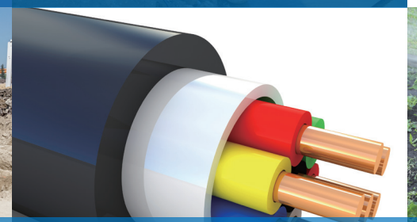
塑料管材的主要应用
Main Applications of Plastic Pipes

给水管
Drinking water supply pipe

PVC 给、排水和电力护套管
PVC water supply,drainage and cable protection pipe



通讯和电力管
Telecommunication wire and cable protection pipe

农业灌溉管
Agriculture irrigation pipe

PPR 给水管
PPR water supply pipe

燃气管
Gas supply pipe

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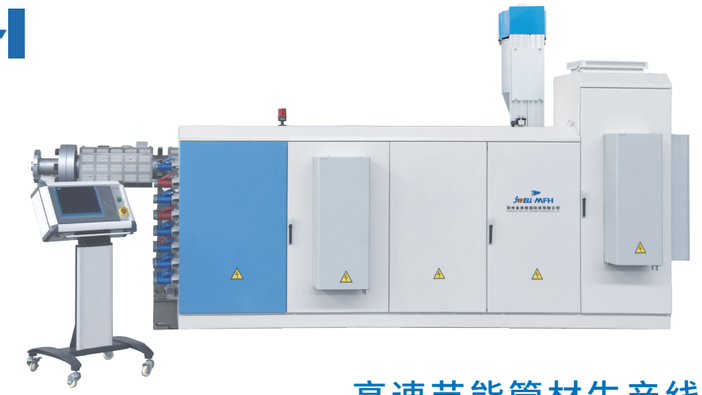


高速节能管材生产线
High-speed Energy-saving Pipe Extrusion Line

CE

TÜV CERT ISO9001:2015

常州金纬管道科技有限公司
CHANGZHOU JWELL PIPE EQUIPMENT TECHNOLOGY CO., LTD.

A Global Supplier of Complete Solutions on Extrusion Technology

金纬机械—全球挤出技术 整体解决方案供应商

80年代初 金海螺第一代螺杆研制成功
In the early 1980s, the first generation screw of JINHAILUO was successfully developed

1997 上海金纬机械
Shanghai JWELL Machinery

2008 苏州金纬机械
Suzhou JWELL Machinery

2012 常州金纬机械
Changzhou JWELL Machinery

2018 贝克威尔（泰国）
Bkwell (Thailand)

2019 浙江金纬智能装备
Zhejiang JWELL Machinery

2020 金纬公司业绩突破50亿人民币
Jwell's annual sales exceeded CNY 5 billion

2021 滁州金纬机械
Chuzhou JWELL Machinery

2022 连续11年荣获中国塑料机械挤出行业排名首位
Ranked first in China's plastic machinery extrusion industry for 11 consecutive years

We Know Extrusion

常州金纬管道科技有限公司是一家定位高端的全新研发型科技有限公司，成立于 2016 年 4 月，为金纬旗下管道设备的高端系列，依托金纬机械常州基地强大的机械加工设备及人才，以全新理念设计研发的 MFH 系列聚烯烃 (PO) 高效节能管材 (Φ8-Φ2000mm) 挤出生产线、聚氯乙烯 (PVC) 高效节能管材 (Φ16mm-Φ1200mm) 挤出生产线，设备具有高产量、低能耗、良好的熔体均质性及长期运行的稳定性，采用模块化设计方案为产品的系列化、通用性提供便利，在如何节省原材料、提高自动化程度、确保高产出率、高品质精密挤出及为用户量身定制的极具竞争力的产品等方面都提供了完美的整体系统解决方案。

Changzhou JWELL Pipe Equipment Technology Co.,Ltd., founded in April 2016, is a new high-end R&D company. JWELL's high-end products. Supported by JWELL Machinery's powerful Changzhou base and human resources, the MFH series polyolefin (PO) high efficient and energy-saving pipe (Φ8-Φ2000mm) extrusion line and polyvinyl chloride (PVC) high efficient and energy-saving pipe (Φ16mm-Φ1200mm) extrusion line, both designed and developed with brand-new rationale, have such merits as high output, low energy consumption, excellent melt homogeneity, and long-term operation stability. Their modular design creates the condition for exchangeability among products and for producing products in series. A perfect and complete system solution is provided that satisfies the need for reducing raw material consumption, improving automation, ensuring high productivity and high quality and precision extrusion, and customized manufacturing of competitive products.

科技是未来的生产力

“品质卓越 完美如一”
是金纬公司的质量方针，是全体员工努力的方向。

“诚实待人”
是我们铸就“百年金纬”的核心理念。

Science and technology constitute the primary productive force for future

“Excellent Quality, Perfect All”
Is Jwell' s quality policy, and all staff's working direction.

“Be Honest”
Is the core idea for us to contribute“ Century JWELL”

董事长 : 何海潮 E-mail:he@jwell.cn

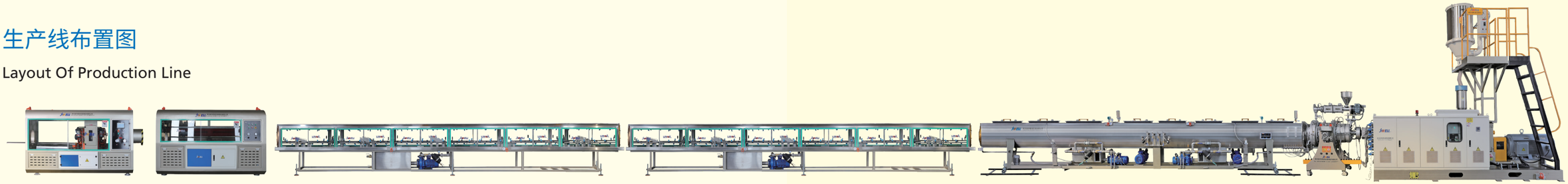
President: He Haichao
Mobile /WhatsApp +86 13601628188

您的塑料管材挤出方案的最佳合作伙伴
The Best Partner For Your Plastic Pipe Extrusion

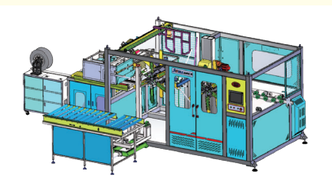
挤出机械物联网 + 智能制造解决方案
Plastic Machinery Fully Integrated Automation + Internet Of Things Control System Solutions

生产线布置图

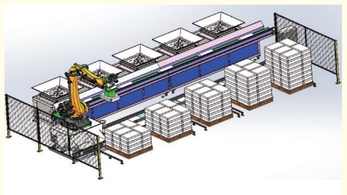
Layout Of Production Line



切割机 Cutter | 牵引机 Haul off unit | 喷淋箱 2 Cooling tank2 | 喷淋箱 1 Cooling tank1 | 真空箱 Vacuum tank | 模具 Mould | 挤出机 + 米重系统 Extruder +Gravimetric dosing system



全自动收卷机
Fully automatic winding machine

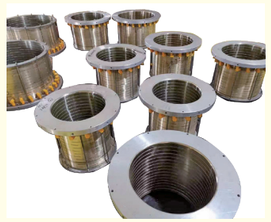


机器人破包上料系统
Robot breaking and feeding system

双金属螺杆
Bimetallic screw

精密螺旋体
Precise spiral body

高产量模具
High output Mould



高速定径套
High speed Calibrator

伺服牵引机
Servo haul off unit

注：可选配的自动化设备：机器人破包上料系统，全自动收卷机，米重系统，测厚仪等

Optional Automation Equipment: Robot breaking and feeding system,
fully automatic winding machine, gravimetric dosing system, thickness gauge.

智慧工厂

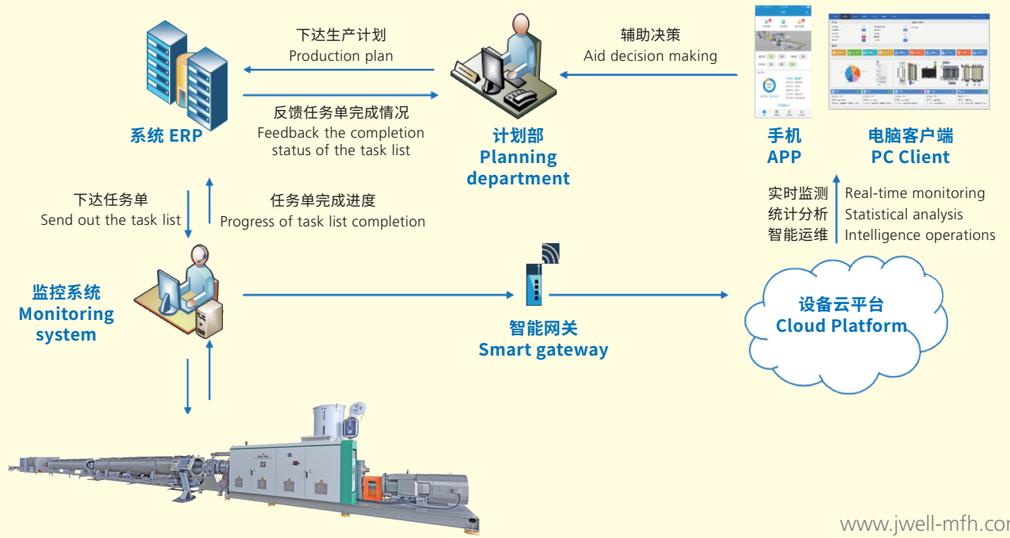
Smart Factory

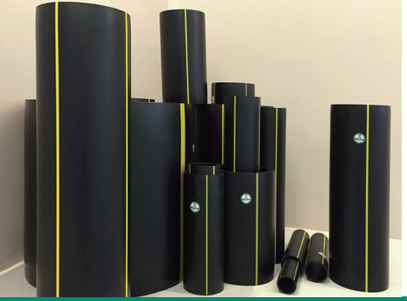
现场大屏幕电子看板可以直接看到当前生产线

- 运行状态
- 单位能耗
- 各电机负载率
- 良品率
- 运行时间
- 排班计划
- 故障预警
- 生产计划等重要数据

On-site large screen electronic kanban can directly view the current production line

- Running state
- Unit energy consumption
- Load rate of each motor
- The yield
- The elapsed time
- Scheduling plan
- Fault early warning
- Production plan and other important data





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Intelligent 智能 | Energy saving 节能 | High speed 高速 | High efficiency 高效

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JWELL-MFH 系列 HDPE 聚乙烯给水管、燃气管高速节能挤出生产线

JWELL-MFH Series HDPE Water Supply Pipe/Gas Pipe Energy-Saving And High Speed Extrusion Line

设备简介：

该生产线主要用于生产单层聚乙烯给水管材 (GB/T13663-2018) 及燃气管材 (GB/T15558-2003) 更换部分单元亦可生产 PP 给水管材 (QB/T1929-1993)。

该生产线外形美观，具有极高的性价比，相比传统设备更高的产能、更低的吨能耗，更精密的挤出，是替代进口品牌设备的最佳选择。

Brief introduction of equipment:

The production line is mainly used to produce single layer Poyethylene water supply pipe (GB/T13663-2018) and gas pipe (GB/T15558-2003), replaced some units can produce PP water supply pipe (QB/T1929-1993).

The product line has a good appearance and high cost performance compared to the traditional equipment. The line is higher capacity and lower tons-consumption, more precise extrusion, that is the best alternative to replace imported brand equipment.

主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)
MFH-F32	MFH-60	8-32	50	180-360
MFH-F63	MFH-60	6-63	40	180-360
MFH-F110	MFH-60	20-110	30	300-360
MFH-F160	MFH-60	20-160	25	300-400
MFH-F160	MFH-60	50-160	10	300-400
MFH-F250	MFH-75	75-250	8	300-640
MFH-F315	MFH-75	110-315	6	400-700
MFH-F450	MFH-90	160-450	2.4	450-800
MFH-F500	MFH-90	160-500	2.4	450-800
MFH-F630	MFH-90	315-630	1.2	500-1250
MFH-F800	MFH-120	400-800	1	700-1400
MFH-F1000	MFH-120	500-1000	1	900-1400
MFH-F1200	MFH-120	630-1200	0.8	1000-1600
MFH-F1600	MFH-150	1000-1600	0.6	1250-1800
MFH-F2000	MFH-120/ MFH-90	1200-2000	0.5	1300-2000

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

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JWELL-MFH 系列 PO(PP-R、PE-RT、PB) 聚烯烃地暖管高速节能挤出生产线

JWELL-MFH Series PO(PP-R, PE-RT, PB)Pipe Energy-Saving And High Speed Extrusion Line

设备简介：

该生产线主要用于生产聚丙烯冷热水管材 (GB/T18742.2-2002) 更换或增加部分单元亦可生产耐热聚乙烯冷热水管材 (GB/T28799.2-2012) 及聚丁烯冷热水管材 (GB/T19473.2-2004)，特别设计的专用螺杆更适合 PP-R、PE-RT 及 PB 管材的高速稳定生产。

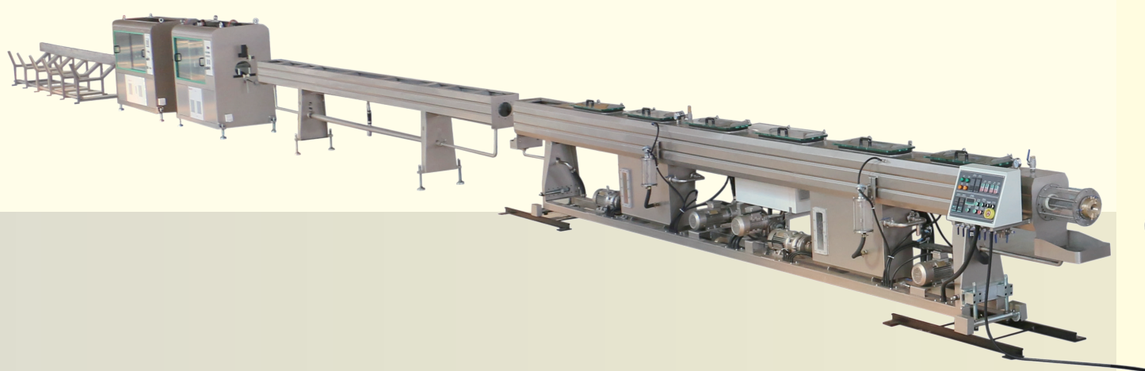
Brief introduction of equipment:

The production line is mainly used to produce PP cold and hot water pipes (GB/T18742.2-2002). To replace or add some units can also produce heat resistant polyethylene cold and hot water pipes (GB/T28799.2-2012) and polybutene cold and hot water pipes. The specially designed screw is more suitable for PP-R, PE-RT and PB pipes with high speed and stable production.

主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F32	MFH-60	8-32	50	200-280	用于生产 PP-R、PE-RT、PB
MFH-F63	MFH-60	16-63	40	250-350	
MFH-F110	MFH-60	20-110	30	280-400	用于生产 PP-R、PE-RT
MFH-F160	MFH-60	40-160	15	300-440	
MFH-F250	MFH-75	50-250	8	480-600	用于生产 PE-RT

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.



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JWELL-MFH 系列 MPP 改性聚丙烯电缆导管高速节能挤出生产线

JWELL-MFH Series MPP Modified Polypropylene Cable Conduit High Speed Energy Saving Extrusion Production Line.

设备简介：

该生产线主要用于生产改性聚丙烯电缆导管 (DL/T802.7-2010)，采用 MPP 专用螺杆，塑化效果好，确保非开挖管的拉伸强度的同时也保证管材高速生产。

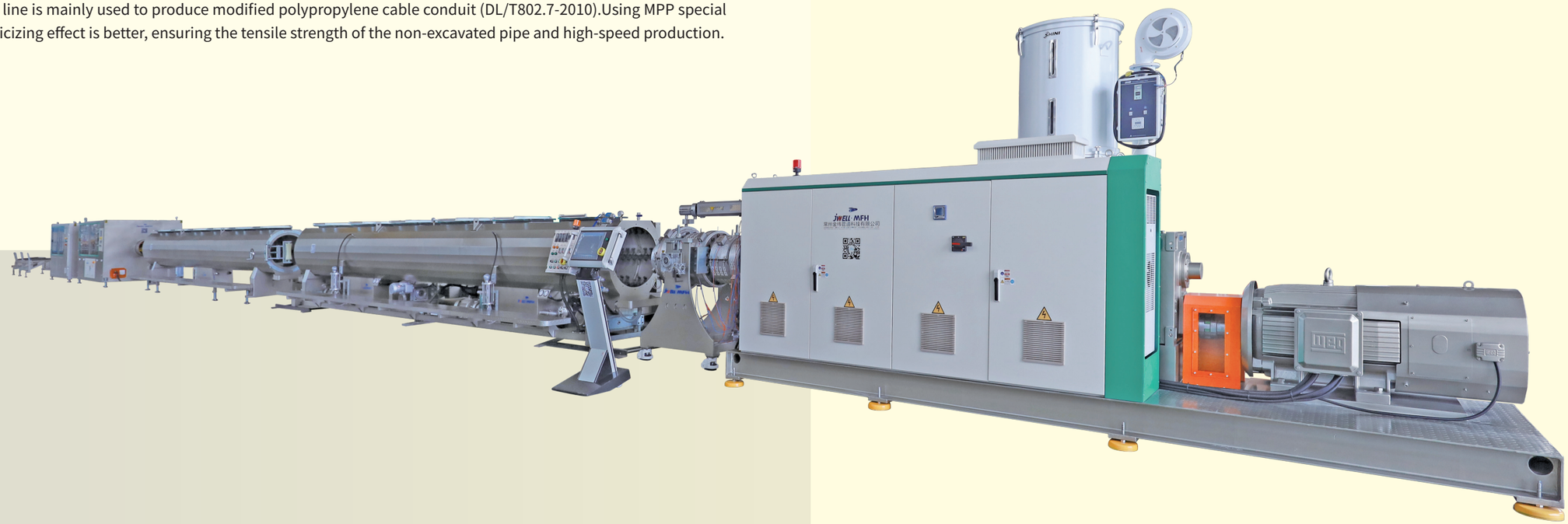
Brief introduction of equipment:

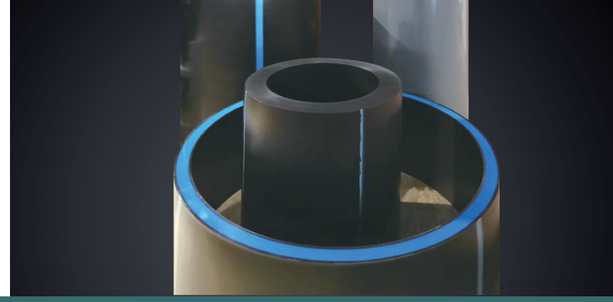
The production line is mainly used to produce modified polypropylene cable conduit (DL/T802.7-2010).Using MPP special screw, the plasticizing effect is better, ensuring the tensile strength of the non-excavated pipe and high-speed production.

主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F250	MFH-75	75-250	8	450-550	--
MFH-F315	MFH-75	110-315	6	550-650	--

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.





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JWELL-MFH 系列 HDPE 聚乙烯多层共挤给排水管高速节能挤出生产线

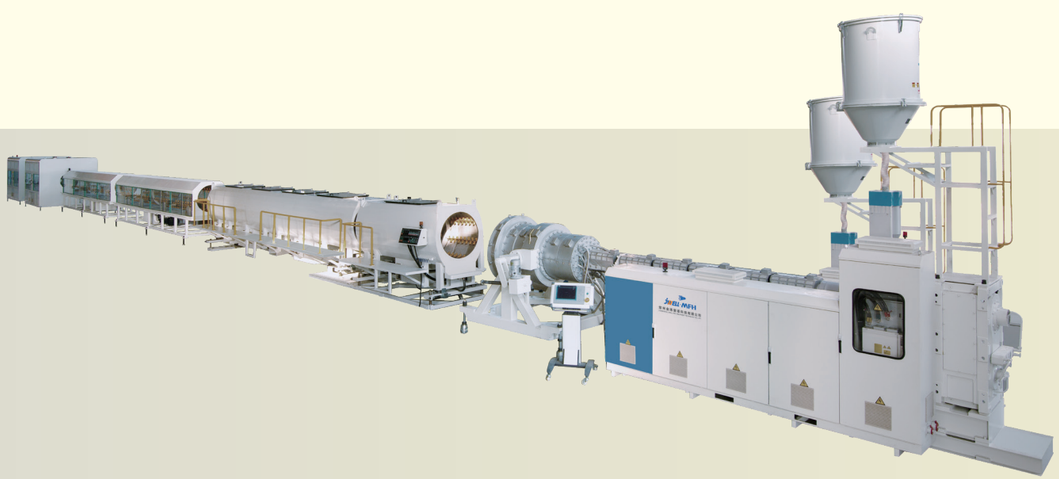
JWELL-MFH Series HDPE Multi-Layer Co-extrusion Water Supply And Drainage Pipe High Speed Energy Saving Extrusion Production Line

设备简介：

该生产线主要用于生产两机两层 (比例可调)、两机三层 (内外壁厚比例可调) 或三机三层 (内外壁厚比例可调) 等多功能聚乙烯给排水管材 (GB/T13663-2016)

Brief introduction of equipment:

The production line is mainly used two extruders making two layers (adjustable in proportion) or two extruders making three layers (adjustable inside and outside walls) or three extruders making three layers (adjustable inside and outside walls) multifunctional polyethylene water supply and drainage pipe(GB /T13663-2016)



主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)
MFH-F63	MFH-60/ MFH-45	16-63	40	250-360
	MFH-60/ MFH-45 x2 pcs	16-63	40	250-360
MFH-F110	MFH-60/ MFH-45	20-110	30	300-440
	MFH-60/ MFH-45 x2 pcs	20-110	30	300-440
MFH-F160	MFH-60/ MFH-45	50-160	15	360-520
	MFH-60/ MFH-45 x2 pcs	50-160	15	360-520
MFH-F250	MFH-75/ MFH-45	75-250	8	450-640
	MFH-75/ MFH-45 x2 pcs	75-250	8	450-640
MFH-F315	MFH-75/ MFH-45	110-315	6	520-740
	MFH-75/ MFH-45 x2 pcs	110-315	6	520-740
MFH-F450	MFH-75/ MFH-60	160-450	2.4	620-880
	MFH-75/ MFH-45 x2 pcs	160-450	2.4	620-880
MFH-F500	MFH-90/ MFH-50	160-500	2.4	700-1000
	MFH-90/ MFH-45 x2 pcs	160-500	2.4	700-1000
MFH-F630	MFH-90/ MFH-50	315-600	1.2	840-1200
	MFH-90/ MFH-50 x2 pcs	315-600	1.2	840-1200
MFH-F800	MFH-90/ MFH-60	400-800	1	980-1400
	MFH-90/ MFH-50 x2 pcs	400-800	1	980-1400
MFH-F1000	MFH-90/ MFH-75	500-1000	1	980-1400
	MFH-90/ MFH-60 x2 pcs	500-1000	1	980-1400
MFH-F1200	MFH-120/ MFH-60	630-1200	0.8	1100-1600
	MFH-120/ MFH-60 x2 pcs	630-1200	0.8	1100-1600
MFH-F1600	MFH-120/ MFH-75	1000-1600	0.6	1250-1800
	MFH-120/ MFH-60 x2 pcs	1000-1600	0.6	1250-1800
MFH-F2000	MFH-120/ MFH-90	1200-2000	0.5	1300-2000
	MFH-120/ MFH-75 x2 pcs	1200-2000	0.5	1300-2000

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

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JWELL-MFH 系列 PO(PP-R、PE-RT、PB) 聚烯烃一模双出管材高速节能挤出生产线

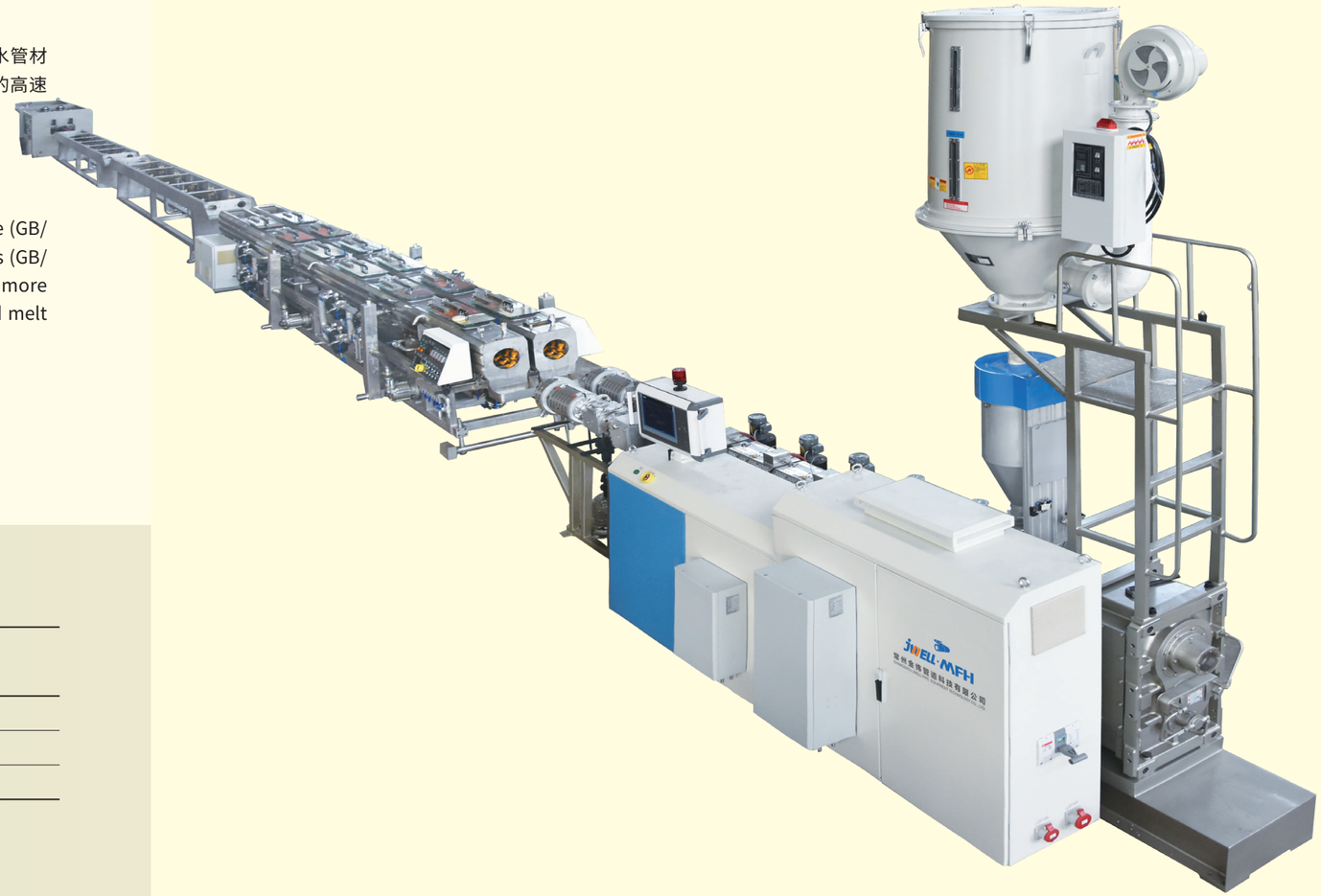
JWELL-MFH Series PO(PP-R, PE-RT, PB) Polyolefin One Die Double Outlet Tube High Speed Energy Saving Extrusion Production Line.

设备简介：

该生产线主要用于生产一模双出聚丙烯冷热水管材 (GB/T18742.2-2002) 更换或增加部分单元亦可生产耐热聚乙烯冷热水管材 (GB/T28799.2-2012) 及聚丁烯冷热水管材 (GB/T19473.2-2004)，特别设计的专用螺杆更适合 PP-R、 PE-RT 及 PB 管材的高速稳定生产，选装集成米重及熔体泵实现速度米重的闭环控制。

Brief introduction of equipment:

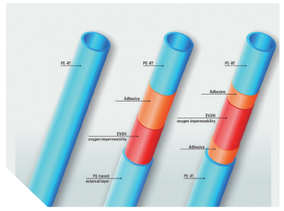
The production line is mainly used for the production of a double extruded polypropylene cold and hot water pipe (GB/T18742-2002). To replace or add some units can also produce heat resistant polyethylene cold and hot water pipes (GB/T28799.2-2012) and polybutene cold and hot water pipes (GB/T19473.2-2004). The specially designed screw is more suitable for PP-R, PE-RT and PB pipes with high speed and stable production, Used integrated weight control and melt pump system to realize the closed-loop control of the pipe meter weight.



主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F32	MFH-75	8-32	50	480-600	
MFH-F63	MFH-75	16-63	40	480-740	
MFH-F110	MFH-90	20-110	30	480-880	

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.



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JWELL-MFH 系列 PO(PE-RT、PB) 聚烯烃三层或五层阻氧管挤出生产线

JWELL-MFH Series PO(PE-RT, PB) Polyolefin Oxygen Resistant Three Layers Or Five Layers Extrusion Line

设备简介：

该生产线主要用于生产三层或五层阻氧耐热聚乙烯冷热水管材 (GB/T28799.2-2012) 更换或增加部分单元亦可生产三层或五层阻氧聚丁烯冷热水管材 (GB/T19473.2-2004)，三层或五层阻氧管材解决了普通管材不能阻止氧气渗透，导致管道系统寿命缩短、安全性下降等问题，管材采用三层 (外层为 EVOH+ 中间层胶水 + 内层 PERT) 或管材采用五层 (外层 PERT+ 胶水 + 中间层 EVOH+ 胶水 + 内层 PERT)，通过利用 EVOH 的阻隔特点来实现管材的阻氧性能。

Brief introduction of equipment:

The production line is mainly used for the production of three or five layers of oxygen resistant polyethylene cold and hot water pipes (GB/T28799.2-2012). The replacement or addition of some units can also produce three or five layers of oxygen resis- tant polybutene cold and hot water pipes (GB/T19473.2-2004).Three or five layers of oxygen resistant pipes solve the problem that ordinary pipes can't prevent oxygen permeation.Lead to problems such as shortening the life of the pipe and lowering safering.The tube adopts three layers (outer layer is evoh interlayer glue innerlayer PERT) or pipe adopts five layers (outer layer PERT+glue+interlayer EVOH+glue+innerlayer PERT), through the use of EVOH barrier characteristics to achieve the oxygen resistance of the pipe.

主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F32	MFH-45/ MFH-45 x2 pcs	16-32	20	120-200	

备注 : 以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

JWELL-MFH 系列纤维无规共聚聚丙烯（PP-R）复合管高速挤出生产线

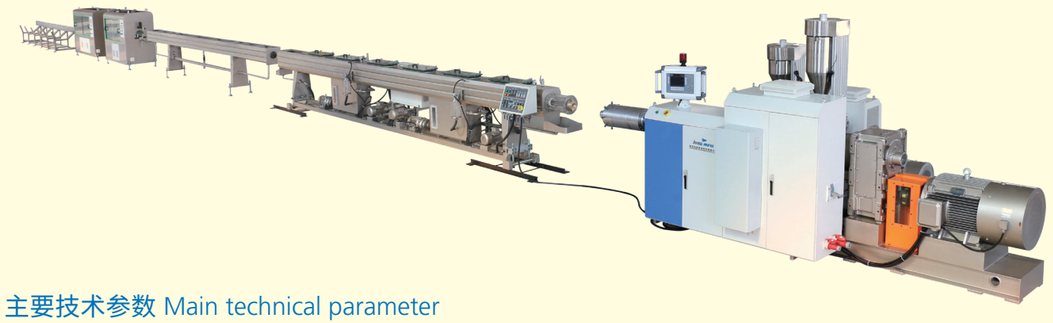
JWELL-MFH Series Fiber Random Copolymerization Polypropylene (PP-R) Composite Pipe Energy-Saving And High Speed Extrusion Line.

设备简介：

该生产线主要用于生产纤维增强无规共聚聚丙烯复合管材 (CJ/T258-2007)，采用两机或三机共挤，该管材成品与普通 PP-R 管材相比具有耐压强度高、高温变形小、膨胀系数低等优点。

Brief introduction of equipment:

This production line is mainly used to produce fiber reinforced random copolymerization polypropylene composite pipe (CJ/T258-2007). Co-extrusion with two or three extruders. Compared with ordinary PPR pipe, the finished product has the advantages of high compressive strength, low deformation at high temperature, low expansion coefficient and so on.



主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F63	MFH-60/ MFH-45	20-63	30	200-300	
MFH-F63	MFH-45 x3 pcs	20-63	30	200-300	
MFH-F110	MFH-60/ MFH-45	50-110	10	250-350	
MFH-F110	MFH-45 x3 pcs	50-110	10	250-350	
MFH-F160	MFH-60/ MFH-45	40-160	10	300-400	
MFH-F160	MFH-50 x3 pcs	40-160	10	300-400	

备注 : 以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

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卧式双壁波纹管生产线

Horizontal Double Wall Corrugated Production Line

性能特点

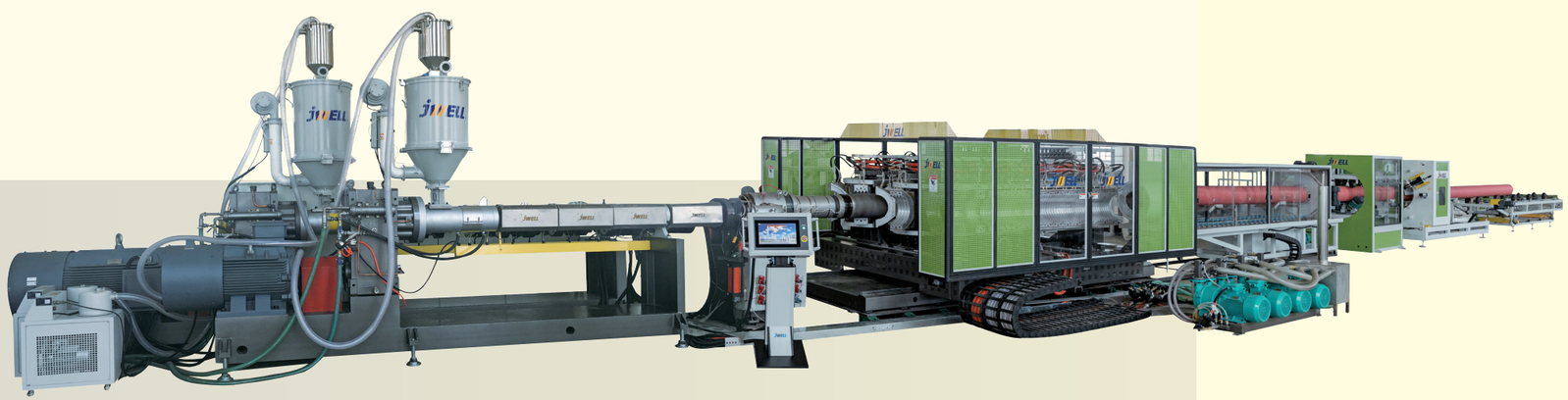
金纬公司最新开发的卧式双壁波纹管生产线，是在充分吸收国内外先进技术的基础上，自主研发的新一代卧式压力水冷生产线，拥有十多项发明专利。

- 有多种类型挤出机可供选择，可实现 HDPE、PP 各种管材的生产，也可满足单壁波纹管生产需求。
- 定径套选用铝合金材质，表面经耐磨处理；管材波形经过专门的软件程序计算，可以在同样的米重下获得更优的环刚度。
- 成型机滑动底座为齿轮传动，装有大尺寸滚针轴承，提高了滑动底座的承载力；运行更平稳，寿命更长。
- 生产线为固定中心高，更换规格时不需再次调整。
- 不同规格生产线模块通用；快卸式模块设计，使模块装卸方便快捷；独特模块内冷却设计，使冷却水在模块内部快速的流动，实现管材的快速冷却定型；主传动采用双速电机驱动，可以实现稳定精确运行。
- 采用先进的PLC与彩色大屏幕液晶显示屏组成的控制系统，可单机调整，全线联动，操作简单，生产稳定可靠，自动化程度高，故障自动报警。

Performance and feature:

Jwell’s newly developed horizontal double-wall corrugated production line is a second-generation horizontal pressure water cooling production line, which is independently developed on the basis of domestic and international advanced technologies. It has more than ten invention patents.

- There are a variety of types of extruders to choose, which can achieve the production of various HDPE, PP pipe, also can meet the production demand of single-wall corrugated pipe.
- Sizing sleeve is made of aluminum alloy, and the surface is wear-resistant. The tube waveform can be calculated by special software program, and the ring stiffness can be obtained at the same weight.
- The sliding base of forming machine is geared and equipped with large size needle roller bearing, which improves the bearing capacity of the sliding base. More stable operation, longer life.
- Production line is fixed center height, and there is no need to adjust again when changing model;
- Common production line modules with different specifications. Quick unloading module design makes module loading and unloading convenient and fast. The unique internal module cooling design enables the cooling water to flow rapidly. internal module realizes the rapid cooling and shaping of pipes. The main drive is driven by a two-speed motor, which can realize stable and accurate operation.
- Using advanced PLC and color LCD control system, which can be adjusted by single machine, linkage of all lines,simple operation, stable and reliable production, high degree of automation, automatic fault alarm.



主要技术参数 Main technical parameter

生产线型号 Line Type	管材规格 (mm) Pipe Size	生产速度 (m/min) Speed	总装机功率 (Kw) Total Power	生产线长宽 (m) Product line
JWBW-150	ID40-150	Max 15	270	length and width
JWBW-300	ID100-300	Max 7.5	340	30×6
JWBW-600	ID100-600	Max 5.5	490	34×6
JWBW-800	ID200-800	Max 4.2	615	38×8
JWBW-1000	ID300-1000	Max 2.9	795	38×8.5
JWBW-1200	ID400-1200	Max 2	890	38×9
JWBW-1500	ID600-1500	Max 1.2	1110	42×9.5

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

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JWELL-MFH 系列聚氯乙烯 (PVC) 管材挤出生产线

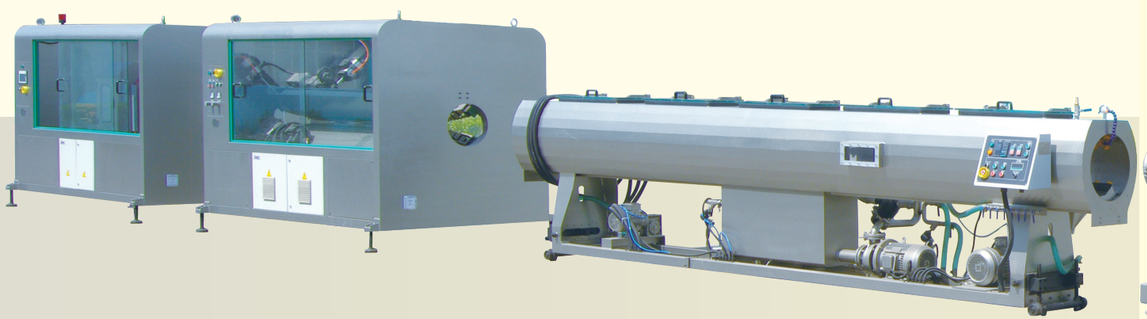
JWELL-MFH Series Polyvinyl Chloride (PVC) Pipe Extrusion Line

设备简介：

该生产线主要用于生产埋地式高压电力电缆氯化聚氯乙烯 (CPVC) 套管 (QB/T2479-2000)、 给水用硬聚氯 乙烯 (UPVC) 管材 (GB/T10002.1-2006)、生产埋地无压排污、排水用硬聚氯乙烯 (UPVC) 管材 (GB/T20221.1-2006)、低压输 送灌溉用硬聚氯乙烯 (UPVC) 管材 (GB/T13664.1-2006)、建筑排水用硬聚氯乙烯 (UPVC) 管材 (GB/T5836.1-2006)、冷热水用 氯化聚氯乙烯 (CPVC) 管材 (GB/T18993.2-2003)、工业用氯化聚氯乙烯 (CPVC) 管材 (GB/T18998.2-2003)

Performance and advantage:

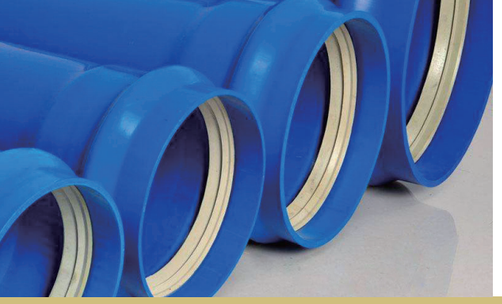
The production line is mainly used for the production of buried high-voltage power cable protection chlorinated polyvinyl chloride (CPVC) pipe (QB/T2479-2000),water supply UPVC pipe (GB/T10002.1-2006), unpressurized sewage and drainage hard polyvinyl chloride (UPVC) pipe (GB/T20221.1-2006), low pressure transportation irrigation hard polyvinyl chloride (UPVC) pipe (GB/ t13664.1-2006), construction drainage with hard polyvinyl chloride (UPVC) pipe (GB/T5836.1-2006), cold and heat water chlorinated polyvinyl chloride (CPVC) pipe (GB/ T18993.2-2003), industrial polyvinyl chloride (CPVC) pipe (GB/T18998.2-2003).

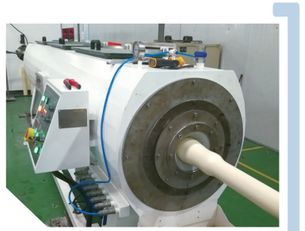


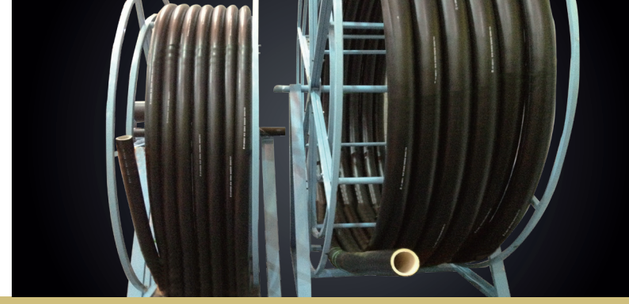
主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F32(四管 Four strand)	MFH-ZS65/132	16-32	10*4	200-300	
MFH-F63(两管 Two strand)	MFH-ZS65/132	20-63	10*2	200-300	
MFH-F110(两管 Two strand)	MFH-ZS80/156	50-110	10*2	300-500	
MFH-F160	MFH-ZS65	63-160	10	150-300	
MFH-F250	MFH-ZS65	50-250	8	250-300	
MFH-F400	MFH-ZS80	110-400	2.4	300-500	
MFH-F630	MFH-ZS92	315-630	1.2	500-750	

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.







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JWELL-MFH 系列双向拉伸聚氯乙烯 (PVC-O) 管材挤出生产线

JWELL-MFH Series Biaxial Oriented Polyvinyl Chloride (PVC-O) Pipe Extrusion Line

设备简介：

该生产线主要用于生产双向拉伸聚氯乙烯 (PVC-O) 给水管材 (CJ/T445-2014)，更换部分单元亦可生产埋地式高压电力电缆氯化聚氯乙烯 (CPVC) 套管 (QB/T2479-2000) 的替代产品，采用挤出生产的 UPVC 管材在线二次经特殊工艺将管材轴向与径向拉伸后，使得 PVC 分子链有规律排列，从而获得优异的机械 (强度、韧性、抗疲劳、抗冲等) 性能。

Brief introduction of equipment:

The production line is mainly used for production of polyvinyl chloride bidirectional stretch (PVC-O) water supply pipe (CJ/T445-2014) or electrical wire sheath pipe, used extruded UPVC pipe which extend the axial and radial direction, making the PVC molecular chain is arranged regularly, thus obtaining excellent mechanical (strength, toughness, resistance to fatigue, shock resistance, etc.)

主要技术参数 Main technical parameter

生产线型号 Line Type	主机型号 Extruder Type	生产范围 Pipe Range(mm)	最大牵引速度 Max. Speed (m/min)	最大生产能力 Max.Capacity(kg/h)	备注 Remarks
MFH-F250	MFH-ZS80	110-250	4	100-220	
MFH-F400	MFH-ZS80	200-400	2	150-300	
MFH-F630	MFH-ZS92	315-630	1	280-450	

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

高压 RTP 编织复合管道生产线 / 钢丝缠绕管生产线

High Pressure RTP Twisted Composite Pipe Extrusion Line

性能和优点：

热塑性塑料增强管 RTP 大部分是三层结构，内层是耐腐蚀耐磨损的聚乙烯管 (PE100)，中层是增强的缠绕层 (缠绕的材料有高强度合成纤维，玻璃纤维，碳纤维、金属铁片和细金属丝多种)，外层是保护用的聚乙烯 (PE100) 层。 芳纶纤维增强 RTP 的工作压力可高达到 9-14Mpa，爆破压力可高达 40Mpa。

Performance and feature:

The thermoplastic reinforced pipe RTP has three layers: the inner layer is anti-erosion and wearing-resistant PE pipe; the middle layer is reinforced twisting layer (the material is high-intension synthesized fiber, or glass fiber, carbon fiber or fine metal thread); the outer layer is PE for protection use. The most popular reinforce material is Aramid fiber. The pressure of Aramid fiber reinforced pipe is up to 9-14Mpa. The explode pressure can be 40Mpa.

主要技术参数 Main technical parameter

生产线型号 Line Type	管材规格 Model(mm)	配套挤出机 Extruder	最大挤出量 Output(kg/h)	总装机功率 Power(kW)
MFH-F160	Ø63~Ø160	MFH-65	120-300	160
MFH-F250	Ø75~Ø250	MFH-75	300-500	210
MFH-F315	Ø110~Ø315	MFH-75	300-500	210

备注：以上规格参数如有变更，恕不另行通知。Note:The specifications are subject to change without prior notice.

PE100 级聚乙烯管材公称压力和规格尺寸

PE100 给水用聚乙烯（PE）管材国家标准（GB/T 13663-2018）

" 公称外径 dn"	公称壁厚 en/mm							
	标准尺寸比							
	SDR9	SDR11	SDR13.6	SDR17	SDR21	SDR26	SDR33	SDR41
	管系列							
	S4	S5	S6.3	S8	S10	S12.5	S16	S20
	"PE80 级公称压力 MPa"							
	1.6	1.25	1.0	0.8	0.6	0.5	0.4	0.32
	"PE100 级公称压力 MPa"							
	2.0	1.6	1.25	1.0	0.8	0.6	0.5	0.4
16	2.3	—	—	—	—	—	—	—
20	2.3	2.3	—	—	—	—	—	—
25	3.0	2.3	2.3	—	—	—	—	—
32	3.6	3.0	2.4	2.3	—	—	—	—
40	4.5	3.7	3.0	2.4	2.3	—	—	—
50	5.6	4.6	3.7	3.0	2.4	2.3	—	—
63	7.1	5.8	4.7	3.8	3.0	2.5	—	—
75	8.4	6.8	5.6	4.5	3.6	2.9	—	—
90	10.1	8.2	6.7	5.4	4.3	3.5	—	—
" 公称外径 dn"	公称壁厚 en/mm							
	标准尺寸比							
	SDR9	SDR11	SDR13.6	SDR17	SDR21	SDR26	SDR33	SDR41
	管系列							
	S4	S5	S6.3	S8	S10	S12.5	S16	S20
	"PE80 级公称压力 MPa"							
	1.6	1.25	1.0	0.8	0.6	0.5	0.4	0.32
	"PE100 级公称压力 MPa"							
	2.0	1.6	1.25	1.0	0.8	0.6	0.5	0.4
110	12.3	10.0	8.1	6.6	5.3	4.2	—	—
125	14.0	11.4	9.2	7.4	6.0	4.8	—	—
140	15.7	12.7	10.3	8.3	6.7	5.4	—	—
160	17.9	14.6	11.8	9.5	7.7	6.2	—	—
180	20.1	16.4	13.3	10.7	8.6	6.9	—	—
200	22.4	18.2	14.7	11.9	9.6	7.7	—	—
225	25.2	20.5	16.6	13.4	10.8	8.6	—	—
250	27.9	22.7	18.4	14.8	11.9	9.6	—	—
280	31.3	25.4	20.6	16.6	13.4	10.7	—	—
315	35.2	28.6	23.2	18.7	15.0	12.1	9.7	7.7
355	39.7	32.2	26.1	21.1	16.9	13.6	10.9	8.7
400	44.7	36.3	29.4	23.7	19.1	15.3	12.3	9.8
450	50.3	40.9	33.1	26.7	21.5	17.2	13.8	11.0
500	55.8	45.4	36.8	29.7	23.9	19.1	15.3	12.3
560	62.5	50.8	41.2	33.2	26.7	21.4	17.2	13.7
630	70.3	57.2	46.3	37.4	30.0	24.1	19.3	15.4
710	79.3	64.5	52.2	42.1	33.9	27.2	21.8	17.4
800	89.3	72.6	58.8	47.4	38.1	30.6	24.5	19.6
900	—	81.7	66.2	53.3	42.9	34.4	27.6	22.0
1000	—	90.2	72.5	59.3	47.7	38.2	30.6	24.5
1200	—	—	88.2	67.9	57.2	45.9	36.7	29.4
1400	—	—	102.9	82.4	66.7	53.5	42.9	34.3
1600	—	—	117.6	94.1	76.2	61.2	49.0	39.2
1800	—	—	—	105.9	85.7	69.1	54.5	43.8
2000	—	—	—	117.6	95.2	76.9	60.6	48.8
2250	—	—	—	—	107.2	86.0	70.0	55.0
2500	—	—	—	—	119.1	95.6	77.7	61.2

注：公称压力按照 C=1.25 计算。

DIMENSIONS OF PIPES

Dimension specification for HDPE pipe refer to ISO 4427-2:2007

Material	SD6		SDR7.4		SDR9		SDR11		SDR13.6		SDR17		SDR21		SDR26		SDR33		SDR41	
PE80	PN25		PN20		PN16		PN12.5		PN10		PN8		PN6		PN5		PN4		PN3.2	
PE100	-		PN25		PN20		PN16		PN12.5		PN10		PN8		PN6		PN5		PN4	
dn	e	ID	e	ID	e	ID	e	ID	e	ID	e	ID	e	ID	e	ID	e	ID	e	ID
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
16	3.0	10.0	2.3	11.4	2.0	12.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
20	3.4	13.2	3.0	14.0	2.3	15.4	2.0	16.0	-	-	-	-	-	-	-	-	-	-	-	-
25	4.2	16.6	3.5	18.0	3.0	19.0	2.3	20.4	2.0	21.0	-	-	-	-	-	-	-	-	-	-
32	5.4	21.2	4.4	23.2	3.6	24.8	3.0	26.0	2.4	27.2	2.0	28.0	-	-	-	-	-	-	-	-
40	6.7	26.6	5.5	29.0	4.5	31.0	3.7	32.6	3.0	34.0	2.4	35.2	2.0	36.0	-	-	-	-	-	-
50	8.3	33.4	6.9	36.2	5.6	38.8	4.6	40.8	3.7	42.6	3.0	44.0	2.4	45.2	2.0	46.0	-	-	-	-
63	10.5	42.0	8.6	45.8	7.1	48.8	5.8	51.4	4.7	53.6	3.8	55.4	3.0	57.0	2.5	58.0	-	-	-	-
75	12.5	50.0	10.3	54.4	8.4	58.2	6.8	61.4	5.6	63.8	4.5	66.0	3.6	67.8	2.9	69.2	-	-	-	-
90	15.0	60.0	12.3	65.4	10.1	69.8	8.2	73.6	6.7	76.6	5.4	79.2	4.3	81.4	3.5	83.0	-	-	-	-
110	18.3	73.4	15.1	79.8	12.3	85.4	10.0	90.0	8.1	93.8	6.6	96.8	5.3	99.4	4.2	101.6	-	-	-	-
125	20.8	83.4	17.1	90.8	14.0	97.0	11.4	102.2	9.2	106.6	7.4	110.2	6.0	113.0	4.8	101.6	-	-	-	-
140	23.3	93.4	19.2	101.6	15.7	108.6	12.7	114.6	10.3	119.4	8.3	123.4	6.7	126.6	5.4	129.2	-	-	-	-
160	26.6	106.8	21.9	116.2	17.9	124.2	14.6	130.8	11.8	135.4	9.5	141.0	7.7	144.6	6.2	147.6	-	-	-	-
180	29.9	120.2	24.6	130.8	20.1	139.8	16.4	147.2	13.3	153.4	10,7	158.6	8.6	162.8	6.9	166.2	-	-	-	-
200	33.2	133.6	27.4	145.2	22.4	155.2	18.2	163.6	14.7	170.6	11.9	176.2	9.6	180.8	7.7	184.6	-	-	-	-
225	37.4	150.2	30.8	163.4	25.2	174.6	20.5	184.0	16.6	191.8	13.4	198.2	10.8	203.4	8.6	207.8	-	-	-	-
250	41.5	167.0	34.2	181.6	27.9	194.2	22.7	204.6	18.4	213.2	14.8	220.4	11.9	226.2	9.6	230.8	-	-	-	-
280	46.5	187.0	38.3	203.4	31.3	217.4	25.4	229.2	20.6	238.8	16.6	246.8	13.4	253.2	10.7	258.6	-	-	-	-
315	52.3	210.4	43.1	228.8	35.2	244.6	28.6	257.8	23.2	268.6	18.7	277.6	15.0	285.0	12.1	290.8	9.7	295.6	7.7	299.6
355	59.0	237.0	48.5	258.0	39.7	275.6	32.2	290.6	26.1	302.8	21.1	312.8	16.9	321.3	13.6	327.8	10.9	333.2	8.7	337.6
400	-	-	54.7	290.6	44.7	310.6	36.3	327.4	29.4	341.2	23.7	352.6	19.1	361.8	15.3	369.4	12.3	375.4	9.8	380.4
450	-	-	61.5	327.0	50.3	349.4	40.9	368.2	33.1	383.8	26.7	396.6	21.5	407.0	17.2	415.6	13.8	422.4	11.0	428.0
500	-	-	-	-	55.8	388.4	45.4	409.2	36.8	426.4	29.7	440.6	23.9	452.2	19.1	461.8	15.3	469.4	12.3	475.4
560	-	-	-	-	62.5	435.0	50.8	458.4	41.2	477.6	33.2	493.6	26.7	506.6	21.4	517.2	17.2	525.4	13.7	532.6
630	-	-	-	-	70.3	489.4	57.2	515.6	46.3	537.4	37.4	555.2	30.0	570.0	24.1	581.8	19.3	591.4	15.4	599.2
710	-	-	-	-	79.3	551.4	64.5	581.0	52.2	605.6	42.1	625.8	33.9	642.2	27.2	655.6	21.8	666.4	17.4	675.2
800	-	-	-	-	89.3	621.4	72.6	654.8	58.8	682.4	47.4	705.2	38.1	723.8	30.6	738.8	24.5	751.0	19.6	760.8
900	-	-	-	-	-	-	81.7	736.6	66.2	767.6	53.3	793.4	42.9	814.2	34.4	831.2	27.6	844.8	22.0	856.0
1000	-	-	-	-	-	-	-	-	72.5	855.0	59.3	881.4	47.7	904.6	38.2	923.6	30.6	938.8	24.5	951.0
1200	-	-	-	-	-	-	-	-	88.2	1023.6	67.9	1064.2	57.2	1085.6	45.9	1108.2	36.7	1126.6	29.4	1141.2
1400	-	-	-	-	-	-	-	-	102.9	1194.2	82.4	1235.2	66.7	1266.6	53.5	1293.0	42.9	1314.2	34.3	1331.4
1600	-	-	-	-	-	-	-	-	117.6	1364.8	94.1	1411.8	76.2	1447.6	61.2	1477.2	49.0	1502.0	39.2	1521.6
1800	-	-	-	-	-	-	-	-	-	-	105.9	1588.2	85.7	1628.6	69.1	1661.8	54.5	1691.0	43.8	1712.4
2000	-	-	-	-	-	-	-	-	-	-	117.6	1764.8	95.2	1764.8	76.9	1846.2	60.6	1878.8	48.8	1902.4

dn: Pipe Outside Diameter, mm
e: Wall thickness, mm

企业风采：品质管理 技术研发 客户服务 国际交流 员工培训

Quality Control Technology Research Customer Service International Communication Staff Training

Note:

24小时服务
24 Hours Service

客户服务热线
Customer Service Hotline

培 训
Training

交钥匙工程
Turn-Key Project