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GUANGDONG LIANSU MACHINERY MANUFACTURING CO.,LTD

Address: Daba Industrial Area,Longjiang Town,Shunde Section,Foshan City, Guangdong, China  
Tel: +86-757-23888569 / +86-757-23365136  
Fax: +86-757-23888558  
E-mail: liansu-extrusion@liansu.com  
Website: www.ls-extrusion.com

GUANGDONG LIANSU MACHINERY MANUFACTURING CO.,LTD

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# COMPANY PROFILE

Guangdong Liansu Machinery Manufacture Co.,Ltd is a plastic extrusion equipments high-tech enterprise that specialized in researching,manufacturing,saling and serving.The company was founded in 1994,located in Daba Industrial zone Longjiang Town Shunde,has developed the scale to the enterprise employees 600 people,floor area over 8,6000 square meters,covered area over 6,0000 square meters;The company is one of China largest plastic extruder production foundation,relies on strong technology and product development ability,continuous research on development and innovation, its excellent product quality and high performance technical strength to establish the enterprise brand; continue to develop the market at home and abroad,set up a multiple marketing network,so as to make the products mainly exported to the United States, Australia, Russia, Egypt, South Africa, South America, southeast Asia, the Middle East and Europe and other countries and regions.Customers spread all over the world.Products include plastic pipe production line,sheet production line,profile production line,steel-plastic composite production line,WPC pipe production line,pelletizing pipe production line,extrusion mould,injection mould,plastic steel doors and windows production line,etc.Compared to the same industry,company scale strength and benefits are among the best of candidates.

Liansu machine has a senior professional technical team,high quality management team,marketing team and after-sales team.We will always put the interests of customers first,constantly improve the product technology and quality level ,provide the most competitive plastic machinery and technology to customers,launch the latest products with the fastest speed,and create the most value for customers.

Liansu machinery always adhere to a high starting point, and a management policy of"Take quality as life,take science and technology as leader,take customer satisfaction as



purpose":constantly strengthen technical innovation and brand establishment, center on energy conservation and environmental protection, high efficiency and high reliability so as to carry out technology development and improvement,constantly increase investment in technology,vigorously introduce technical personnel,cooperate with European enterprises to strengthen the technical cooperation,apply 129 items patents,totally got 52 items authorized patents,including 6 items invention patents,44 items utility model patent, 2 items appearance patent;be about to get 77 items authorized patents,including 26 items invention patents,51 items utility model patents;high-quality PVC conical twin-screw extrusion technology,efficient single screw extrusion technology and new developed inverted parallel twin-screw extrusion technology;PVC,PP-R,PE(large diameter) pipe extrusion technology, HDPE spiral forming technology;PVC,PE double-wall corrugated pipe forming technology; PVC plastic-steel windows and doors profiles extrusion technology; PC,PP hollow grid plate extrusion technology; PE APCP(Aluminum-plastic Composite Panel) extrusion technology; PPPVC ultra-thickness plate extrusion technology; PE,PS,ABS,PC,PMMA and others plate sheet extrusion technology;PVC mixing system and flaring equipment,etc.Company constantly improve and create new technology,improve the product technology level and quality level,so to get the appreciation and recognition of customers around the world,strive to build a world-class plastic machine manufacture enterprise.

## 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

## 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



- 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 developed "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 ISO9000 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 pipe Internal and external screw thread connection technology, won the Shunde Zone major scientific and technical project finance 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 finance 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, honored as National high-tech enterprises.
- Honored as Guangdong Province machinery industry association vice-chairman unit in 2012; Chinese Plastic machinery association council member.
- In 2014, honored as Guangdong Province work safety standardization second level enterprise.
- Pass the 2015 creative application demonstration project inspection of first-generation numerical control mechanical products of Guangdong province.



## THE EXTRUSION TECHNOLOGY FOR PIPE

**LIANSU**

- 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-HDPE Pressure Pipe and Gas Pipe Extrusion Line
- 11 LS-Multi Layer Pipe Extrusion Line
- 13 LSP-32PERT Pipe Extrusion Line
- 15 LS-Pex Aluminum Plastic Composite Pipe Production Line
- 16 LS-Single Wall Corrugated Pipe Extrusion Line
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- 19 LS-PVC Soft Hose Extrusion Line
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- 22 LS-Conical Twin Screw Extruder
- 23 LS-Parallel Twin-Screw Extruder
- 24 LS-Single Screw Extruder
- 25 LS-Tank
- 26 LS-Haul-Off Unit
- 27 LS-Cutting
- 28 LS-COILER
- 29 LS-Mixer Unit
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- 31 LS-PVC Die Head
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- 33 Calibrating
- 34 On-Line Bundling & Bagging Machine
- 35 Standard



# LS-PVC Conduit

## Four Pipe Production line



STACKER      HAUL OFF & CUTTING UNIT      VACUUM TANK      DIE HEAD      EXTRUDER

### MAIN FEATURES

- Four cavity extrusion, a production line produces four pipes at the same time in high efficiency.
- Each station of downstream is independent control, like each station of vacuum calibrating, vacuum abnormal alarm, hauling, cutting and stacker, it's convenient during operation.
- Stable speed of each station can reach 16m/min, eg: Ø16x1.5, it is up to 60-70m/min.
- Unique swarfless double cutting device, light structure, fast cutting, smooth cutting edge, perfect cutting end.



### HAUL - OFF UNIT

- The encoding is the servo motor slipway structure. And one can quickly choose the single sprayer or double sprayer to proceed encoding.
- The hauling belt design can effectively prohibit the belt pulley from running off the track.

### CUTTER

- Super delicate cutting head (Patent code: ZL201420562930.1)
- Independent servo adjusting cutter rotary speed, swarfless cutting compatible with thick and thin pipe perfectly.
- PLC independent synchronous control hardware and arithmetic, making sure the accuracy of the cutting length.

### TANK

- Vacuum alarming for every section and waste pipe automatic cutting.



### BELLING MACHINE

- Optional to use with four pipe on-line socketing machine
- Double station heating and solvent bell design.



### MOLD



### MAIN TECHNICAL PARAMETER

MODEL	EXTRUDER MODEL	MAX HAULING SPEED (m/min)	MAX OUTPUT (kg/h)	TOTAL INSTALLED POWER (kw)	LINE LENGTH (m)
LSFP-32PVC	LSE-80	16	450	165	25
LSFP-32PVC	LSE-65	16	280	110	23





# LS-PVC

## Double Pipe Production line

### MAIN FEATURES

- Equipped with LSE65 extruder,the stable production speed can reach 2x16m/min
- Die head adopts stainless steel material, hard chroming surface,durable.
- Independent control in each section of the vacuum tank.avoid interference in production.
- The haul-off unit adopts optimized design of two/three caterpillar double-station.
- Double station independent control swarfless cutter, cutting length tolerance is within±3mm. Clean cut, no scraps, no flanging.



### DIE HEAD

- Reasonable compression ratio design, ensure the good melt and even extrusion.



### CUTTING UNIT

- Swarfless cutting avoids pollution in workshops, quiet.



### VACUUM TANK

- Completed tank adopts 304 stainless steel,individually control the vacuum and cooling water consumption.
- Spraying cooling and immersing for option.



MODEL	PIPE RANGE (m)	EXTRUDER MODEL	MAX HAULING SPEED (m/min)	MAX OUTPUT (kg/h)	TOTAL INSTALLED POWER (kw)	LINE LENGTH (m)
LSDP-63PVC	Ø16-Ø63	LSE-65/132	16x2	280	110	23
LSDP-75PVC	Ø16-Ø75	LSE-65/132	12x2	280	110	23
LSDP-110PVC	Ø75-Ø110	LSE-80/156	8x2	450	200	26
LSDP-110PVC	Ø75-Ø110	LSE-95/191	8x2	1000	390	36



# LS-UPVC

## Pipe Production Line

### MAIN FEATURES

- Extruder with high output more than 1000kg/h.
- Precise and customized die head design
- Double chamber vacuum tank with arc supporter for large diameter pipe, improving pipe formation quality
- Eight-caterpillar haul-off unit. When producing small pipes, only need to apply four caterpillars to clamp which is energy saving. Optional to use winching machine to reduce the cost of the hauling pipe.
- Planetary cutting, uniform chamfer
- Optional to use with on-line socketing machine

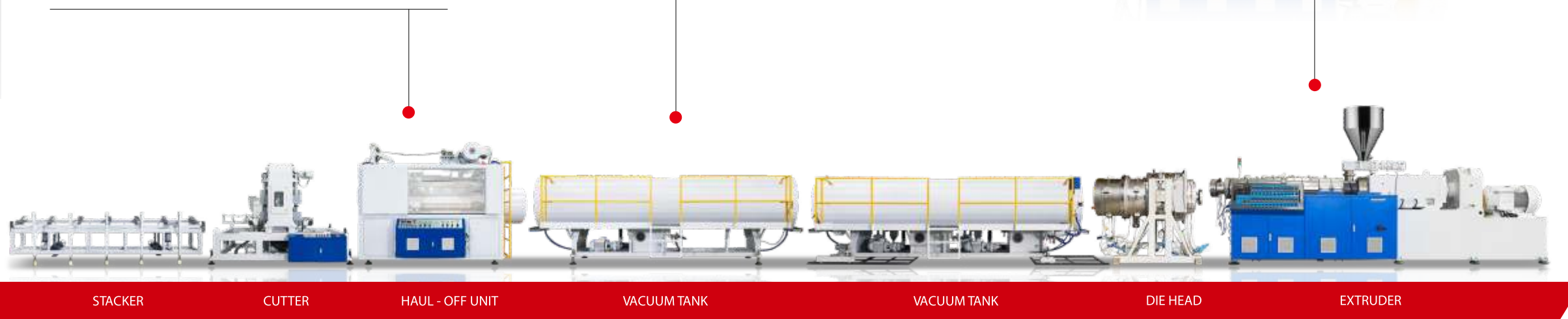


### SOCKETING PIPE

- Provide enough and even heating power inside and outside the pipe to make sure best socketing performance.

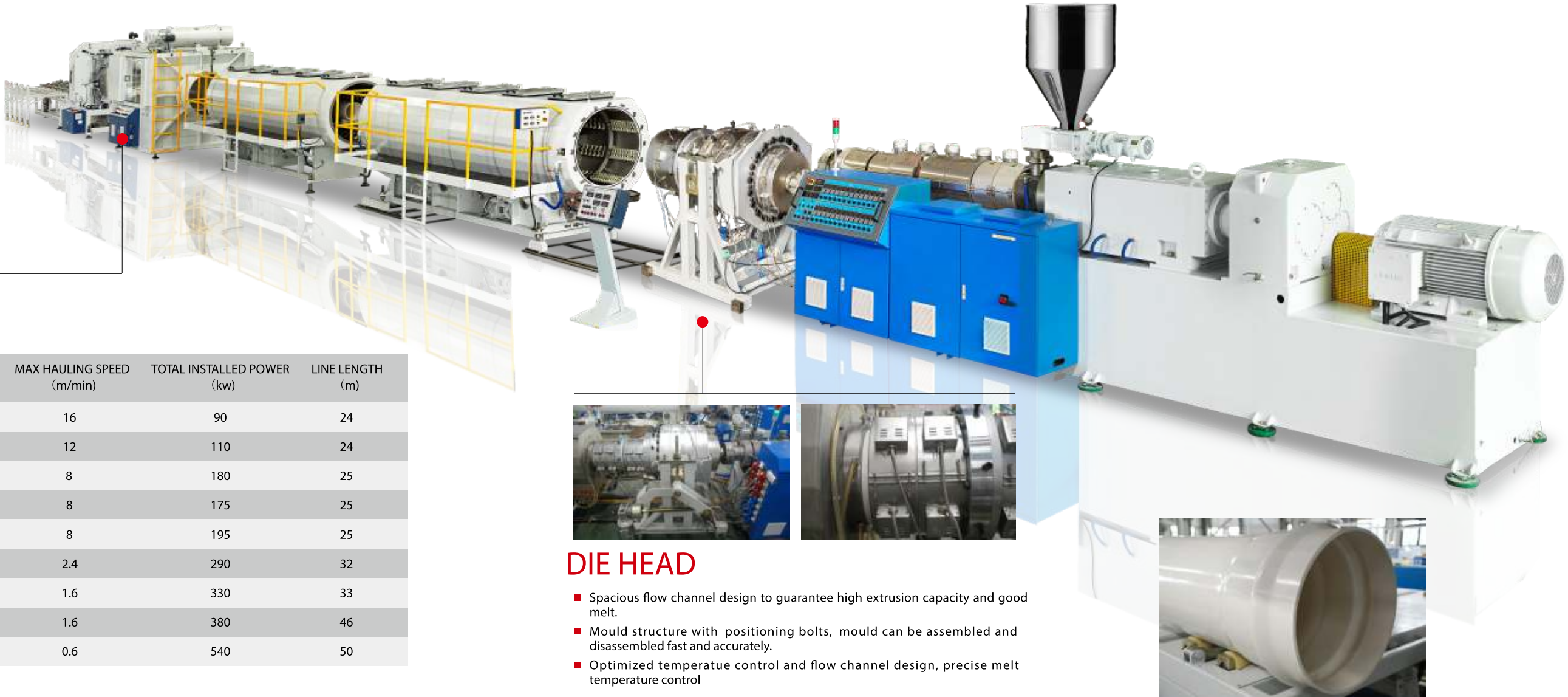


### EXTRUDER



### CUTTER

- New model of planetary cutting design, durable, dust-collecting efficiently, and quiet



### MAIN TECHNICAL PARAMETER

MODEL	PIPE RANGE (m)	EXTRUDER MODEL	MAX OUTPUT	MAX HAULING SPEED (m/min)	TOTAL INSTALLED POWER (kw)	LINE LENGTH (m)
LSP-63PVC	Ø16-Ø63	LSE-55	180	16	90	24
LSP-110PVC-I	Ø20-Ø110	LSE-65	280	12	110	24
LSP-110PVC-II	Ø63-Ø110	LSE-80	450	8	180	25
LSP-160PVC	Ø63-Ø160	LSE-80	450	8	175	25
LSP-250PVC-II	Ø63-Ø250	LSE-80	480	8	195	25
LSP-400PVC	Ø110-Ø400	LSE-92	750	2.4	290	32
LSP-630PVC	Ø160-Ø630	LSE-92	750	1.6	330	33
LSP-800PVC	Ø280-Ø800	LSE-95	1000	1.6	380	46
LSP-1000PVC	Ø630-Ø1000	LSE-95	1000	0.6	540	50



### DIE HEAD

- Spacious flow channel design to guarantee high extrusion capacity and good melt.
- Mould structure with positioning bolts, mould can be assembled and disassembled fast and accurately.
- Optimized temperature control and flow channel design, precise melt temperature control







# LS-PPR

## Pipe Production Line

### MAIN FEATURES

- Liansu developed screw with excellent plasticization performance and high output.
- Calibrator supplied with integrated graduated flow control valve
- Doubt-belt haul-off unit, applicable in high-speed production
- Chipless cutting head, clean cut, swarfless, and quiet



### CUTTER

- Cutter is synchroizedly controlled by servo motor to make sure precise cutting length.



### HAUL - OFF UNIT

- Haul-off unit running stable in high speed.
- The up and down belt adopts special gear meshing transmission, guarantee strict synchronous transmission.

### CO-EXTRUDER

- Color-strip extruder is mounted right on the main extruder , convenient operating and space saving.



CUTTER



HAUL - OFF UNIT



SPRAY TANK



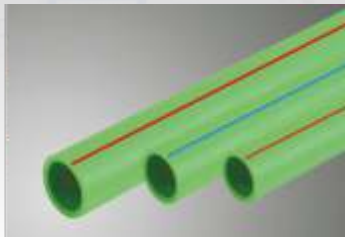
VACUUM TANK



DIE HEAD



EXTRUDER



### MAIN TECHNICAL PARAMETER

MODEL	PIPE DIAMETER RANG (m)	EXTRUDER MODEL	MAX OUTPUT (kg/h)	MAX HAULING SPEED (m/min)	TOTAL INSTALLED POWER (kw)	LINE LENGTH (m)
LSP-63PPR	Ø16-Ø63	LSS-65-34	200	25	165	53
LSP-110PPR	Ø20-Ø110	LSS-80-34	300	18	215	53
LSP-160PPR	Ø32-Ø160	LSE-82-34	300	7.5	225	53



### DIE HEAD

- Extrusion head with spiral structure, make sure the melt inside distributed evenly so as to achieve best plasticization.
- Calibrator design with water ring which is easy to clean, to achieve better cooling and then fast forming.
- The first chamber of the vacuum tank has pre-heating options to guarantee pipe quality.





# LS-HDPE

## Pressure and Gas Pipe Production Line

### MAIN FEATURES

- According to different pipe application and pipe pressure, we recommend different configurations of production line.
- With optimized screw design, we achieve high output and low power consumption, as well as good material plasticization at high screw RPM.
- The integrated gravimetric system allows us to detect the weight of product in real time, which saves production cost and guarantees pipe quality.
- Stainless steel material, with reasonable arrangement of pipelines, low power consumption.
- Die head designed with air exhausting system, which enhances the cooling efficiency, and on the other hand, reduce tank length, and save production cost.
- Optional to choose multi-caterpillar haul-off unit with wide speed range.
- Designed with double hydraulic system, the swarfless cutter offers a clean cut without flanging.

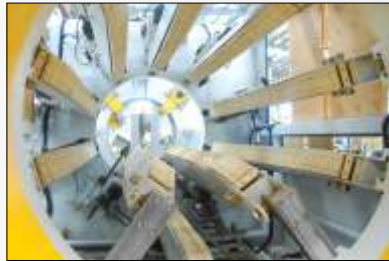
### CUTTER

- Cutter is synrhoneziedly controlled by servo motor to make sure precise cutting length.



### HAUL - OFF UNIT

- Optional to choose multi-caterpillar haul-off unit with wide speed range.



### VACUUM TANK

- Driven by hydraulic system, the vacuum tank can move forward and backward rapidly.
- Multi-caterpillar haul-off unit driven by independent motor applicable for a wide range of diameter pipe.
- Designed with integrated water supply system to reduce water consumption in production which is on the other hand, saving energy

### 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-63PE	Ø16-Ø63	LSS50-40	300	25	165	53
LSP-110PE	Ø20-Ø110	LSS50-40	300	14	180	55
LSP-160PE-I	Ø40-Ø160	LSS65-40	600	8	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	LSS120-40	1400	0.8	675	70
LSP-1200PE	Ø500-Ø1200	LSS120-40	1400	0.6	685	71
LSP-1600PE	Ø800-Ø1600	LSS120-40	1400	0.25	940	71



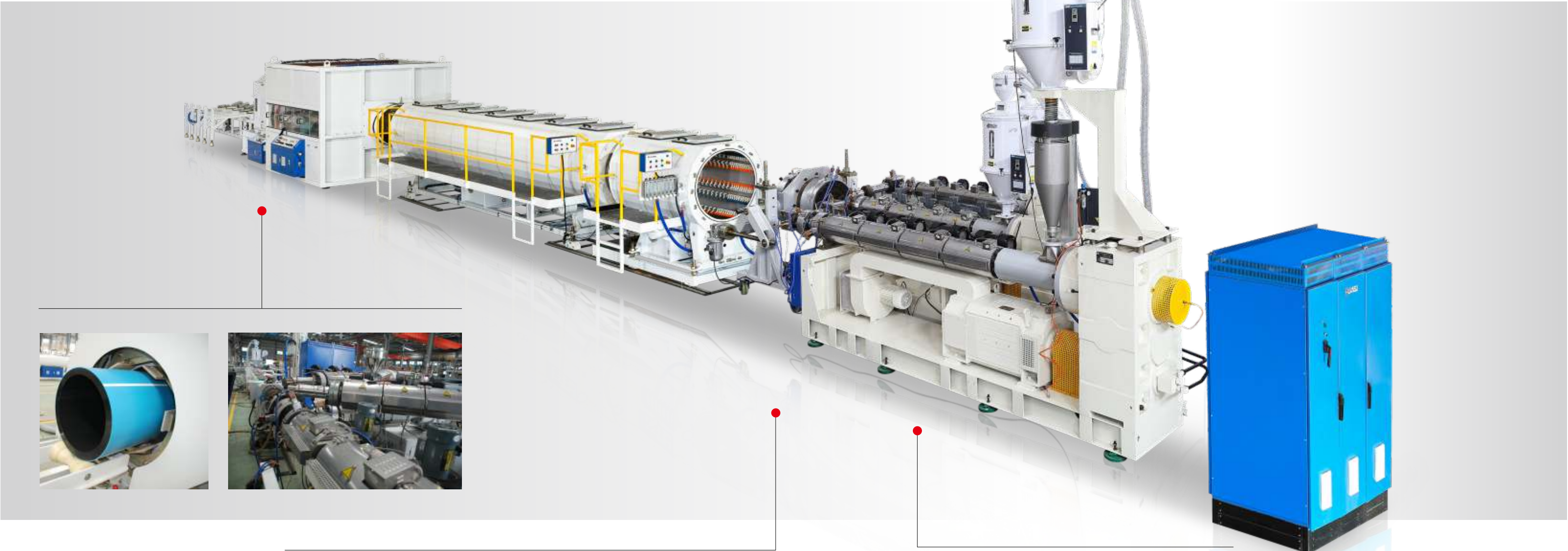
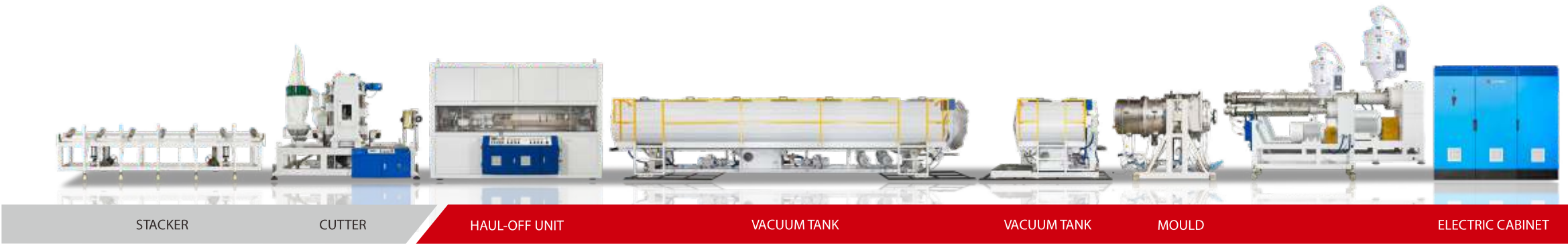


# LS-Multilayer

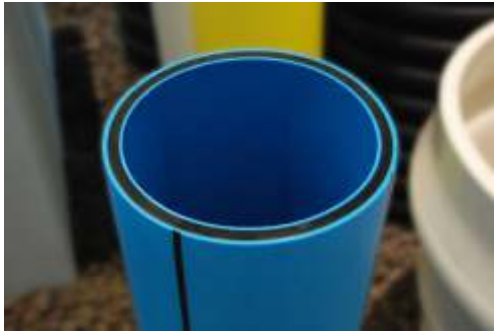
## Pipe Extrusion Line

### MAIN FEATURES

- Provide different manufacturing solutions for multi-layer pipes.
- According to different material nature, Liansu provides one or multiple spiral heads with reasonable and precise mould channel design to achieve even thickness and good plasticization in each layer.
- With double chamber design to achieve rapid forming
- Optional to choose double belt haul-off unit in production with high speed.
- Optional to choose multi-caterpillar haul-off unit with big reduction ratio.
- Designed with double hydraulic system, the swarfless cutter offers a clean cut without flanging.



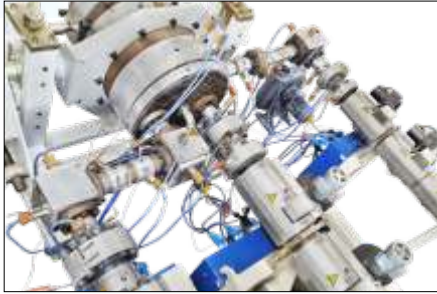
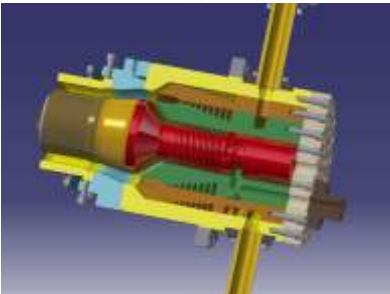
### PRODUCTS



Three-layer HDPE co-extruding pipe



Ø800 Five-layer PERT thermal insulating pipe



- Design with multiple spiral head, easy adjusting of the wall thickness.
- Different layer materials, multi-group extruding.





# LS-32HDPE/PERT

## Pipe Extrusion Line

### MAIN FEATURES

- The complete production line is applicable for high-speed production.
- Special screw design for PERT materials with better plasticizing & mixing effects.
- Coiler speed reach 50 m/min with on line strapping.



### 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)
LSP-32PERT-EVOH	Ø16-Ø32	LSS65-34	280	32	140	36
LSP-32PERT-EVOH	Ø16-Ø32	LSS40-30 X 2	280	32	140	36



### VACUUM TANK

- with water level control, ensuring the constant water pressure.



COILER



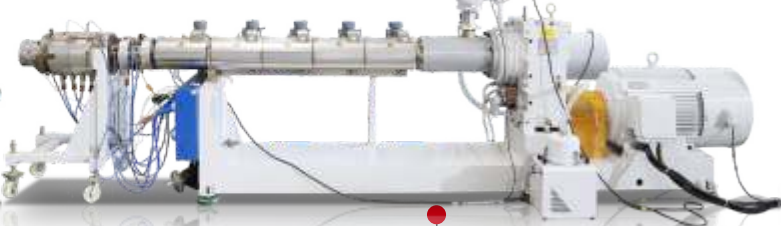
SPRAY TANK



VACUUM TANK



DIE HEAD



EXTRUDER



### AUTO COILER STRAPPING

- Full-auto changing and winding. Motor with electronic cam mode assures that arrangement is synchronous with winding. Moreover, it still keeps neat winding in the high speed of 50 m/min.
- Smooth winding, good automatic tension control and electronic cam computing method assure the liner motor's running constantly and synchronously.
- Even in the high speed of 30m/min, it can ensure the neat winding.



### MOULD

- The mold adopts cyclone air cooling structure, which can accelerate the cooling speed of the inner wall of the pipe.



### EXTRUDER

- Adopting precise imported vertical gearbox, sound off, high efficiency, with high-efficient stainless steel cooler and metal powder device.
- Optimized screw structure, making the raw material plasticizing and mixed completely.
- Equipped with gravity metering system, real-time testing the production situation.
- Special screw design for PERT materials provides better plasticizing mixed effects.





# LS-Pex

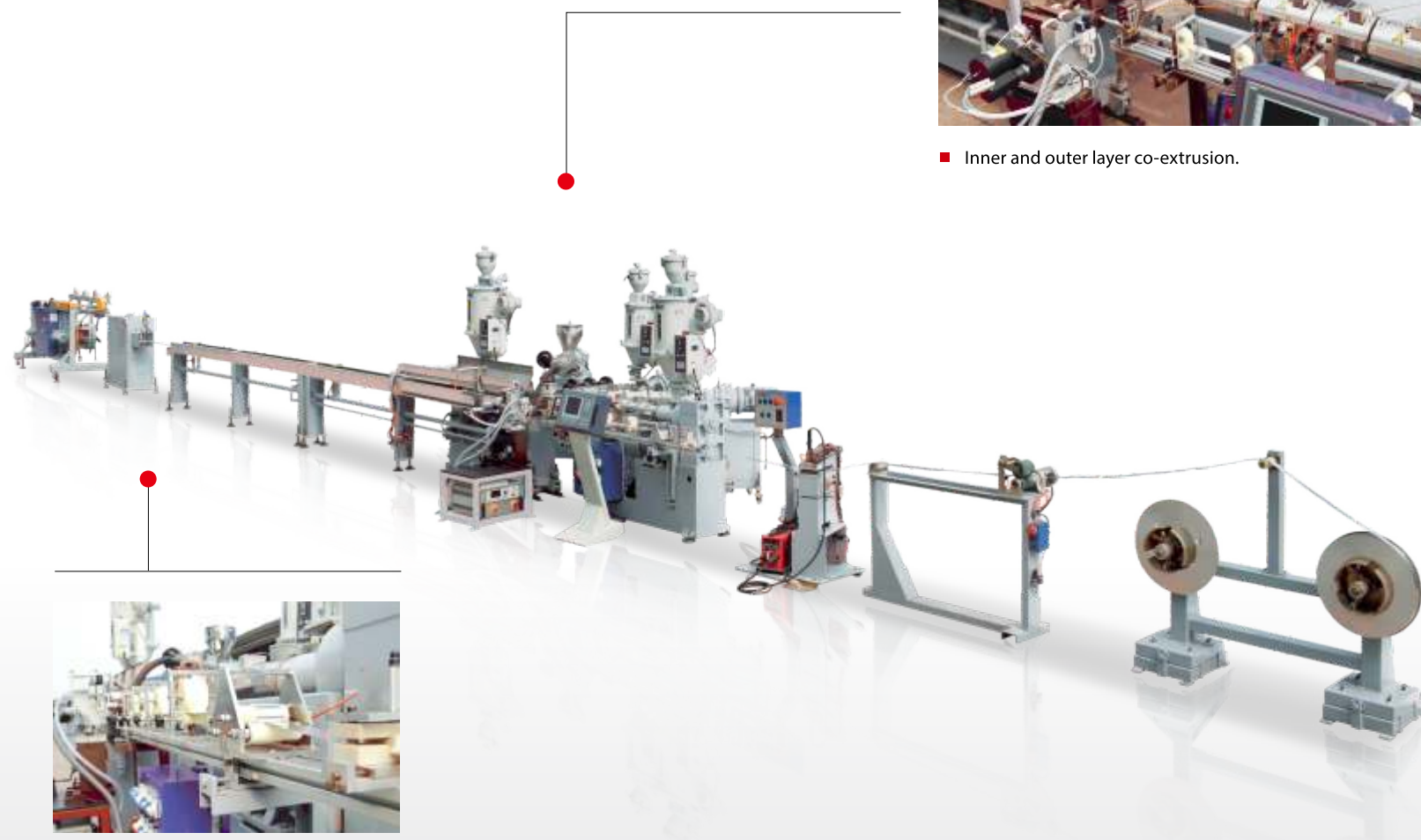
## Aluminum Plastic Composite Pipe Production Line

### 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.



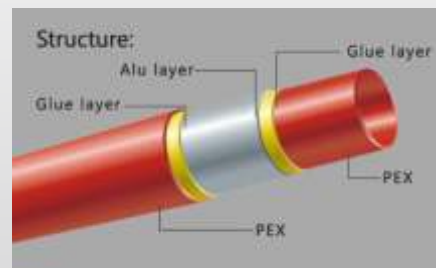
■ Inner and outer layer co-extrusion.



■ PPR-Aluminum-PPR Composite Pipe



■ Calibrating rollers of aluminum sheet



■ 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 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	20
LSBP-50PVC	Ø16-Ø50	LSE-55	180	25	70	20



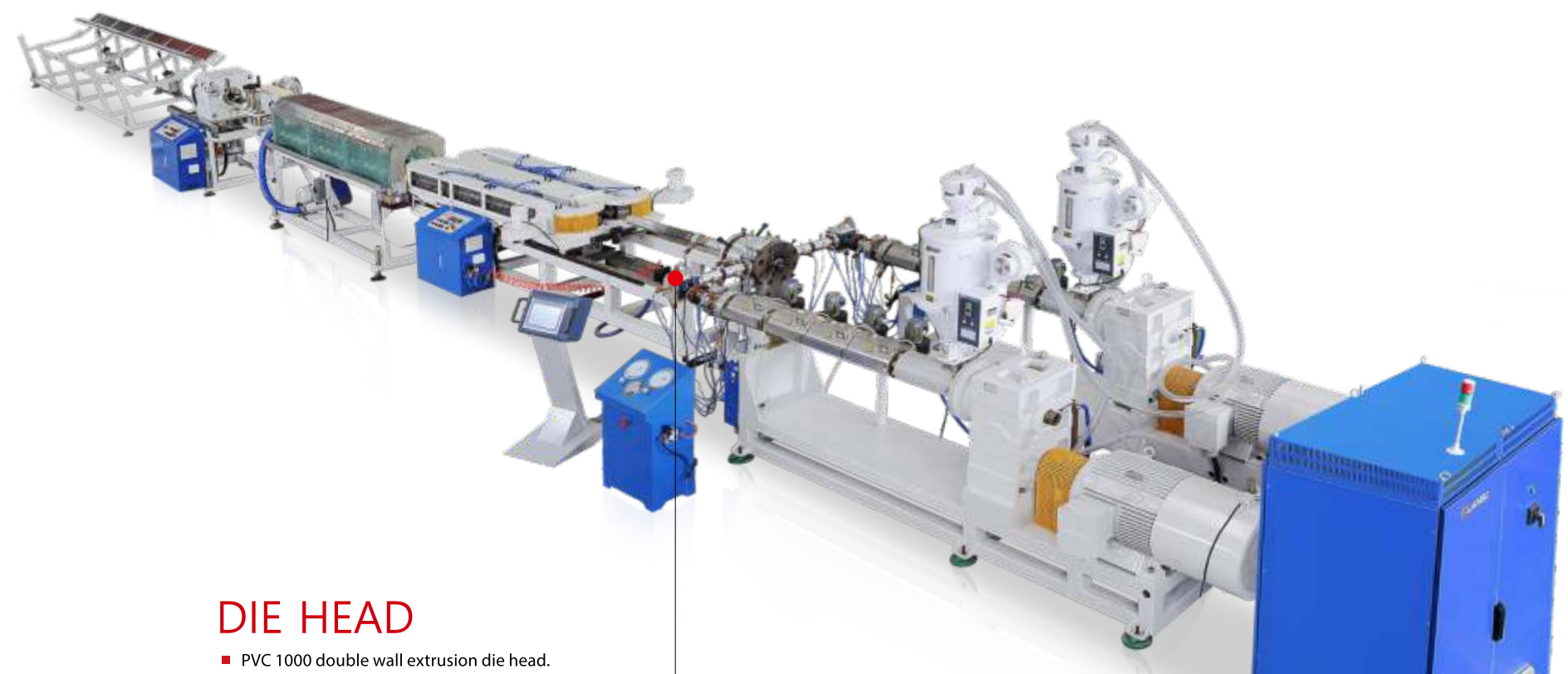


# LS-Double Wall

## Corrugated Pipe Extrusion Line

### MAIN FEATURES

- Shuttle transmission design, vacuum forming system, adopts SIEMENS control system, with more precise control.
- Pipe is vacuum forming, forming mold blocks adopt water cooling, with good cooling effect.
- Forming unit is applied of imported charging device, battery free of maintenance function, in case that if the power is off, the working platform still can set back to disconnect the module and machine head.
- Water jacket is made of aluminum alloy plating steel, with better heat-conducting capacity.
- Swarfless cutter ,can precisely control cutting position. Reduce waste rate.



### DIE HEAD

- PVC 1000 double wall extrusion die head.

### CUTTER



STACKER

CUTTER

COOLING TANK

CORRUGATOR

DIE HEAD

EXTRUDER

### 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-160PE	Ø75-Ø160	LSS-65-35 LSS-65-35	600	6	270	25
LSBP-400PE	Ø200-Ø400	LSS-65-35 LSS-80-35	770	1.2	395	28
LSBP-800PE	Ø500-Ø800	LSS-80-34 LSS-100-34	1170	0.7	650	36
LSBP-160PVC	Ø110-Ø160	LSF-65	280	5	140	30
LSBP-500PVC	Ø200-Ø500	LSF-92	750	4.5	300	30
LSBP-1000PVC	Ø630-Ø1000	LSF-95	1000	1	485	36



- PVC 1000 double wall corrugator.



- PE-400 double wall corrugated pipe corrugator



- PE-160 double wall corrugated pipe corrugator



# 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.

### SPRAYING AND COOLING DEVICE



### 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 (kg/h)	TOTAL INSTALLED POWER (kw)	LINE LENGTH (m)
LSP110-PE	LSS65-34 2set 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

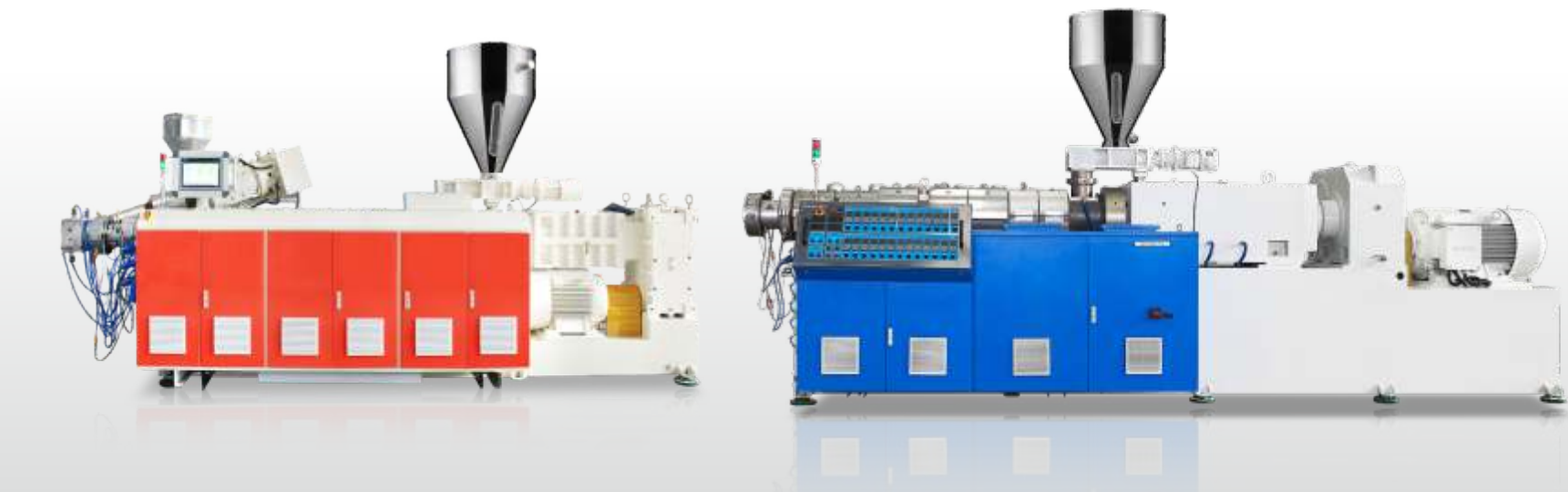
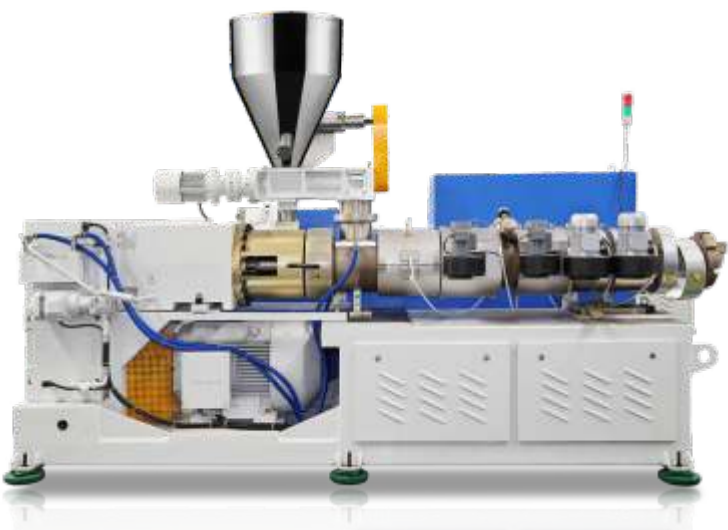
MODEL	PIPE DIAMETER RANG (m)	EXTRUDER MODEL	TOTAL INSTALLED POWER (kw)	MAX OUTPUT (kg/h)
LSWP-800	Ø200-Ø800	LSS-65X35, LSS-65X30	250	470
LSWP-1200	Ø400-Ø1200	LSS-80X34, LSS-65X30	300	540
LSWP-1800	Ø800-Ø1800	LSS-100X34, LSS-65X34	450	1000
LSWP-2400	Ø1400-Ø2400	LSS-100X34, LSS-65X34	470	1000
LSWP-3000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

# LS-Conical

Twin Screw Extruder

## MAIN FEATURES

- High output,good plasticizing effect.
- Unique screw design for plastic pipe, profile, with good melt and high capacity.



## 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	180
LSE65/132	37	75	280
LSE80/156	75	128	450
LSE80/172	75	128	600
LSE92/188	110	193	750
LSE95/191	132	215	1000

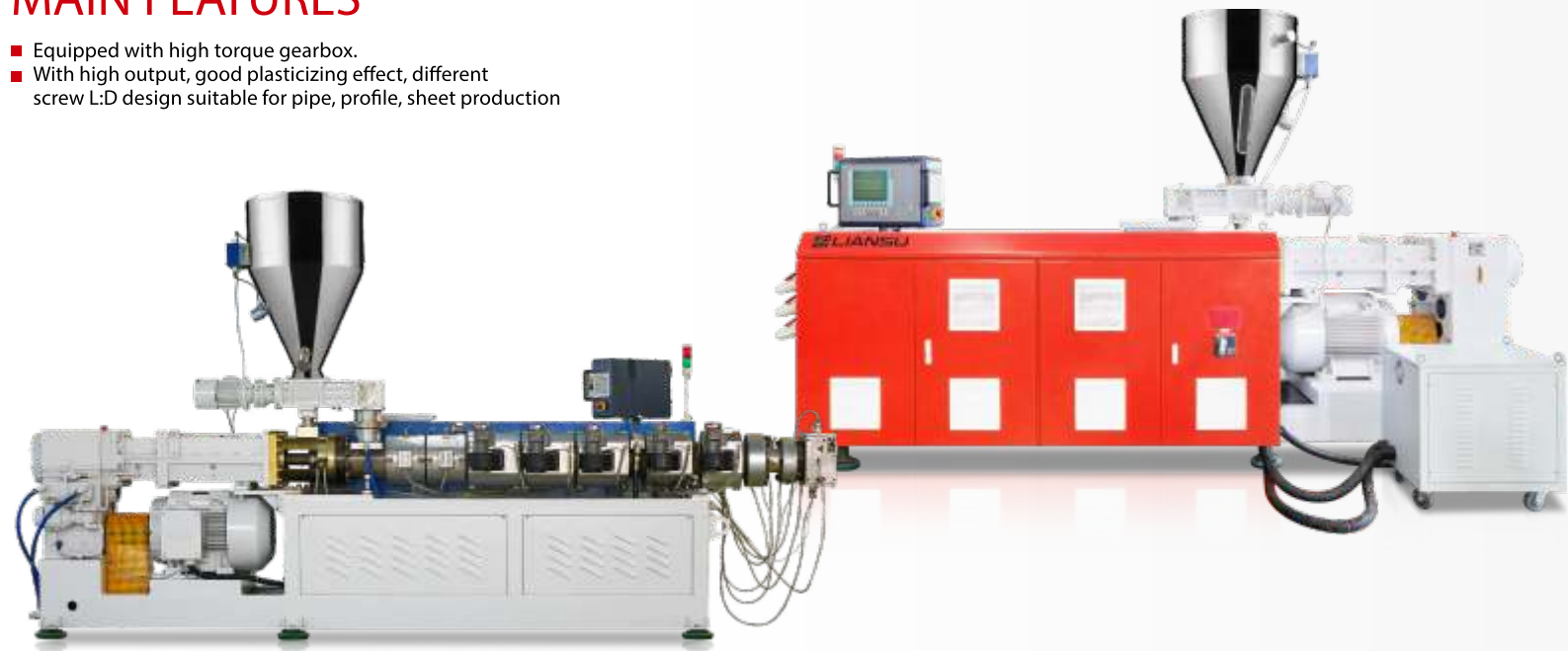


# LS-Parallel

## Twin-Screw Extruder

### MAIN FEATURES

- Equipped with high torque gearbox.
- With high output, good plasticizing effect, different screw L:D design suitable for pipe, profile, sheet production



### MAIN TECHNICAL PARAMETER

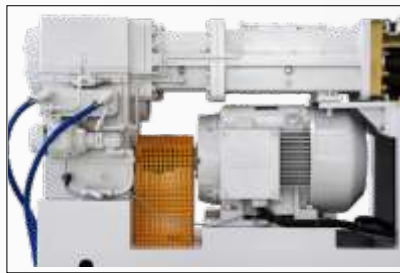
MODEL	ROTATING SPEED (r/min)	MOTOR POWER (kw)	TOTAL INSTALLED POWER (kw)	PVC OUTPUT (kg/h)	REMARK
LSPD75-26	47	37	75	300	verticaltype
LSPD90-26	45	55	105	500	verticaltype
LSPD114-26	45	90	165	800	horizontal type
LSPD130-26	45	132	215	1000	verticaltype

For Pipe



MODEL	ROTATING SPEED (r/min)	MOTOR POWER (kw)	TOTAL INSTALLED POWER (kw)	PVC OUTPUT (kg/h)
LSPD90-26	36	45	95	350
LSPD114-26	35	90	165	600
LSPD130-26	35	132	215	750

For Panel



MODEL	ROTATING SPEED (r/min)	MOTOR POWER (kw)	TOTAL INSTALLED POWER (kw)	PVC OUTPUT (kg/h)
LSPD75-26	36	37	75	240
LSPD90-26	36	55	105	350
LSPD114-26	35	90	165	500
LSPD130-26	35	132	215	700

For Profile



# LS-Single

## Screw Extruder

### MAIN FEATURES

- High rotating speed, high output.
- Discharge part of barrel is grooved feedbush structure, to increase the output by 30-40%.
- Large L/D ratio ensures the good plasticizing effect under the high rotating speed.
- Optimized screw design lowers down the energy consumption/ unit of products.



Hlex 40D Single Screw Extruder

### MAIN TECHNICAL PARAMETER

MODEL	SCREWDIAMETER (mm)	L:D	MOTOR POWER (kw)	HDPE OUTPUT (kg/h)
LSS45-25	45	25	15	25
LSS45-28	45	28	15	30
LSS65-25	65	25	30	60
LSS65-28	65	28	30	80
LSS80-25	80	25	45	100

For PVC Pipe Profile Sheet

MODEL	L:D	HDPE OUTPUT (kg/h)	MOTOR POWER (kw)
Hlex-50	40	300~340	75
Hlex-65	40	550~600	132
Hlex-80	40	820~870	200
Hlex-100	40	1,150~1200	280
Hlex-120	40	1,400~1500	355

For HDPE pipe

MODEL	ROTATING SPEED (r/min)	MOTOR POWER (kw)	TOTAL INSTALLED POWER (kw)	PE OUTPUT (kg/h)	PPR OUTPUT (kg/h)
LSS30-25	17	1.1	8	1.5	1.0
LSS40-25	17	2.2	9	45	
LSS45-30	75	15	32	30~40	20~30
LSS65-30	93	37	65	120	80
LSS65-34	142	75	105	250	200
LSS65-35	142	90	120	350	250
LSS80-34	120	110	150	420	300
LSS80-35	142	132	175	540	390
LSS100-34	120	200	255	750	
LSS120-33	93	250	320	1000	
LSS150-34	75	355	455	1200	

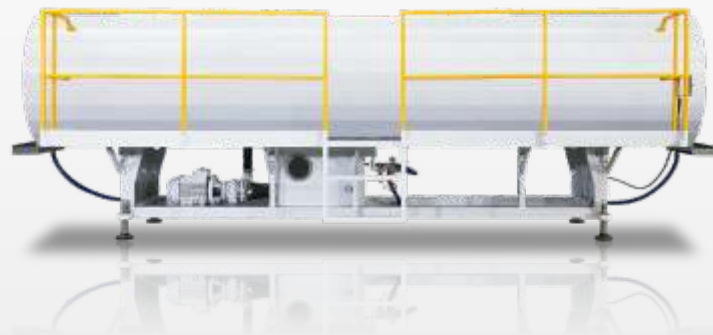
For PE Pipe PPR Pipe



# LS-Tank

## MAIN FEATURES

- Tank body adopts stainless steel material, electric control, can move forward and backward.
- High-capacity filter sieve, ensures spraying water volume and cleanliness.
- Spray nozzles adopt solid cone high-pressure spray nozzles, reasonable layout, front dense& back loose; to make speedy cooling for different size pipe.
- Water level is automatically controlled by liquid switch and pneumatic control valve; water temperature is controlled by temperature control valve; high automation degree, stable water temperature& water level.
- Vacuum degree adopts vacuum overflow valve to adjust, convenient adjusting can ensure stable vacuum degree.
- Pipeline adopts stainless steel elbow and so on pipe fitting welding, reducing the loss of water pump pressure. 7.Equipped with roundness adjusting device, can ensure the oval pipe convert back to roundness.



# LS-Haul-Off Unit

## MAIN FEATURES

- For the different pipe size and different speed requirement, Liansu developed kinds of haul-off unit accordingly, such as double caterpillar haul-off unit, three-caterpillar haul-off unit, six-caterpillar haul-off unit, eight-caterpillar haul-off unit, ten-caterpillar haul-off unit. The haul off unit equipped with single motor drive or every caterpillar with separate motor drive, there is the belt type haul-off unit, stable hauling. For the large diameter pipe, a pipe winch device is equipped to the production line to reduce the waste material.



■ two-caterpillar



■ three-caterpillar



■ three-caterpillar



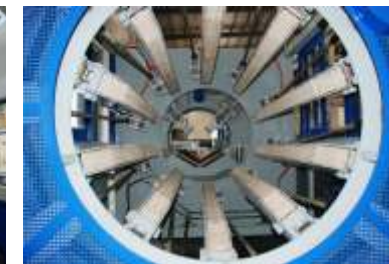
■ four-caterpillar



■ six-caterpillar



■ eight-caterpillar



■ ten-caterpillar



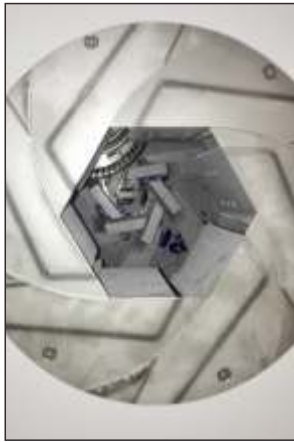
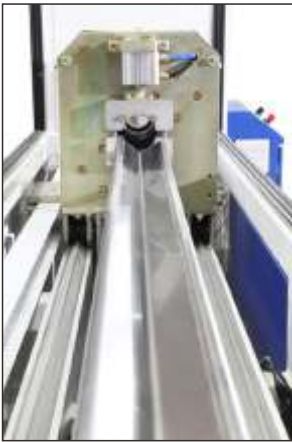
■ twelve-caterpillar



# LS-Cutting

## MAIN FEATURES

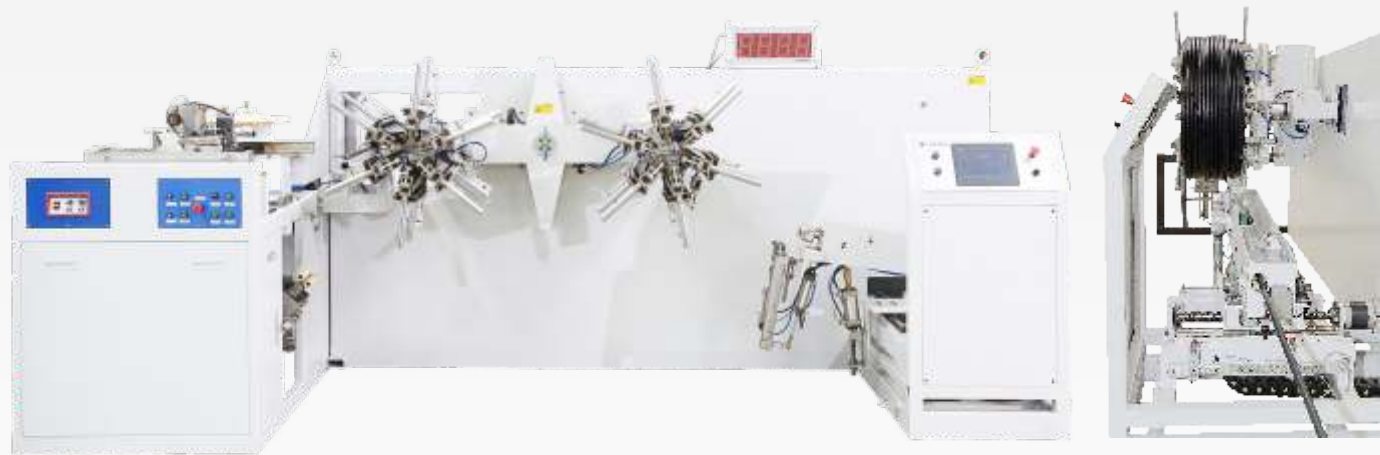
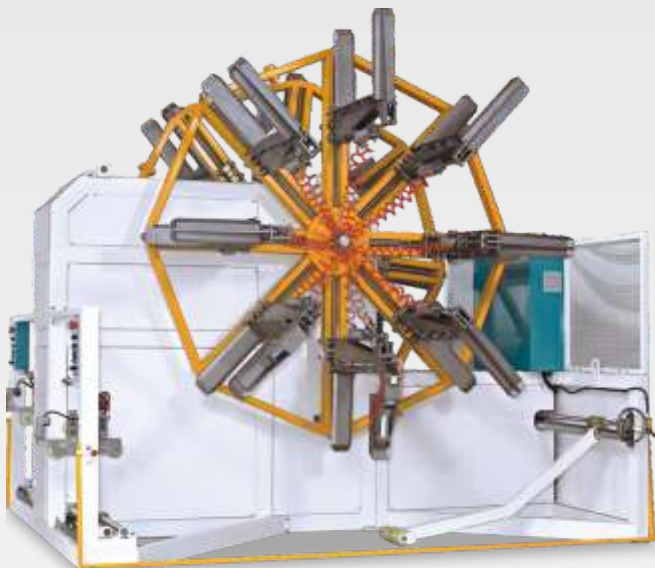
- According to different wall thickness, Liansu develops the whole series of swarfless cutting, especially the servo synchronizing units, with precise length control and extremely accurate synchronization movement and flexible speed control, ensure the durability of mechanical parts. Adopting traditional planetary cutting, which is applicable for thick pipe & thin pipe cutting.



# LS-Coiler

## MAIN FEATURES

- Liansu offers different solutions according to different required speed.
- Under 32mm it can realize high speed auto coiling with auto strapping on line.
- Reliable tensile force control can match different line speed.



■ LSPJDDJ-32PE Autornatic coiler on line strapping

## MAIN TECHNICAL PARAMETER

MODEL	PRODUCT SERIES (mm)	COILER ID (mm)	COILER THICKESS(mm)	COILER WIDTH (mm)	POWER OF MAIN MOTOR (kw)
LSPJ32BPE	Ø16-Ø32	Ø400-Ø650	230	300	1.5X2
LSBPJ-63DPE	Ø16-Ø63	Ø700-Ø1800	400	510	3
LSPE5110PE	Ø63-Ø110	Ø840-Ø2600	550	700	4X2
LSPE5160PE	Ø50-Ø160	Ø1000-Ø3200	480	600	5.5



# LS-Mixer

## MAIN FEATURES

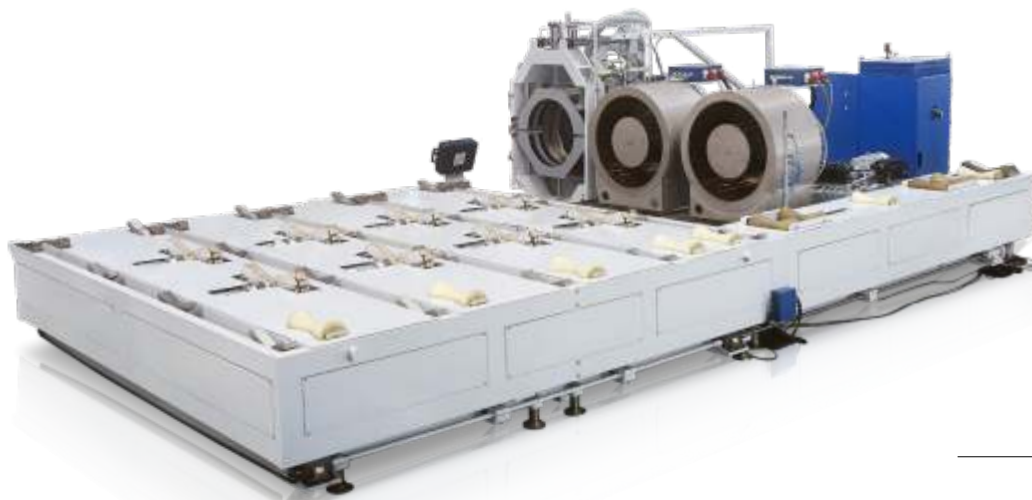
- Tank cover is double sealing, opened by pneumatic, easy operation.
- Cylinder is stainless steel material, wall thickness is up to 8mm.
- Material discharge is temperature auto controlled or time controlled.
- Anti-abrasive blade, adopts special coating technology, ensures the durability of the blade.
- Flowchart electric control operation interface has simple human-machine exchange function.
- Equipped with impulse dedusting device, ensuring speedy discharging and reducing mixing area's pollution.
- Motor start and speed regulation is governed by the inverter, to avert the excessive power that caused by high power motor start to impact on the electric network, so as to protect the electric network safety and to achieve a stable speed control.
- With direct& stable control type and analog display screen, the staff can complete the setting for the different mixing material requirements within few seconds, realizing the full automation of the manufacturing procedure, which greatly reduces labor intensity and production costs.
- "Thermocouple PLC" direct control averts the situation of too high/low temperature when discharging, so as to ensure the high product quality and improve the production's flexibility, security and reliability.



## MAIN TECHNICAL PARAMETER

MODEL	MOTOR POWER FOR HOTMIXER (kw)	MOTOR POWER COOLING MIXER (kw)	CAPACITY PER BATCH (kg)
GRH-200/LH500	45	7.5	80
GRH-300/LH500	55	7.5	125
GRH-500/LH1000	90	15	185
GRH-500/LH1500	90	22	185
GRH-1000/LH3000	160	37	370

# LS-Socketing Machine





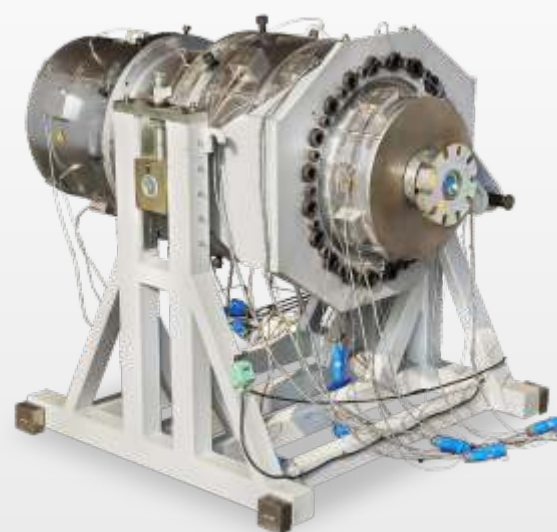


# LS-PVC

## DIE HEAD

### MAIN FEATURES

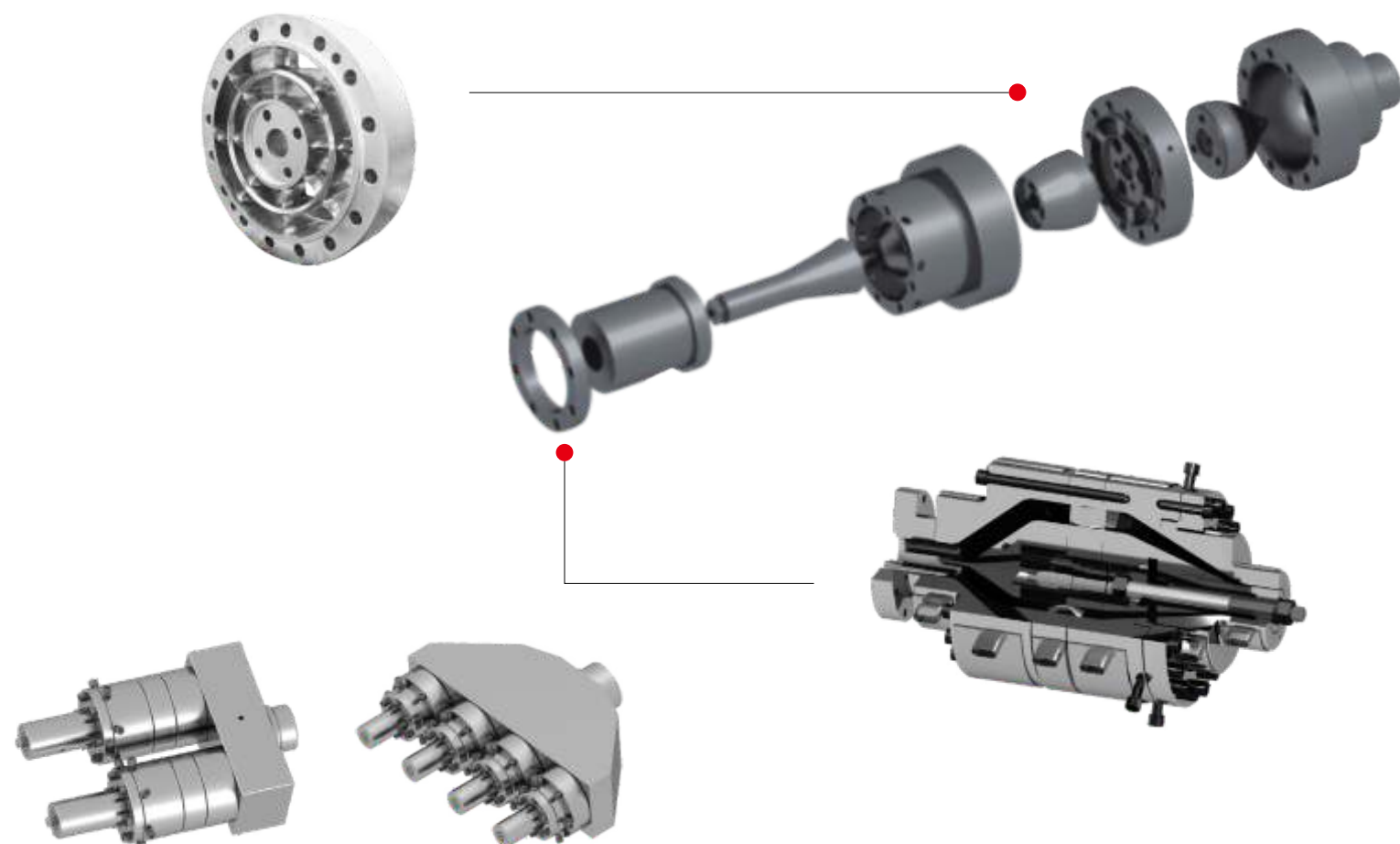
- Liansu develops PVC single layer and multilayer pipe heads, Max die head upto.  $\varnothing 1000\text{mm}$  PVC single layer pipe, .Reasonable compression ratio design guarantees good plasticizing effect.
- Easy dismounting and mounting of the die head structure, guarantees the efficiency production.



■  $\varnothing 1000\text{PVC}$  die head



■ PVC-800



- Mold-PVC dual-pipe design constitutional diagram.
- Mold-PVC four pipe design diagram.
- High quality and high stability pipe extrusion (Production Speed Max. 17meter/min ).

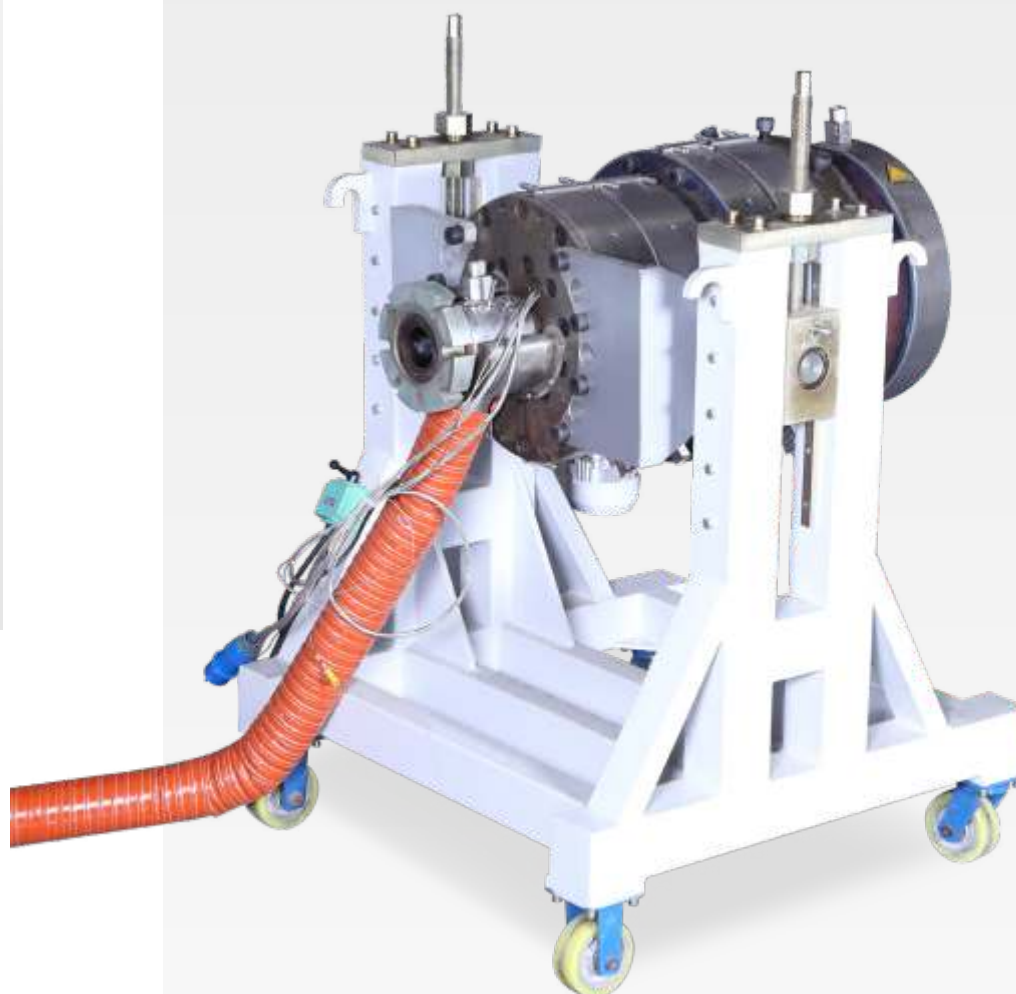


# LS-HDPE

## Single layer & Multilayer Mould

### 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.



## SINGL-LAYER POLYOLEFIN PIPE DIE HEAD STRUCTURE

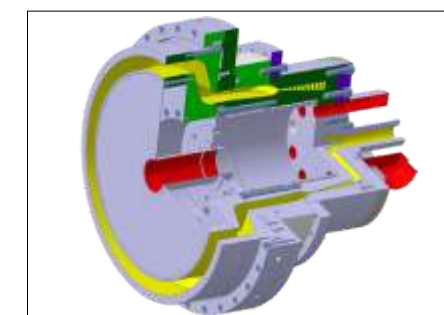


Base on the market requirement, Liansu offer the extrusion mould as below:

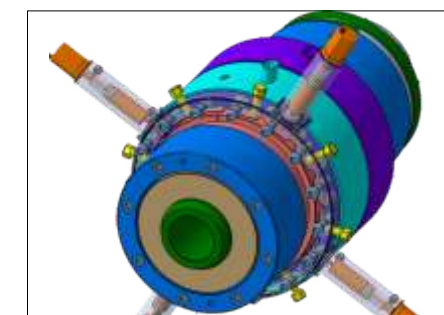
- $\varnothing 16$ -  $\varnothing 1600$  pressure sewage solid pipe mould.
- $\varnothing 63$ - $\varnothing 1200$  double wall corrugated pipe mould.
- $\varnothing 16$ - $\varnothing 250$  single-wall corrugated pipe mould.
- Communication cable duct mould.
- Different kinds of profile mould.



■ MOLD-PE-SPIRAL HEAD



■ SINGLE-LAYER MOLD



■ PE-MULTI-LAYER-HEAD



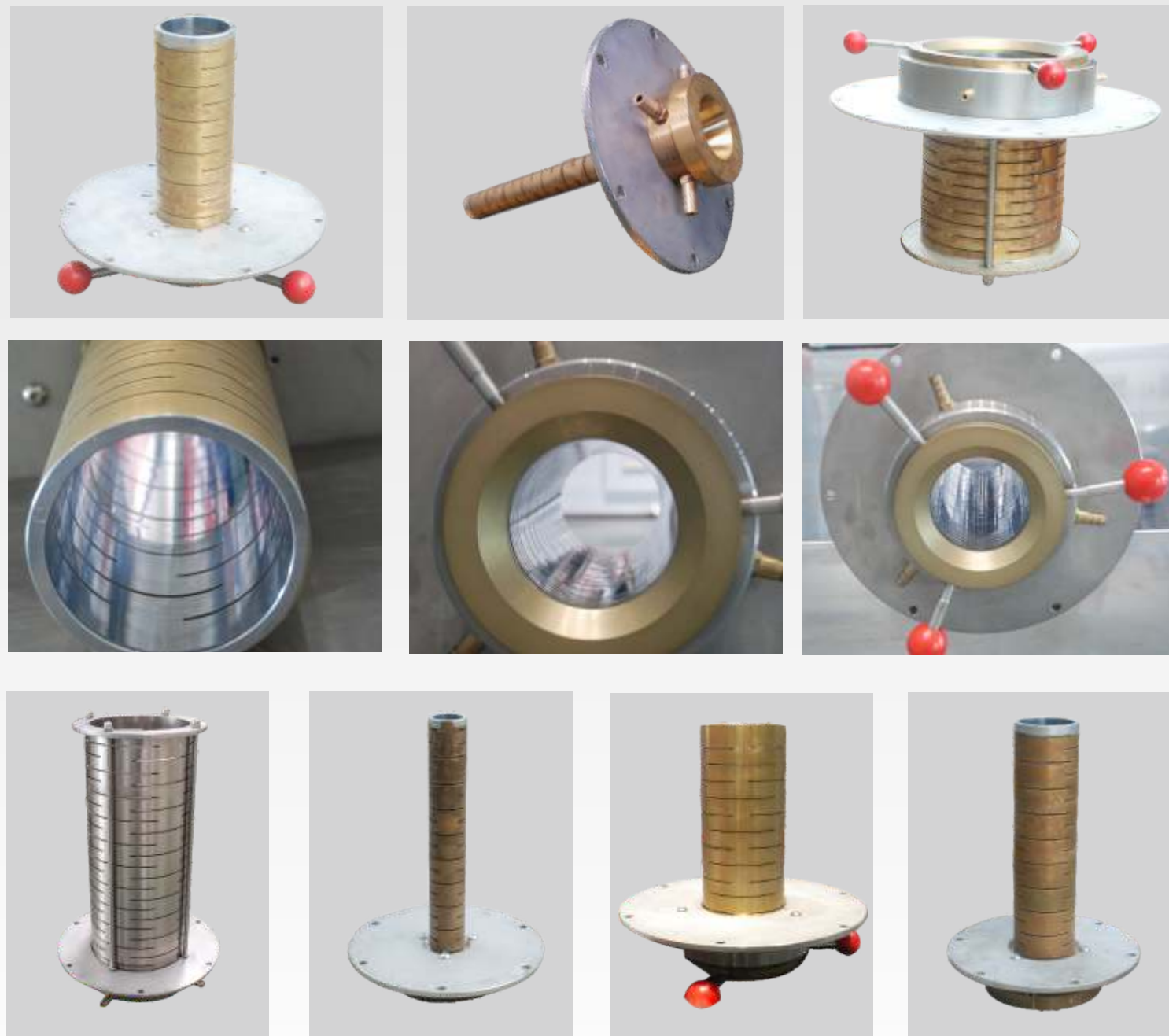
■ 250PE-MOLD



# 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.



# On-Line Bundling & Bagging Machine

## MAIN FEATURES

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







# Standard

ASTM standard ASTM D1784-D1785→ASTM D2265.

Nominal size inch	Outsidediameter ( mm)		Wall thickness(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 OD. mm	Tolerance on OD. (mm)	Class 1 2.5 bar		Class 2 4 bar		Class 3 6 bar		Class 4 10 bar		Class 5 16 bar	
		Nominal thickness (mm)	Nominal weight (mm)	Nominal thickness (mm)	Nominal weight (mm)	Nominal thickness (mm)	Nominal weight (mm)	Nominal thickness (mm)	Nominal weight (mm)	Nominal thickness (mm)	Nominal weight (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 MPa	0.8 MPa	1.0 MPa	1.25 MPa	1.6 MPa	2.0 MPa	2.5 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).

	Pipe series									
	SDR 17,6 S 8,3		SDR 21 S 10		SDR 26 S 12,5		SDR 33 S 16		SDR 41 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. 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 4 bar forPE100 and6,3 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.

	Dimensions in millimetres											
	Pipe series											
	SDR 6 S 2,5		SDR 7,4 S 3,2		SDR 9 S 4		SDR 11 S 5		SDR 13,6 S 6,3		SDR 17 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. 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	–	–	–	–	–	–	–	–	–	–	–	–





# MULTI-LAYERUCO-EXTRUSION CASTING FILM MACHINE

- 38 CPP Casting Film Production Line
- 39 CPE Casting Film Production Line
- 40 CPE Stretch Film Production Line
- 41 CPE Permeable Film Production Line
- 42 CPE/EVA Embossing Film Production Line
- 43 Lithium Battery Isolating Film Production Line
- 44 PA/EVOH Separating Film Production Line
- 45 PE High-Speed Slitter
- 46 Cold Extruding Pelletizer
- 47 Glue Spraying Machine

# CPP Casting

Film Production Line

## MAIN FEATURES

- Automatic die head and multi-layer distributor make adjustment of thickness tolerance easier.
- Features of casting roller: high in precision, low in maintenance cost.
- “Junjia”patent product “Long lasting filtration system”.
- High-performance corona system.
- Increase a swing frame of ±50MM to improve the winding quality.
- Double-station winding machine.Max winding diameter is up to1000MM.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.

## MAIN TECHNICAL PARAMETER

PRODUCT WIDTH(m)	1~5.5
Line(m/min)	250
THICKNESS RANGE(micron)	20-120





# CPE Casting

Film Production Line

## MAIN FEATURES

- High precision extrusion pressure closed loop control system, it can maintain a constant of extrusion output.
- High quality multicavity flow channel automatic die head, it can solve the lateral spread uneven situation which caused by different flow of material, the automatic thickness gauge system match on-line, its convenient to control the films even thicknes.
- Interlace spiral flow channel design of casting roll, it helps the surface temperature's error less ,to improve thin film quality.
- With Full-automatic double-station winding machine, to coil in gap or winding contact mode can be adjustable.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.
- Equipped with remote diagnosis module, its convenient to maintain the equipment.

## MAIN TECHNICAL PARAMETER

PRODUCT WIDTH(m)	1~4
LINE SPEED(m/min)	200
THICKNESS RANGE(micron)	20-120

# CPE Stretch

Film Production Line

## PRODUCTION APPLICATION

- Mainly used in Used for cargo pallet packaging, is heat shrinkable packaging film's better substitute product; Bale silage grass, can keep forage feed's moisture, improve the nutritional value, make storage stacking effective and transportation convenient, so as to reduce the loss of feed and the cost.

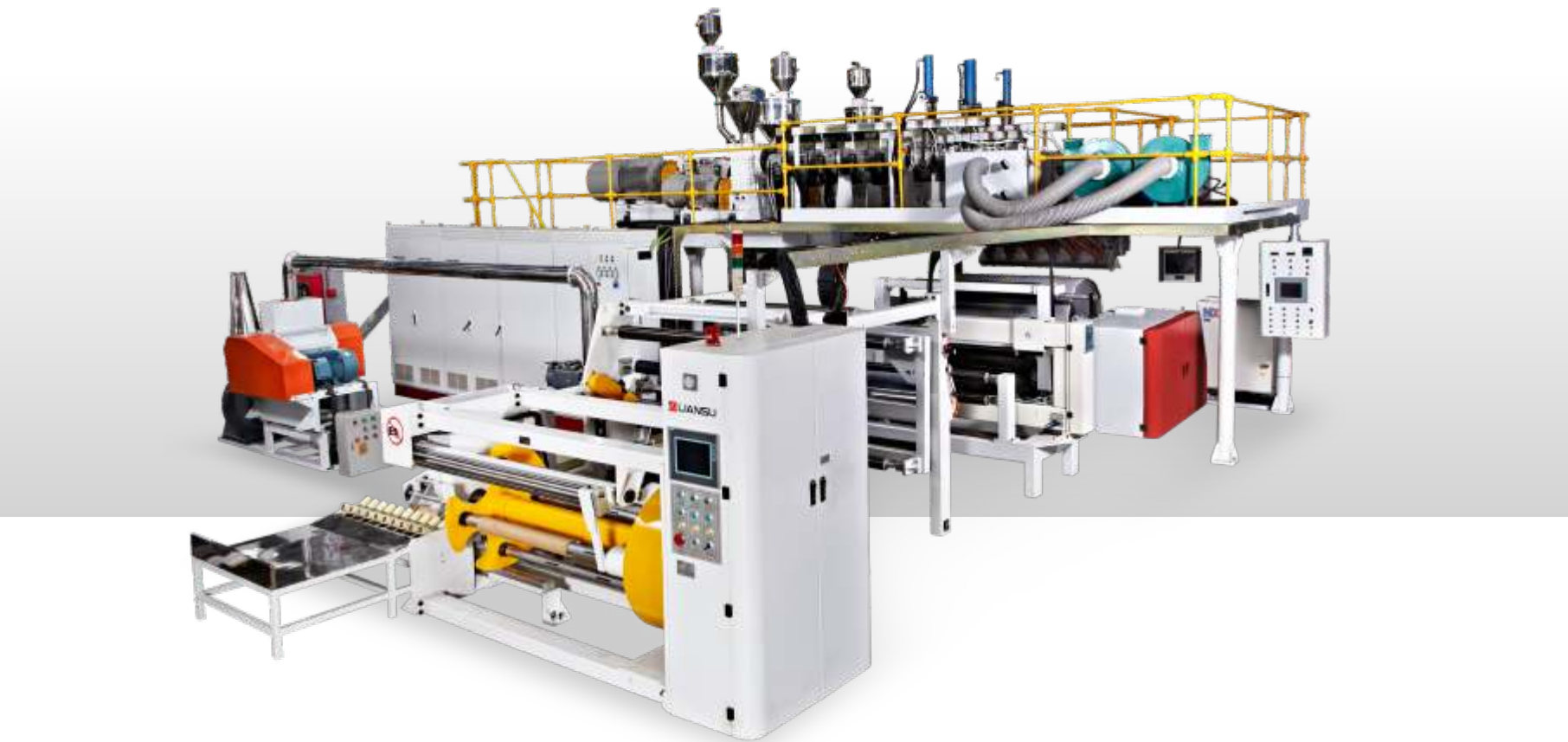


## MAIN FEATURES

- Multi-layer co-extrusion can produce product with higher tensile strength, puncture resistance and impact resistance to ensure product quality.
- High quality alloy steel automatic die, match the infrared on-line automatic thickness gauge, it helps the thin film's thickness more uniformity.
- Interlace spiral flow channel design of casting roll, it helps the surface temperature's error less ,to improve thin film quality.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.
- Full servo control system, online cutting, four station turret type winding machine, which can truly realize full-automatic production.

## MAIN TECHNICAL PARAMETER

LINE SPEED(m/min)	600
THICKNESS RANGE(micron)	0.015-0.05
DIMENSION(L*W*H m)	10x10x5



## PRODUCTION APPLICATION

- Mainly used in Food, facial tissue soft packing, cosmetic soft bag, installed electrical appliance packaging, dust cover, shopping bag, gift bag, file cover, etc.







# CPE Permeable

Film Production Line

## MAIN FEATURES

- High precise extrusion pressure closed-loop control system, keeps the extrusion capacity constant, precise melt metering control.
- High quality alloy steel automatic die, match the infrared on-line automatic thickness gauge, it helps the thin film's thickness more uniformity.
- Interlace spiral flow channel design of casting roll, it helps the surface temperature's error less ,to improve thin film quality.
- Vertical multistage stretching machine unit,each tensile roll's speed can be independent frequency control,to make the stretch more uniformity.
- Full-automatic double-station winding machine, to coil the film in gap or winding contact mode can be adjustable.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.
- It can configure online printing & slitting device, to improve production efficiency and save production cost.

## MAIN TECHNICAL PARAMETER

PRODUCT WIDTH(m)	1.5~3.5
LINE SPEED(m/min)	200
THICKNESS RANGE(micron)	20-100



## PRODUCTION APPLICATION

- Mainly used in medical surgical suit, baby diapers, women sanitary towel and disposable bed sheets, etc.; also a big trend in house construction field.



# CPE/EVA Embossing

Film Production Line

## MAIN FEATURES

- High precise extrusion pressure closed-loop control system, keeps the extrusion capacity constant.
- High quality alloy steel automatic die head, can match on-line automatic thickness gauge,make thin film's thickness more uniformity.
- Interlace helical flow channel design of casting roll make the surface temperature's error less.
- Independent oscillating system, variable frequency speed regulate, adjustable range.
- Full-automatic double-station winding machine, to coil the film in gap or winding contact mode can be adjustable.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.

## PRODUCTION APPLICATION

- Mainly used in medical surgical suit, baby diapers, women sanitary towel and disposable bed sheets, etc.;Umbrellas, raincoats, suit jackets, all kinds of table cloth, shower cap, shower curtain, apron.



## MAIN TECHNICAL PARAMETER

PRODUCT WIDTH(m)	1.5~3.5
LINE SPEED(m/min)	200
THICKNESS RANGE(micron)	20-120



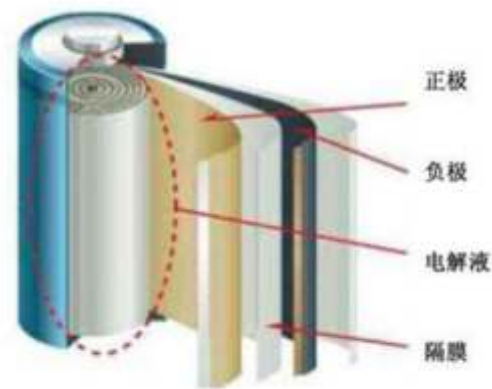


# Lithium Battery

## Isolating Film Production Line

### MAIN FEATURES

- First line developed and succeed running in China in 2005.
- Advanced screw channel design, resulting in good plastification effect.
- Match with high-precision melt pump, ensuring the pressure stable of die chamber.
- Long lasting filter system for remarkable production cost saving.
- Alloy steel automatic die imported from Europe, match with the online automatic thickness gauge.
- Casting roller is closed-loop thermostatical control, ensuring the film forming stable.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.



### MAIN TECHNICAL PARAMETER

PRODUCT WIDTH(m)	1.5
LINE SPEED(m/min)	100
THICKNESS RANGE(micron)	15-80
DIMENSION(L*W*H m)	15x3x4.5



# PA/EVOH Separating

## Film Production Line

### MAIN FEATURES

- 5-9 layers co-extrusion, can choose various interlayer structure.
- Double-layer platform design of extrusion system, high-accuracy closed-loop control system of extrusion pressure.
- Available to install the weightlessness feeding system, and closed-loop control with extruder, to guarantee the extrusion capacity.
- High quality alloy steel automatic die head, make thin film's thickness more uniformity.
- Interlace helical flow channel design of casting roll ensure the less error of surface temperature.
- Infrared online automatic thickness gauge, can detect every layer's thickness.
- Full-automatic double-station winding machine, to coil the film in gap or winding contact mode can be adjustable.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.



### MAIN TECHNICAL PARAMETER

PRODUCT WIDTH(m)	2.5	3
LINE SPEED(m/min)	200	200
THICKNESS RANGE(micron)	20-120	20-120





# PE High-speed slitte

## MAIN FEATURES

- High-speed slitting, active unwinding.
- Automatic rectify control system.
- Winding tension is closed-loop control, conical degree is automatic calculated, guaranteeing the constant of tension.
- Applicable for plastic film ,including PE,PP,PET, PVC.etc., paper, composite/aluminum plated film, color printing film slitting. Perfect equipments for film and slice secondary processing and best choice for color-printing & package industry.



# Cold Extruding Pelletizer

## MAIN FEATURES

- When the scraps cut off from edge cutting unit, directly brought into this machine,using screw friction producing heat,to make material become half molten state and then quickly cooling and dicing.
- This machine's advantage is no need heating, no dust, minimal noise. Therefore it won't destroy plastic's molecular structure,no need secondary plasticizing,less power consumption.The process granules proportion is similar to original grain, can evenly mix with raw material,not easy jam in feed bush and produce crystallite,additive amount can reach 30% - 40%.
- This product is widely adapted to PE,PEVA,stretch film,which can match on-line synchronous recycling of casting production line and film blowing machine unit.

## PRODUCTION APPLICATION

- Mainly application in film recycle unit for casting film production line and blow film machine.

## MAIN TECHNICAL PARAMETER

MOTOR POWER(kg)	30
OUTPUT(m/min)	200m/min 100-150kg/h
DIMENSION(L*W*H m)	2x1x1.5
WEIGHT(kg)	800



# Cast Film

For Lab Application

## MAIN FEATURES

- Specially designed for lab use, time-saving, less in material consumption, high in utility value.
- Minimum in material consumption, maximum in practical value.



# Cranulator

## MAIN FEATURES

- Scraps feed into this machine,using direct spiral pressing and dicing, on line recyle and feeding.
- This machine's advantage is no need heating, no dust, minimal noise.Therefore it won't destroy plastic's molecular structure, no need secondary plasticizing,less power consumption.The process aggregate proportion is similar to original grain, can evenly mix with raw material,not easy jam the material inlet and produce crystallite,additive amount can reach 30% - 40%.
- This product is widely adapted to the offcut recycling ,such as PE, PO, PP, CPP, CPE, PA, PVC, EVA, PEVA, TPU, stretch film,preservative film, protective film, Non-woven fabric and so on,can match on-line synchronous recycling of casting production line and film blowing machine unit. Compared to crusher and renewable granules,can greatly reduce production cost and improve finished product's quality.

## PRODUCTION APPLICATION

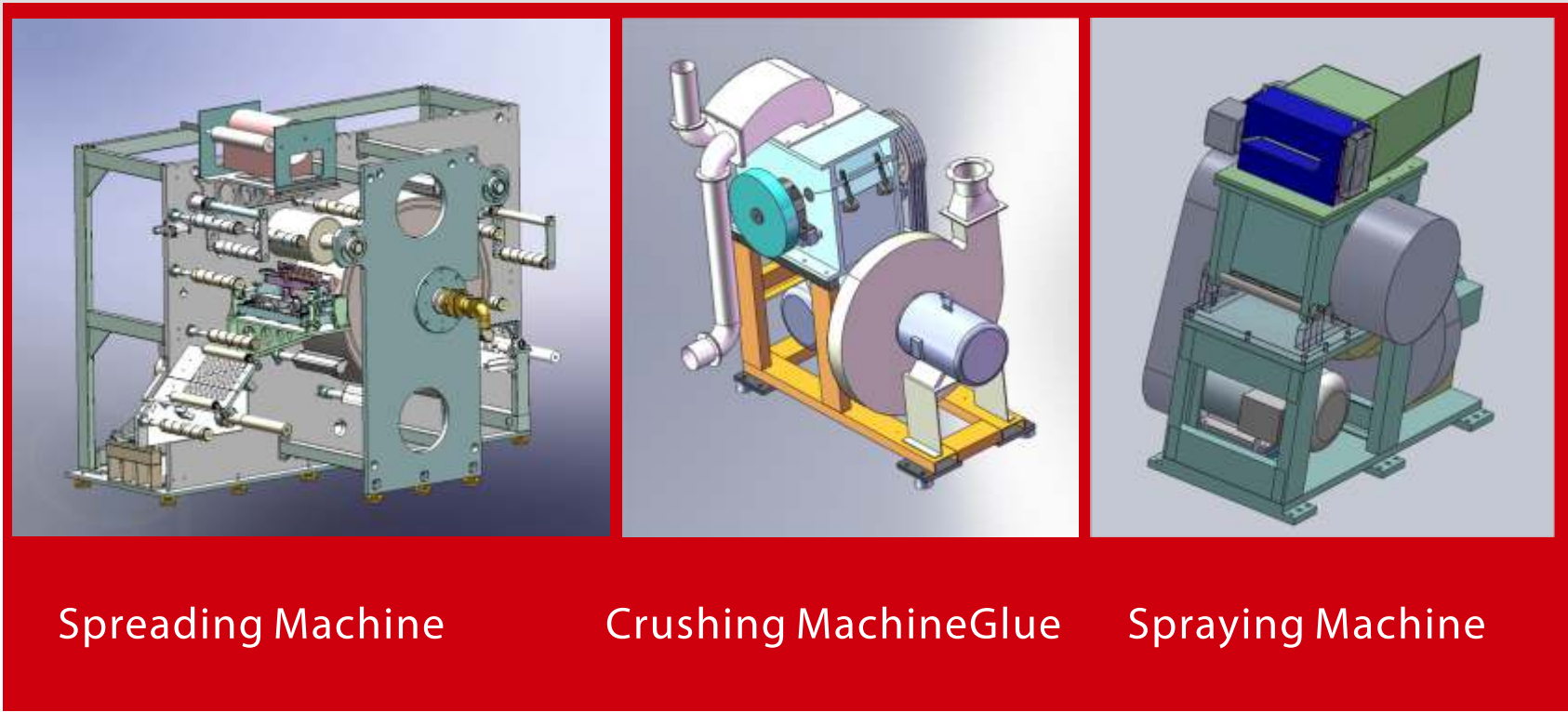
- Mainly application in film recycle unit for casting film production line and blow film machine.

## MAIN TECHNICAL PARAMETER

MOTOR POWER(kg)	5.5
OUTPUT(m/min)	150m/min 100-150kg/h
DIMENSION(L*W*H m)	1.1x0.6x1.7
WEIGHT(kg)	400







Spreading Machine

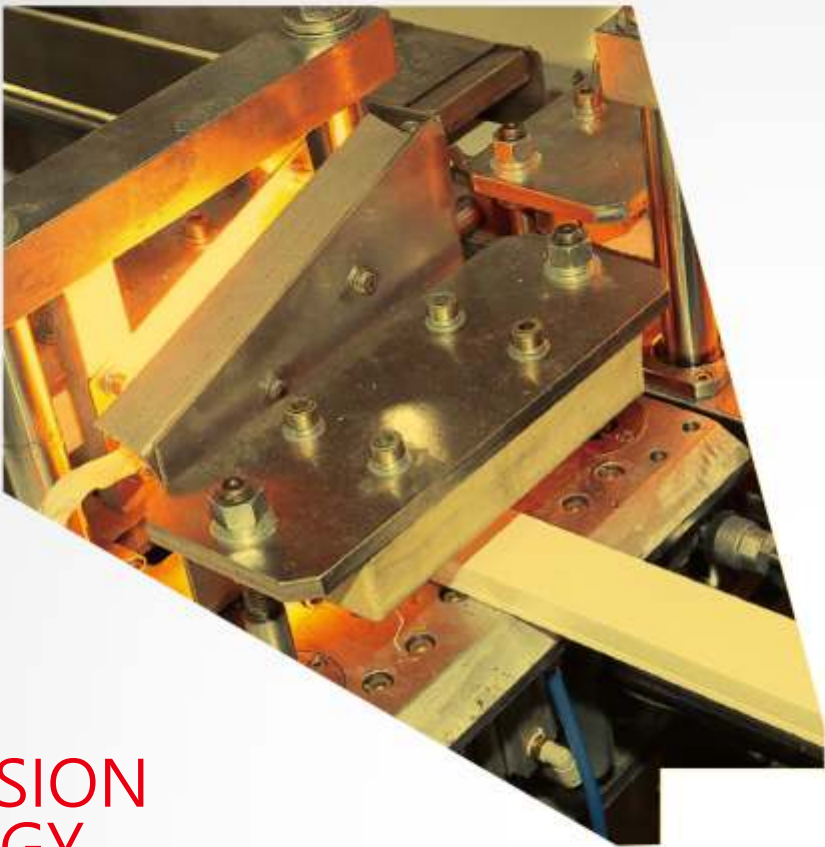
Crushing Machine

Glue Spraying Machine



# Model

Category	Model	Model	Material	Thickness range (mm)	Width of equipment (m)	Application
Package film production equipments	CPP	JJ-CFM CPP film production line	PP	0.02-0.08	1-5.5	Applicable for food package, medicine package, hot filling, retort pouch, aseptic packaging, aluminum substrate film
		JJ-CFM CPP multi-layer co-extrusion isolating film production line	PP / PA / EVOH / adhesive	0.02-0.08	1-3	
		JJ-CFM CPE film production line	PE	0.02-0.08	1-4	
	CPE	JJ-CFM CPE multi-layer co-extrusion isolating film production line	PP / PA / EVOH / adhesive	0.02-0.08	1-3	
		Stretch film	PE / PVC	0.017-0.050	1	
Eisai film production equipment	CPE	JJ-CFM CPE permeable film production line	PE	0.02-0.06	1-3.5	Applicable for infant napkin film, women sanitary towel basement membrane For new material and new product research and development test
		JJ-CFM CPE embossing film production line	PE	0.02-0.06	1-3.5	
		JJ-CFM CPE matte film production line	PE	0.02-0.06	1-3.5	
Functional film production equipment		JJ-CFM testing machine	Applicable for casting extrusion material	0.15-0.10	0.2	Applicable for Li-Ion battery separating applicable for solar battery package film
		JJ-CFM solar battery package film production line	EVA/DVDF	0.02-0.08	0.9-1.6	
		JJ-CFM Li-Ion battery separator production line	PP/PE	0.02-0.08	1-1.5	
Coating equipment		Single / multi-layer lamination machine	PP/PE/EVA	0.02-0.08	1-3.5	Applicable for paper, film and other material laminating
		Water glue composite machine	PE embossing film	0.02-0.08	0.6	Applicable for film, non-woven fabrics and other material laminating
		Glue spraying machine	PE embossing film	0.02-0.08	0.3	Applicable for film, non-woven fabrics and other material laminating
		Scraping machine	PE embossing film	0.02-0.08	0.6	Applicable for film, non-woven fabrics and other material laminating



## THE EXTRUSION TECHNOLOGY FOR PROFILE & PANEL



- 51 LS-PVC Window Profile Production Line
- 53 LS-Trunking Production Line
- 54 LS-Corrugated Tile Production Line
- 55 LS-PVC Door Panel Production Line
- 57 LS-Aluminum Plastic Composite Panel production Line
- 59 LS-Plastic Sheet Production Line
- 60 LS-PP Panel Production Line
- 61 LS-Grid Plate Production Line
- 62 LS-Pelletizing Production Line



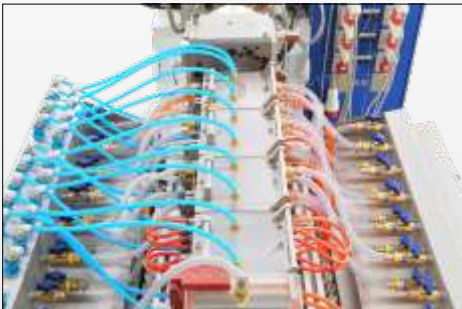
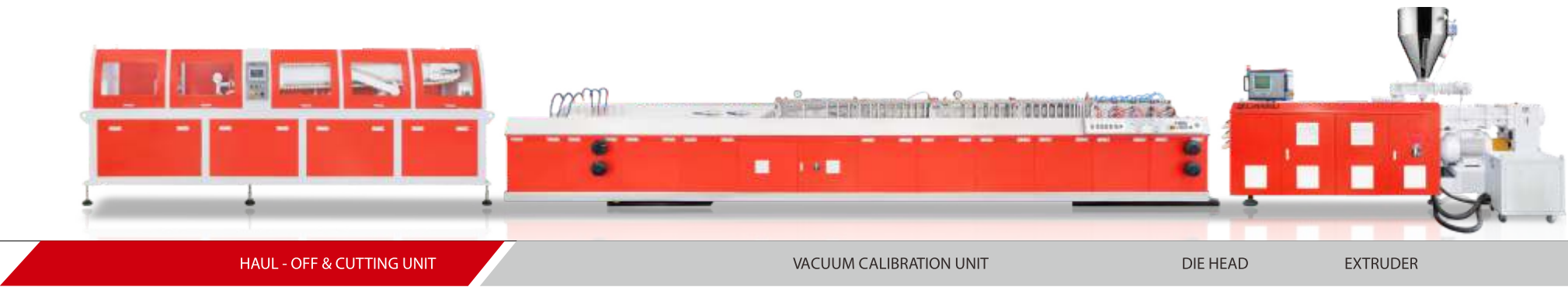


# LS-PVC Window

## 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.

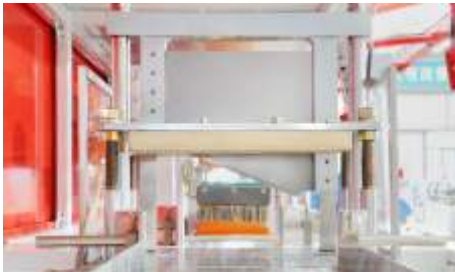


### CALIBRATING TABLE

- 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

### EXTRUDER

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





# LS-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.



CORRUGATED  
TUBE SAMPLE



STACKER

CUTTER

CALIBRATING TABLE

DIE HEAD

EXTRUDER

CUTTER



DIE HEAD



- Able to supply single or dual cavities PVC trunking mould
- trunking-mold-inner chamber.



# 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.

## EXTRUDER



## HAUL - OFF UNIT



## 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





# 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.



### PRODUCTION STATUS



STACKER

CUTTER

HAUL - OFF UNIT

CALIBRATING TABLE

EXTRUDER

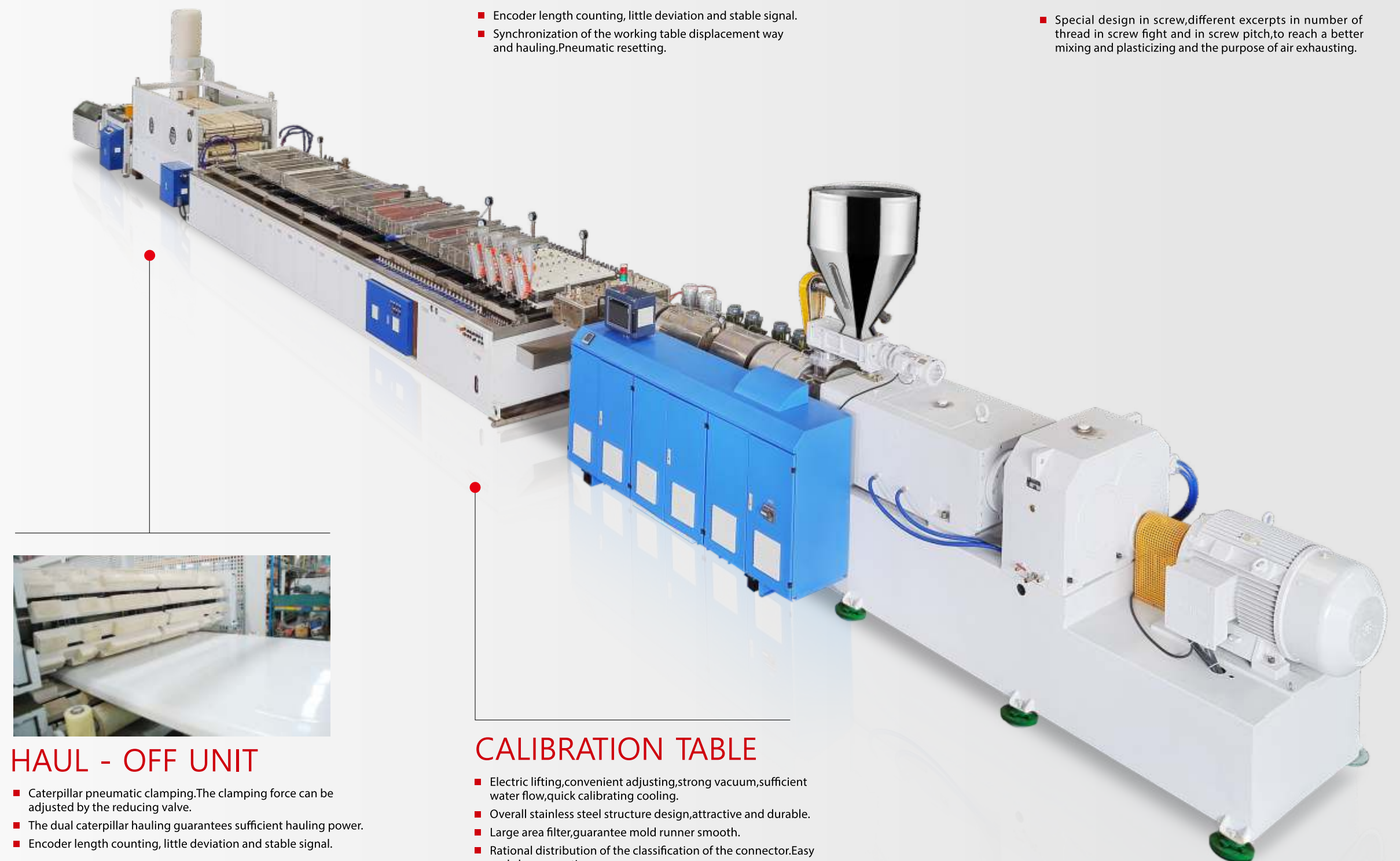
DIE HEAD

### 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.

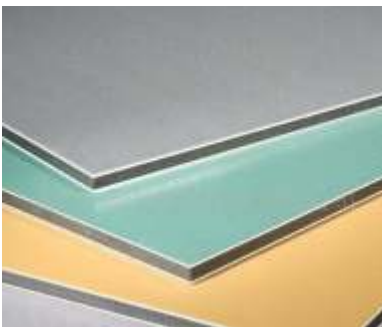
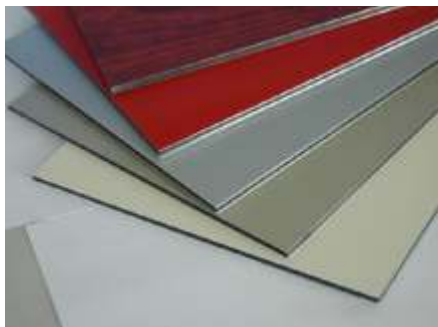


# LS-Aluminum Plastic

## 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.



SAMPLE



PRODUCTION STATUS



■ Aluminum-plastic panel-polymer composite-composite.



DIE HEAD  
■ PE-APCP Extruding production line:T mold.



WORKTABLE

### 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

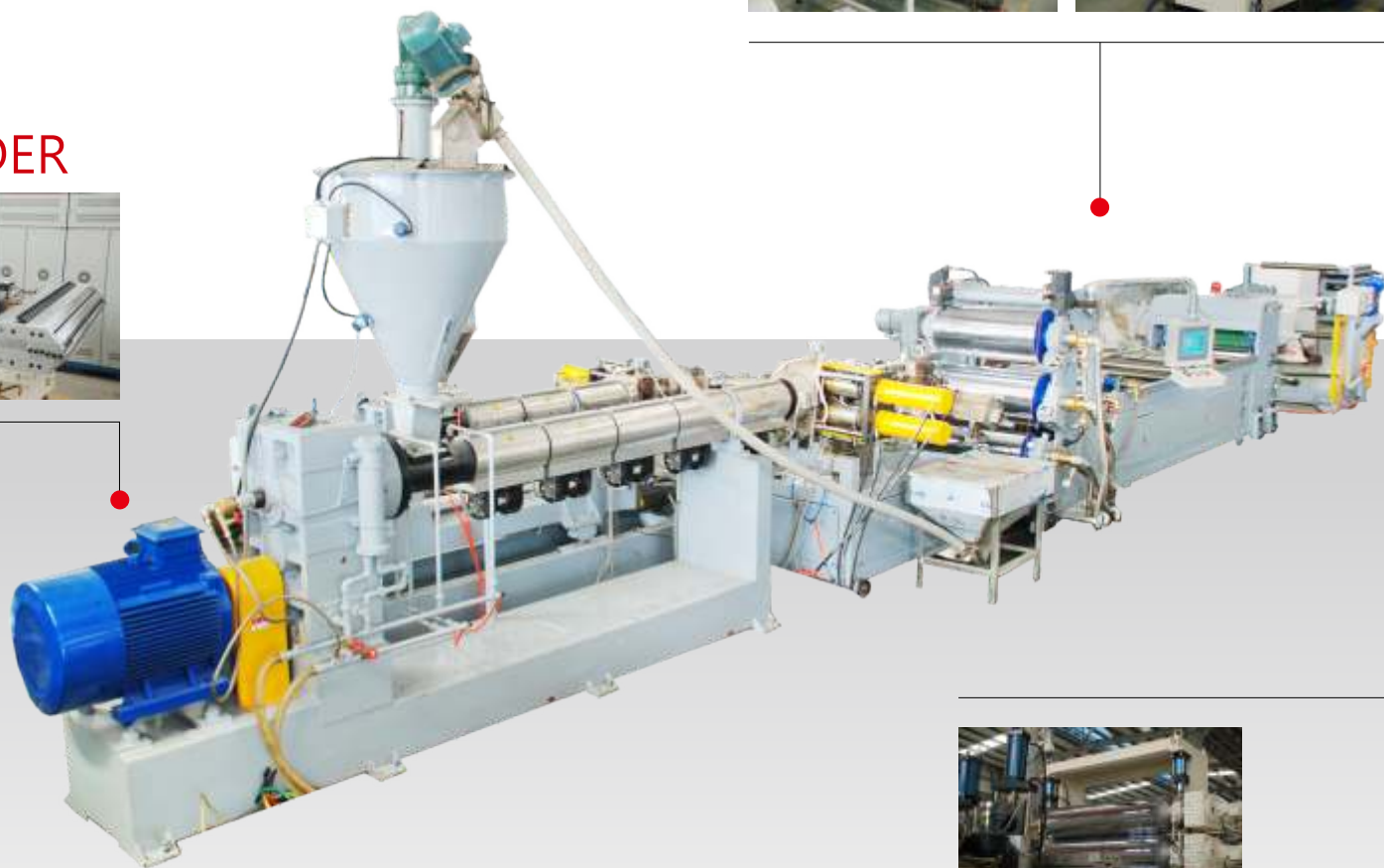
## MAIN FEATURES

- 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



## EXTRUDER



■ 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

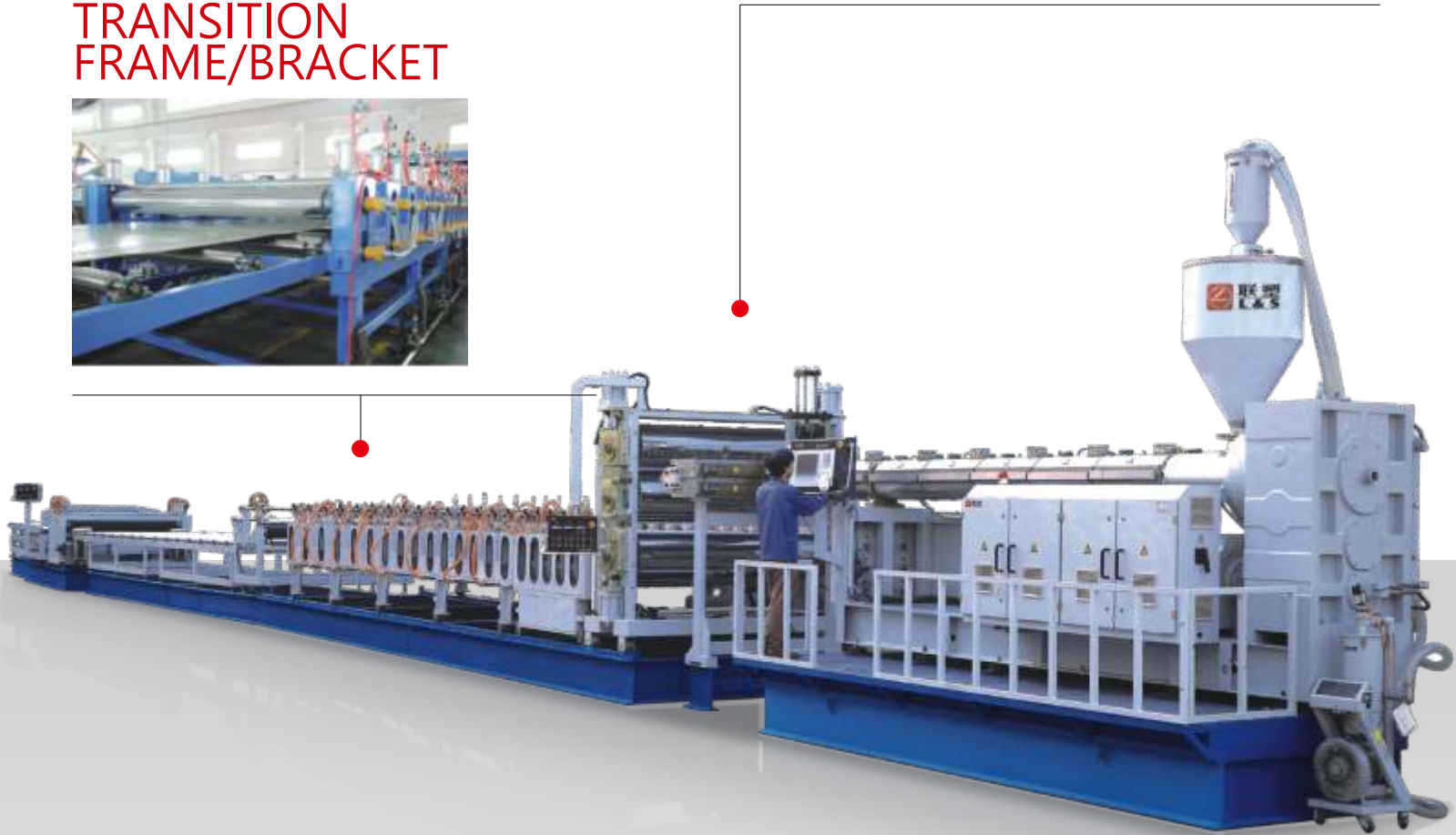
- Special screw design ensures the good plasticizing effect and good panel quality.
- Calender roller adopts multi-spiral water channel design, uniform temperature roll surface and high product surface quality.
- Tri-roll calender adopts independent motor drive, frequency variable speed regulation.Moreover, 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.



## HAUL - OFF UNIT



## TRANSITION FRAME/BRACKET



## 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



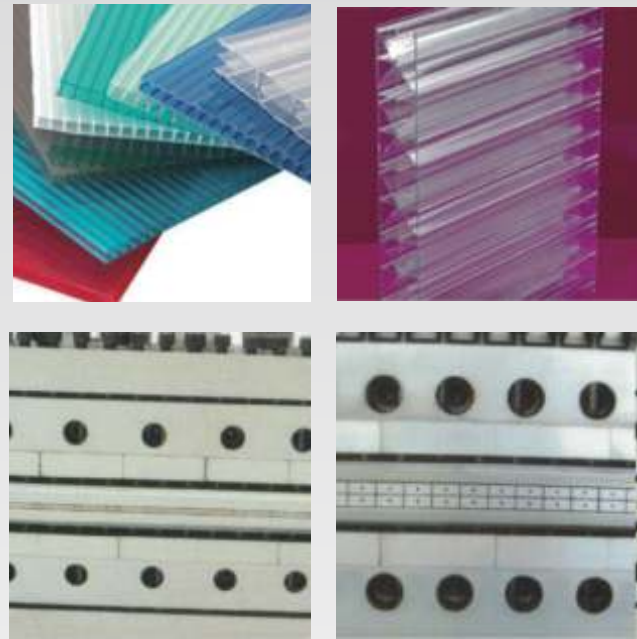
# LS-Grid Plate

Production Line

## MAIN FEATURES

- Special screw structure ensures the good plasticizing effect of the material and the high transparent grade of the panel.
- Speedy cooling forming die supports the production line with faster linear speed and higher efficiency.
- Heat treatment device can eliminate the inter stress of the PC/PMMA product to avert of product warp or crack.
- The PP/PC hollow panel product of this equipment is widely used in recycling bin, acoustic panel, greenhouse, courtyard scaffold, etc.

## CORRUGATED TUBE SAMPLE



## MAIN TECHNICAL PARAMETER

MODEL	PRODUCT SPECIFICATION (mm)	THICKNESS (mm)	EXTRUDER MODEL	MAX OUTPUT (kg/h)	MAX HAULING SPEED (m/min)	LINE LENGTH (m)	INSTALLED CAPACITY (kw)
LSYG-2100-PC/PP	2100	4-12	LSS-120-35/LSS-45-30	400	2.5	27	600

# LS-Pelletizing

Production Line



DIE HEAD



MAIN TECHNICAL PARAMETER



## MAIN FEATURES

- Special pelletizing screw with high output and good mixing effect.
- 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.



CUTTER

HAUL - OFF UNIT

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

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