cool cutting     |
| LSZL-100PE | 800              | Ø3           | 250                           | LSE-92   | Cool cutting     |



## PROFILES & SHEET EXTRUSION SERIES



- 41 LS-PVC Trunking Production Line
- 43 LS-PVC Door Panel Production Line
- 45 LS-PVC Window Profile Production Line

- 47 LS-Aluminum Plastic Composite Panel Production Line
- 49 LS-Plastic Sheet Production Line
- 50 LS-PP Panel Production Line
- 51 LS-Corrugated Tile Production Line



# LS-PVC Trunking

## Production Line

### MAIN FEATURES

- High productivity with Max.speed 2\*18 m/min.Able to provide single cavity or dual cavities production line as per dimension of product.
- Belt caterpillar type haul-off unit provides with fast and steady hauling, each cavity can be controlled independently.
- Swarfless cutter,low noise,energy saving, precise control in length.



### HAUL OFF & CUTTING COMBE UNIT



### ONLINE STRAPPING PACKAGING MACHINE



### MOULD

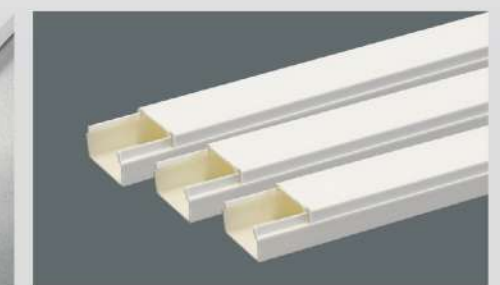


- Able to supply single or dual cavities PVC trunking mould



- trunking-mold-inner chamber.

### SAMPLE





# LS-PVC Door

## Panel Production Line

### MAIN FEATURES

- Customized downstream as per client's request.
- A equitable vacuum channel, water in and out distribution network, Y type filter equipped.
- Each caterpillar drives independently, providing with sufficient hauling force.



STACKER

CUTTER

HAUL-OFF UNIT

CALIBRATING TABLE

DIE HEAD

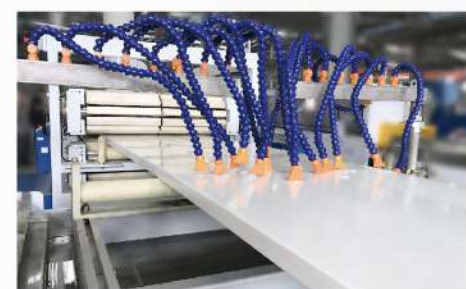
EXTRUDER

### CUTTER

- Encoder length counting, little deviation and stable signal.
- Synchronization of the working table displacement way and hauling. Pneumatic resetting.

### EXTRUDER

- Special design in screw, different excerpts in number of thread in screw fight and in screw pitch, to reach a better mixing and plasticizing and the purpose of air exhausting.



### HAUL - OFF UNIT

- Caterpillar pneumatic clamping. The clamping force can be adjusted by the reducing valve.
- The dual caterpillar hauling guarantees sufficient hauling power.
- Encoder length counting, little deviation and stable signal.



### CALIBRATION TABLE

- Electric lifting, convenient adjusting, strong vacuum, sufficient water flow, quick calibrating cooling.
- Overall stainless steel structure design, attractive and durable.
- Large area filter, guarantee mold runner smooth.
- Rational distribution of the classification of the connector. Easy and clear operation.

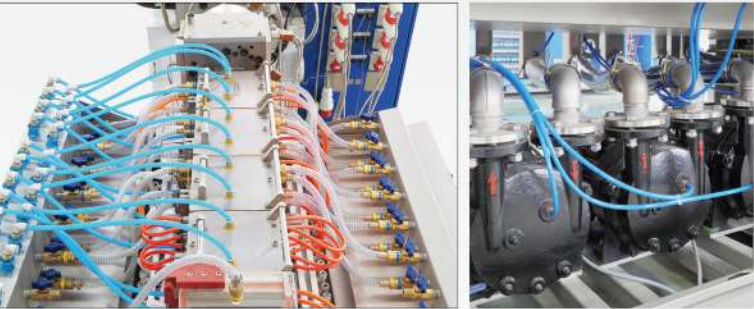


# LS-PVC Window

## Profile Production Line

### MAIN FEATURES

- High efficiency, reliability and easy operation. Customized equipment configurations as per client's request.
- Low -shear, high torque and large L:D ratio, guaranteeing stable extruding.
- High efficiency, energy saving, closed-loop structure of water channel and easy operation design.
- Swarfless cutting, guarantees good incision effect.



### CALIBRATING TABLE

- Stainless steel material,durable.
- Quick-forming pipe design,shorten initial commissioning time.
- Quiet design,low noise(77dB) when the whole machine working.
- Smart water pipeline design brings benefits to water pressure loss in order to reduce complete line energy consumption.
- Y type filter ensures stable water flows.
- Reasonable layout joint classification, simple and clear operation.
- Four-dimensional adjustable calibrating table structure.



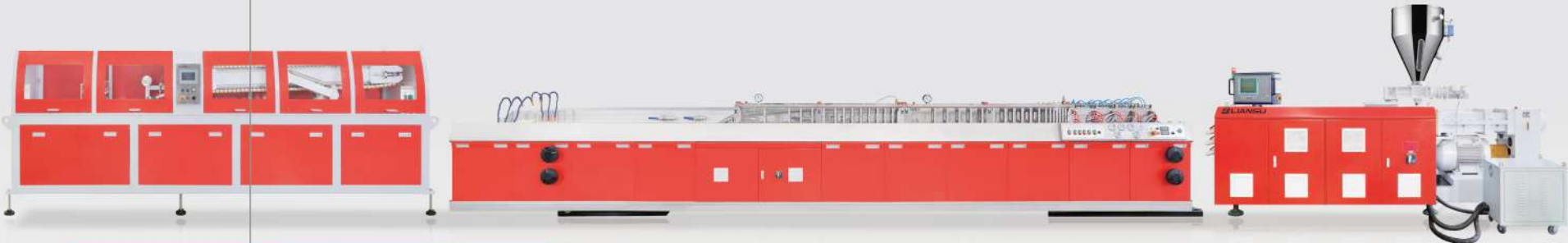
### HAUL - OFF & CUTTING UNIT

- Swarfless cutting structure, good synchronization, precise control in length and good cutting quality.
- Each caterpillar drives independently, providing with sufficient hauling force.



### MAIN TECHNICAL PARAMETER

| MODEL | PRODUCT SERIES (mm) | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | INSTALLED CAPACITY (kw) | LINE LENGTH (m) |
|-------|---------------------|-------------------|---------------------------|-------------------------|-----------------|
| F-150 | 150X50              | 120               | 12                        | 80                      | 22              |
| F-250 | 250X60              | 250               | 5.3                       | 120                     | 26              |
| F-850 | 850X35              | 450               | 5.3                       | 220                     | 25              |



HAUL - OFF & CUTTING UNIT

VACUUM CALIBRATION UNIT

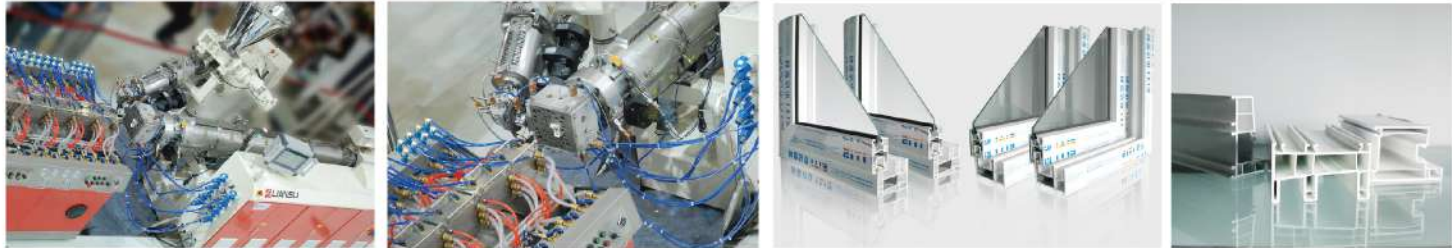
DIE HEAD

EXTRUDER



### EXTRUDER

- An equitable vacuum channel, water in and out distribution network.





# LS-Aluminum Plastic

## Composite Panel Production Line

### MAIN FEATURES

- The complete line synchronization is ensured by Siemens Profibus control system.
- Calender roller adopts multi-spiral water channel design, uniform roll surface temperature and efficient cooling.
- High-temperature composite roller adopts multi-spiral water channel design, uniform roll surface temperature enables plastic plate and aluminum plate glued firmly.
- Applicable for aluminum plastic composite panel and PE panel production.



■ Aluminum-plastic panel-polymer composite-composite.

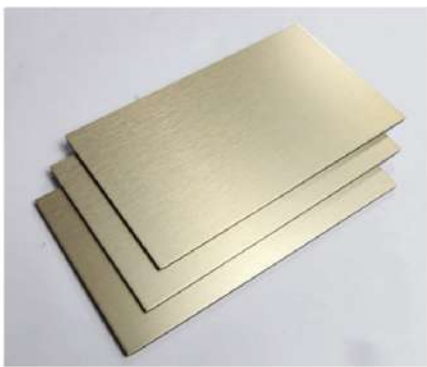
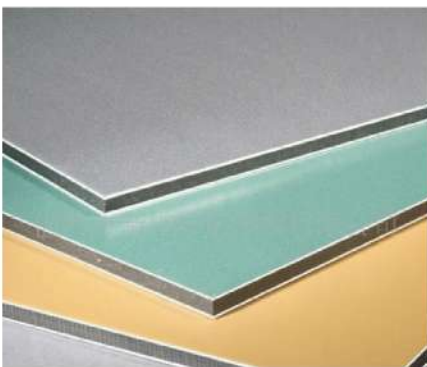
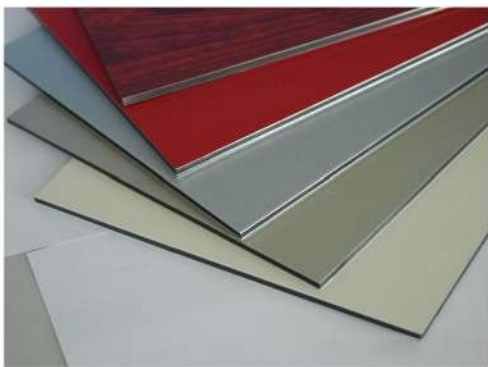


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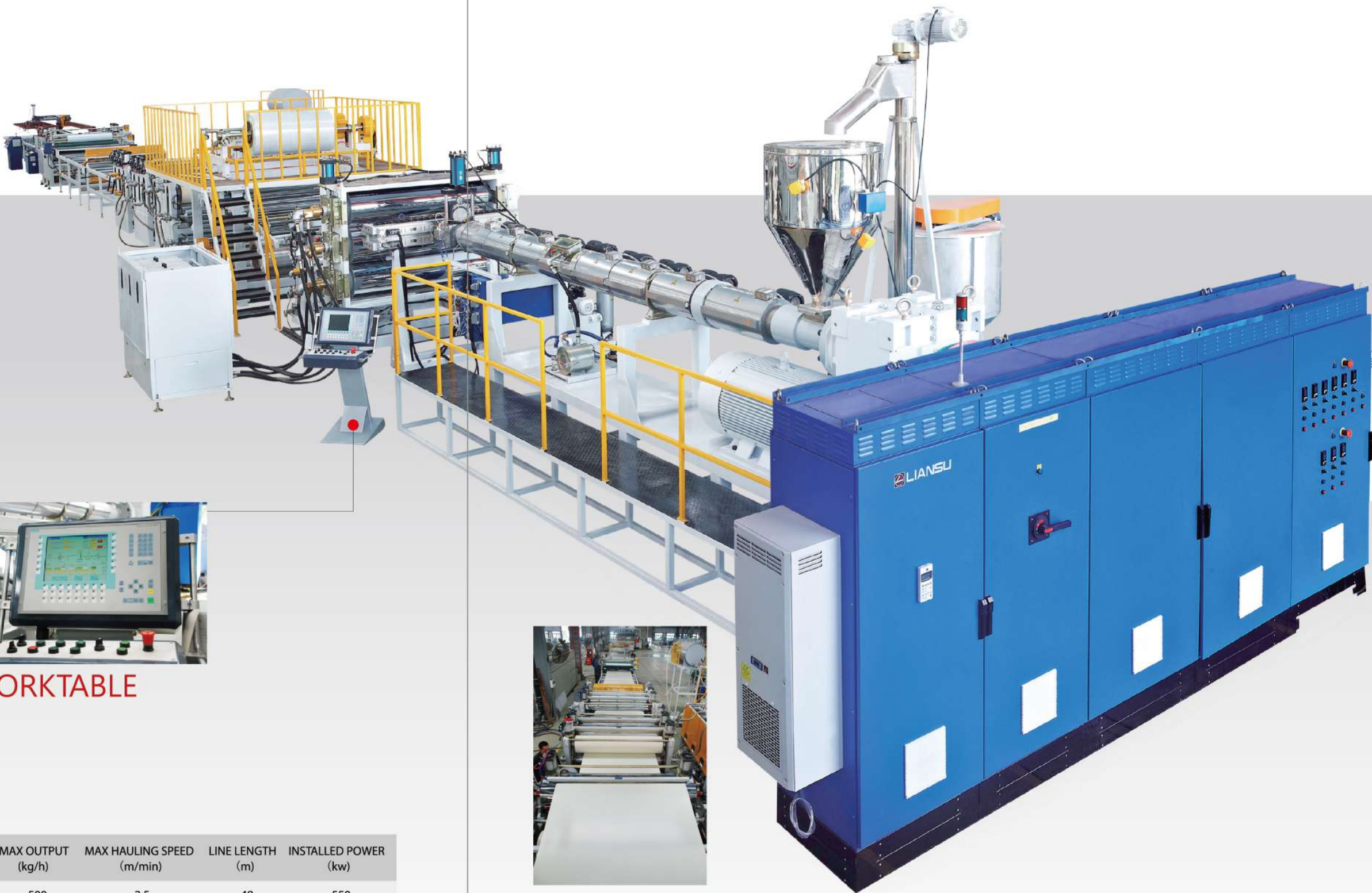
■ APCP Extruding production line: T mold.



### WORKTABLE



### SAMPLE



### PRODUCTION STATUS

### MAIN TECHNICAL PARAMETER

| MODEL      | PRODUCT SPECIFICATION (mm) | THICKNESS (mm) | EXTRUDER MODEL | POWER (kw) | MAX OUTPUT (kg/h) | MAX HAULING SPEED (m/min) | LINE LENGTH (m) | INSTALLED POWER (kw) |
|------------|----------------------------|----------------|----------------|------------|-------------------|---------------------------|-----------------|----------------------|
| LSACP-1300 | 1300                       | 1-5            | LSS150-35      | 250        | 500               | 2.5                       | 48              | 550                  |
| LSACP-1600 | 1600                       | 1-5            | LSS170-35      | 250        | 700               | 2.5                       | 55              | 650                  |



# LS-Plastic

## Sheet Production Line

### MAIN FEATURES

On account of the different plastic material, Liansu designs the corresponding screws, ensuring the good plasticizing effect and good product quality. Such as PVC, PP, PE, PS, HIPS, etc. Calender roller adopts multi-spiral water channel design, uniform temperature roll surface and high product surface quality. Tri-roll calender adopts independent motor drive, frequency variable speed regulation. Moreover, the panel extension ratio is adjustable.

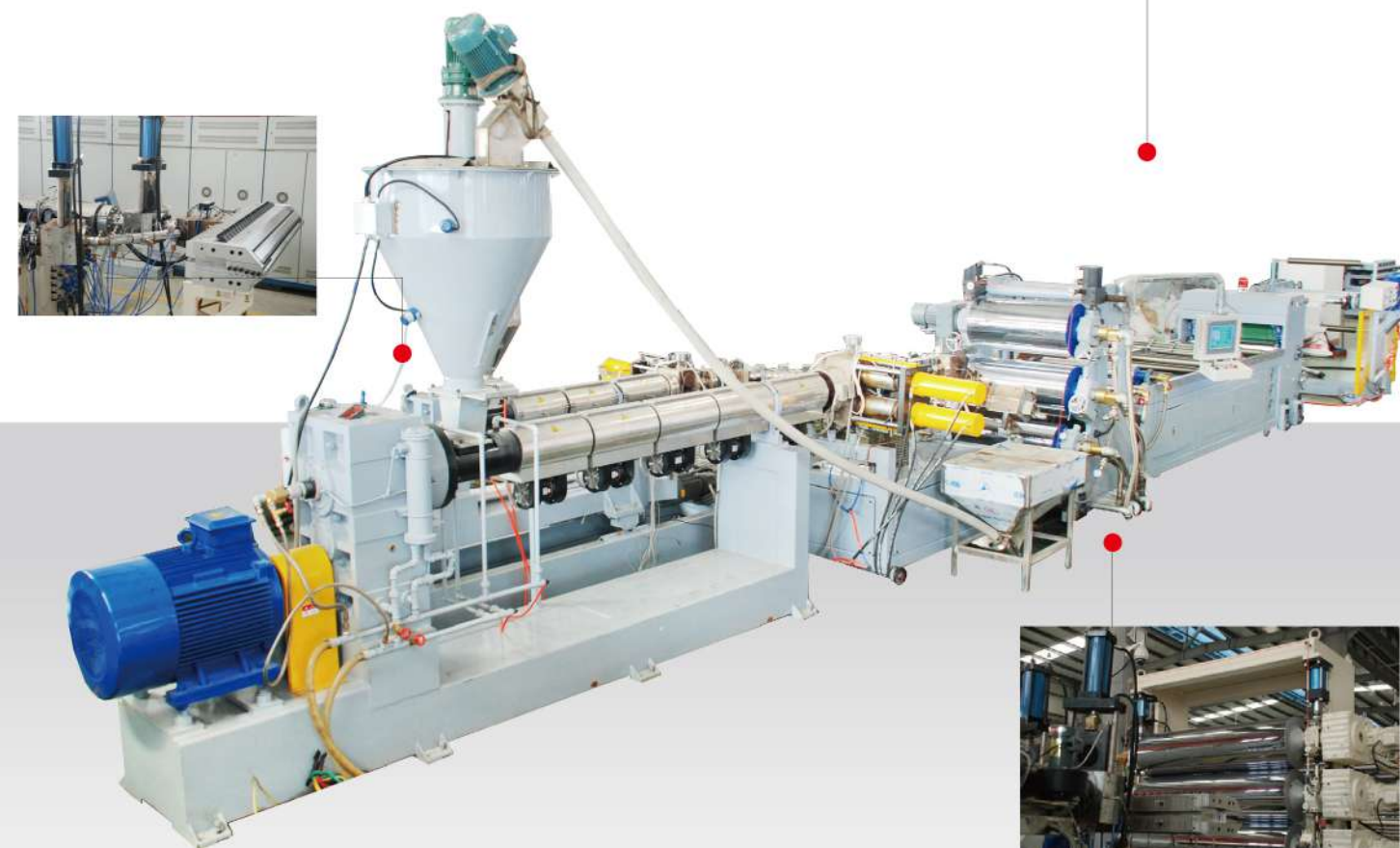
### SHEET



### PANEL PRODUCTION



### HAUL-OFF&CUTTING UNIT



■ PE-three roller

### MAIN TECHNICAL PARAMETER

| MODEL         | PRODUCT WIDTH (mm) | PRODUCT THICKNESS (mm) | MAX OUTPUT (kg/h) | SPEED OF THE PRODUCTION LINE (m/min) | LINE LENGTH (m) | INSTALLED CAPACITY (kw) |
|---------------|--------------------|------------------------|-------------------|--------------------------------------|-----------------|-------------------------|
| LSP-1200      | 1200               | 0.2-3                  | 400               | 20                                   | 30              | 330                     |
| LSP-1600      | 1600               | 0.2-3                  | 600               | 20                                   | 35              | 350                     |
| LSB-1500PVC   | 1500               | 0.2-3                  | 600               | 20                                   | 30              | 410                     |
| LSBP-650PS/PP | 650                | 0.2-3                  | 250               | 20                                   | 17              | 190                     |

# LS-PP Panel

## Production Line

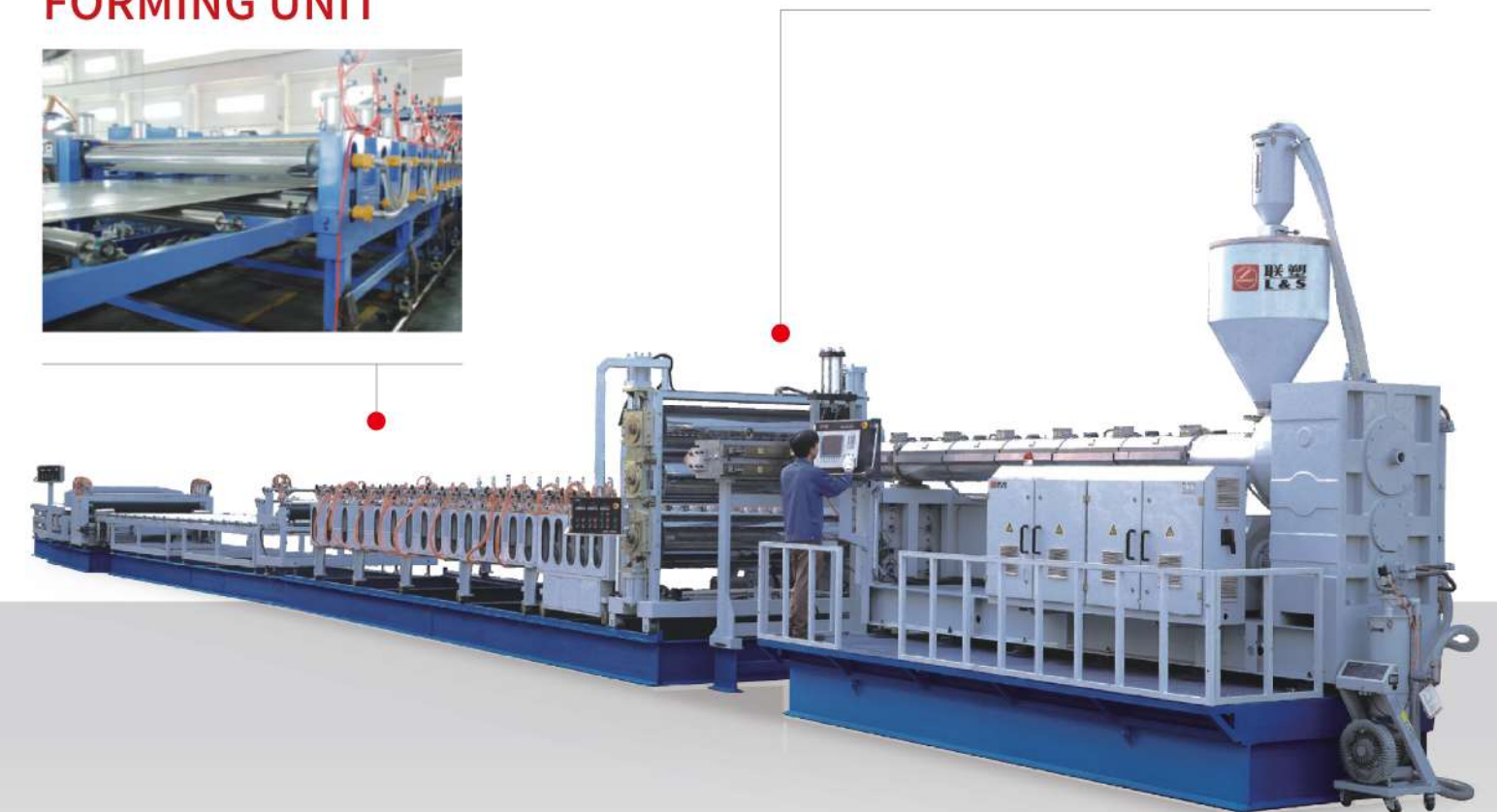
### MAIN FEATURES

- Special screw design ensures the good plasticizing effect and good panel quality.
- Calender roller adopts multi-spiral water channel design, uniform temperature roll surface and high product surface quality.
- Tri-roll calender adopts independent motor drive, frequency variable speed regulation. Moreover, the panel extension ratio is adjustable.
- Multi-group cooling roll configurations ensure the full cooling of the thick panel.
- Lateral movable cutting device corrects the panel width timely.
- Equipped with auto vacuum suction device for product stacking.

### CALENDER UNIT



### FORMING UNIT



### SAMPLE



### MAIN TECHNICAL PARAMETER

| MODEL      | MAX OUTPUT (kg/h) | PRODUCT SPECIFICATION (mm) | THICKNESS (mm) | INSTALLED CAPACITY (kw) | MAX HAULING SPEED (m/min) |
|------------|-------------------|----------------------------|----------------|-------------------------|---------------------------|
| LSB-1500PP | 600               | 1500                       | 3-25           | 500                     | 2                         |
| LSB-1800PP | 600               | 1800                       | 3-25           | 769                     | 2                         |



# LS-Corrugated

## Tile Production Line

### MAIN FEATURES

- Liansu develops special screw for high-filling material production, accordingly to ensure the good plasticizing effect under low cost formular, manufacturing high quality product.
- Cloth-hanger die makes the material flow stably.
- Forming die cools down fast, easy adjustment.
- Hydraulic cutter with speedy & safe cutting and smooth cutting edge.

### HAUL - OFF UNIT



### EXTRUDER



### FORMING AND COOLING DEVICE



### SAMPLE

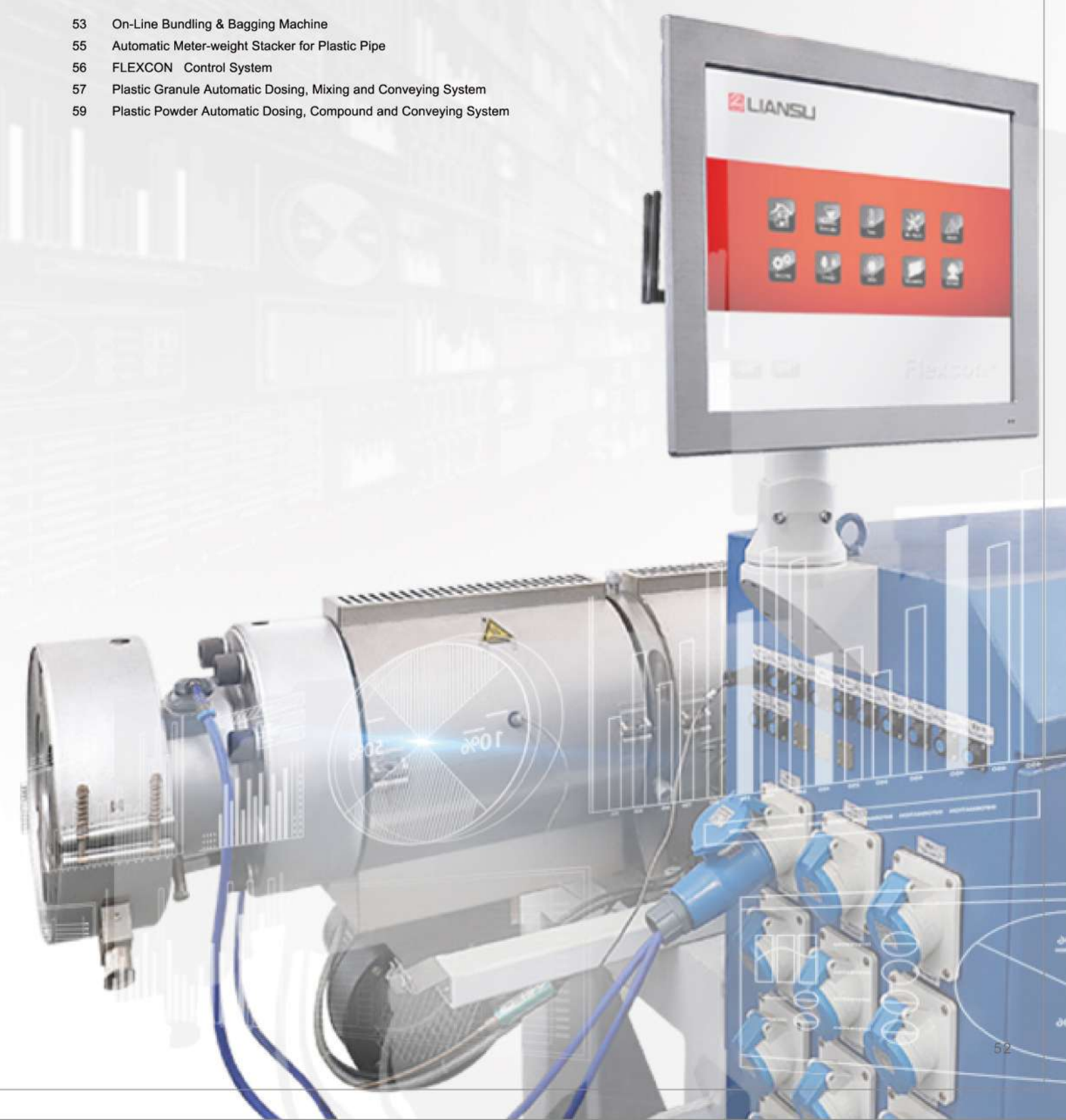


### MAIN TECHNICAL PARAMETER

| EXTRUDER MODEL                       | PRODUCT WIDTH (mm) | PRODUCT THICKNESS (mm) | SPEED OF THE PRODUCTION LINE (m/min) | LINE LENGTH (m) | INSTALLED CAPACITY (kw) |
|--------------------------------------|--------------------|------------------------|--------------------------------------|-----------------|-------------------------|
| LSBV1050,PC-UV-II LSS120-35,LSS45-30 | 1050               | 0.8-3                  | 0.25-5                               | 18.5            | 412                     |
| LSB1130PVC LSE80/156                 | 1130               | 1-2.5                  | 0.15-3                               | 18.5            | 180                     |

## AUTOMATIC SERIES

- 53 On-Line Bundling & Bagging Machine
- 55 Automatic Meter-weight Stacker for Plastic Pipe
- 56 FLEXCON Control System
- 57 Plastic Granule Automatic Dosing, Mixing and Conveying System
- 59 Plastic Powder Automatic Dosing, Compound and Conveying System





# On-Line

## Bundling & Bagging Machine

### MAIN FEATURES

- Compact design, less occupies;
- When changing size the adjustment is simple and fast , humannized design;
- Stretch film and packing bag easy to replace;
- Reliable alarm system on the shortage of stretch films and packing bag;
- Smart and reliable bundling way.
- Bundling and baging wrapped simultaneously structure simple.
- Bundling and baging adopted Servo control, fast and stable.
- Storage stacker with detect fuction of pipe storage
- Open structure of storage stacker, tube automatic arraying neatly after cutting;

### AVAILABLE RANGE

- PVC、PPR straight pipe.
- It can be matched with single pipe, double pipe and four pipe extrusion line.
- Be able to meet the requirement of 20m/min online packing.
- Suitable for plastic film, woven bag and other bagging&packing material.



### ONLINE PACKING-CONDUIT



- Various packing methods for all kinds of pipes, such as PE bag packing, woven bag sewing&packing, winding&packing, etc., have completed comprehensive serialization, mass production and sales.

## TRUNKING BUNDLING,BAGGING&PACKING MACHINE



■ Wire slot series strapping packing machine online

## ONLINE FILM STRAPPING MECHANISM FOR PIPES





# Automatic Meter-weight Stacker for Plastic Pipe

- Body dimension: 6000\*667\*1260 (L \* W \* H), compact size .
- The qualified pipe is automatically lifted and stacked to the material cage after cutting.
- Online real-time monitoring of the weight of each pipe, and automatically eliminate the unqualified weight of the pipe.
- Automatically count the qualified and unqualified quantity and weight of pipe
- IPC with 17 inch color touch screen is optional to realize data acquisition and data analysis (IPC) of the whole line.

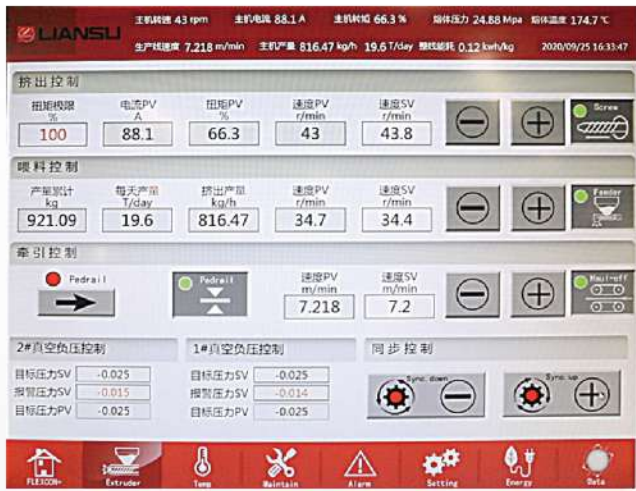


# Flexibility control system

## FLEXCON<sup>+</sup>

Flexible control system integrating extrusion equipment control and production data acquisition and analysis can select data in real-time or user-defined time period for Equipment utilization, Capacity analysis, Energy consumption analysis, Alarm monitoring, Equipment maintenance, Production data;

Present data analysis in the form of graphs and tables, so as to directly monitor the use status of the equipment.





# Plastic Granule Automatic Dosing, Mixing and Conveying System

The granule material conveying system consists of the following units:

Material Feeding station, silo, pneumatic conveying system, multi-component gravimetric blender, dehumidifier, dryer, raw material distribution station, hopper loader, online automatic masterbatch mixing feeding system, and centralized control system.



Mconvey is a brand of LIANSU Machinery, mainly engaged in material handling system and a full range of auxiliary equipments for plastic processing industry. Mconvey provides a customized solution according to user's need. In recent 8 years, Mconvey has successfully built more than 300 complete material handling systems for different industries and provided services for more than 3000 sets of plastic processing equipment.



Standard Dryer

Vertical Batch Mixer

Insulation Dryer

Gravimetric Blender

Separate Type Hopper Loader



Dehumidifying Dryer

Loss In Weight Feeder (Powder)

Loss in Weight Feeder (Granules)

Gravimetric Doser

Gravimetric Metering System



## System introduction:

- In the granule feeding system, various granule materials are poured into the "feeding bucket" through manual debagging feeding or ton bag feeding;
- The granules are conveyed to the large silo for storage through positive or negative pressure pneumatic conveying system;
- The granules are conveyed to the "multi-component gravimetric blender" through the "vacuum pneumatic conveying system". After various granule materials are accurately measured according to the predetermined formula, they are fully mixed;
- The mixture is conveyed by the vacuum pneumatic conveying system to the hot air dryer or dehumidifying dryer to remove the moisture in the raw materials;
- The dried raw materials are conveyed to the "vacuum hopper loader" the extruder or injection molding machine through the "material distribution station" or the pipeline for the extruder or the injection molding machine (for high requirements on masterbatch mixing or products with multiple colors, the volumetric doser can be used to realize online color mixing);
- It is widely used in the home appliance packaging industry, auto parts packaging, extrusion molding (pipes, profiles and plates) packaging and other plastic molding applications. It adopts a centralized automatic control system to realize data monitoring and management, and provides complete solutions and professional services for intelligent manufacturing.

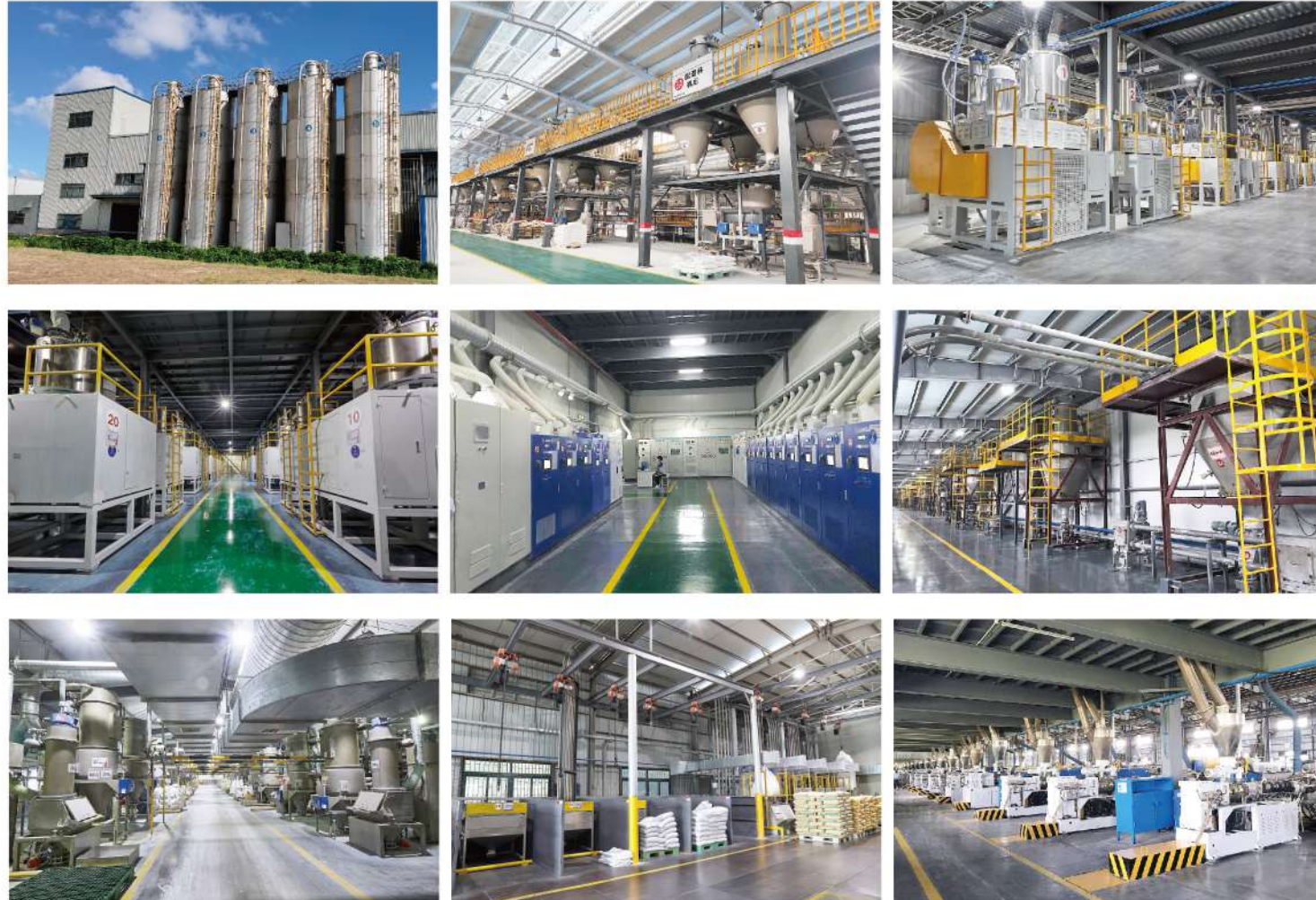




# Plastic Powder Automatic Dosing, Compound and Conveying System

The powder feeding system covers the following units:

Feeding station, pneumatic conveying system, weighing scale, auxiliary material dosing scale, exhaust air filter, compound mixer, tube chain conveyor, screw conveyor, gravimetric metering system, online color mixing system, centralized control system.



## Introduction of the powder feeding system

- Bagged main raw materials (in 25kg bags or ton bags) of the powder feeding system are unpacked and fed to the feeding station;
- Powder materials are conveyed to the "weighing scale" through the "pneumatic conveying system" (for some systems, the materials are conveyed from the feeding station to the intermediate storage silo, and then from the intermediate storage silo to the weighing scale);
- Measured powder and formula materials (synchronized by the "formula material dosing scale" or weighed in advance) are conveyed to the "compound mixer" by gravity or "screw conveyor";
- All the raw materials are mixed by high speed compound mixer and then conveyed to the top of the "tube chain conveyor" via the "pneumatic conveying system" (directly conveyed to the top of the extruder through negative pressure);
- The tube chain conveyor conveys the compound materials to the hopper of the extruder as required;
- It is widely used for pneumatic conveying of powder materials in the fields of PVC pipe, profiles and sheet plastic modified compound material food processing, etc. It adopts computer centralized automatic control, realizes data-based centralized feeding and control, and provides solutions for automated production systems.

