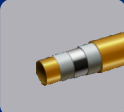


作为全球管材挤出和线缆挤出技术的领导者
我们的使命是通过先进的技术、技能和服务
提升客户的核心竞争力

塑料管材制造方案

- 

暖通/卫浴管生产线
- 

PAP铝塑复合管生产线
- 

PEX-a/b/c 交联管生产线
- 

PSP钢塑复合管生产线
- 

PE/PP市政排水、供水、电力
和供气管材生产线
- 

高端家装管材生产线
- 

PP-R管材生产线
- 

PE-RT/EVOH管材生产线
- 

PVC管材生产线
- 

电力电缆设备
- 高压电缆平滑铝和波纹铝护套生产线
海底电缆护套生产线
柔性防火电缆生产线



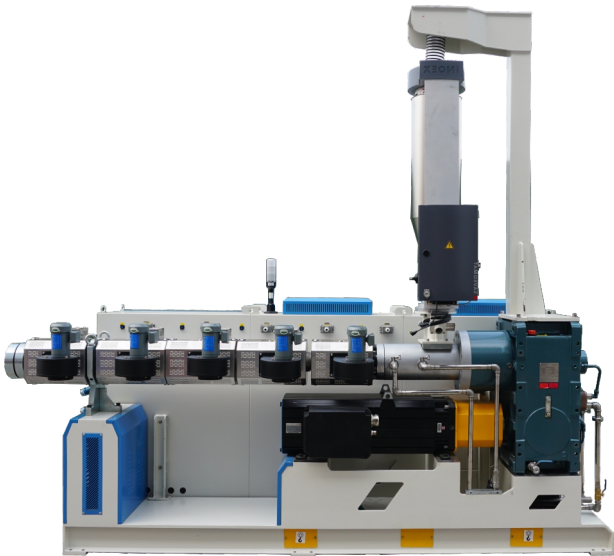
浙江双林环境股份有限公司
浙江双林机电科技有限公司

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【专业管道/电缆挤出生产线】

高效节能塑料管道挤出生产线
High Speed Plastic Pipe Extrusion Line



- 

更高产量
- 

更加智能
- 

更加稳定
- 

更低能耗
- 

更快服务
- 

更加安全



Mission

公司使命

做全球值得拥有的管道塑机!

Make the Worthy Owning Plastic Pipe Machine.

Value

核心价值

创新为先，品质为重，以人为本，诚信为根!

Honesty Consists of Specialized Innovation and Quality.

Corporate culture

企业文化

让留在公司的每一名员工成为最好的自己!

To be a Better Person each Shuanglin employee!



公司简介

COMPANY INTRODUCTION

浙江双林机电科技有限公司是专业从事大直径塑料管道生产线、复合管道生产线等各种塑料机械成套装备研发、制造的国家级高新技术企业。标准厂房面积25万多平方米，年管道设备生产能力在1000套左右，独具优势的产品有铝塑复合管生产线、16-2600mm PE实壁管生产线、300-4000mm缠绕增强管生产线、暖通和卫浴管材PE-Xa, PE-Xb、PE-Xc、PP-R、PE-RT生产线、PVC管生产线、电力电缆生产线。

现有职工400多人，其中，中、高级工程师及专业技术人员60多名，2008年成立杭州市企业技术中心。公司自成立以来不断地进行技术创新和产业升级，加入了余杭区“双百工程”、开展了与浙江大学机械研究所的长期合作。截止到2012年3月，获得国家专利80余项，并承担了多项国家火炬计划项目。2008年12月，公司评定为国家高新技术企业，近几年获得多项国家创新基金;双林公司现在为国家重点支持领域的高新技术企业、中国驰名商标; 2010年12月，双林产品被评为“杭州名牌产品”; 公司现已通过ISO9000质量体系、GB/T28001:2001职业健康安全体系、ISO14001:2004环境管理体系、欧盟CE等各项认证。

2009年公司在浙江省湖州市禹越工业区成立双林工业园，总投资2亿元，专注于塑料机械成套装备的研发、制造、培训。经过多年的潜心研究，公司在排水给水成套装备取得重大突破，其中大直径聚乙烯缠绕增强管生产线填补了国内空白，并已获得国家发明专利。

Shuanglin company business covers plastic pipe and composite pipe machinery, plastic pipe and material trading. New material technology innovation.

The main business of Shuanglin company specialized on plastic and composite pipe machinery. Since year 1978, Shuanalin has been seeking new solutions for the plastic extrusion, extrusion moulding and multi-layers pipe forming & welding. All the innovations are based on safer application, faster installation, easier production and less energy consumption. Thanks to the 400 employees, who makes Shuanglin pipe machinery reached 7500 sets all over the world. University and Chemical institute cooperation helps Shuanglin pipe extrusion solutionsfully certified and approved.

We follow the ISO9000 quality management system, and CE design standard, making the machinery high reliable quality and fast remote service. Meanwhile, Shuanglin service engineer goes all over the world to spread the know-how and skills, to help the pipe factory save energy and waste, improve pipe quality and efficiency.

对接焊铝塑复合管生产线

(内管由PE-Xa,PE-Xb,PE-Xc或PERT制成)

Butt Welding PAP Aluminum Plastic

Composite Pipe Extrusion Line

(The inner pipe material be: PE-Xa, PE-Xb, PE-Xc or PERT)

- 五层结构复合管道
- 内管可选由各种耐热交联材料的管材制成
- 耐热型粘结剂
- 对接焊成型铝管
- 耐热型粘结剂
- 外管由PE,PE-X或PERT制成

技术特点:

- 更大的生产速度结合高水平的产品质量
- 专用交联挤出主机和内管模具
- 高速铝带成型装置和可靠焊接装置
- 壁厚和外径的严格公差保证系统
- 更薄且均匀胶水厚度的专业涂覆模具
- 更加节能和高效的铝管高频加热装置
- 可配置高品质铝带激光接带技术
- 可配置全自动打包收卷装置

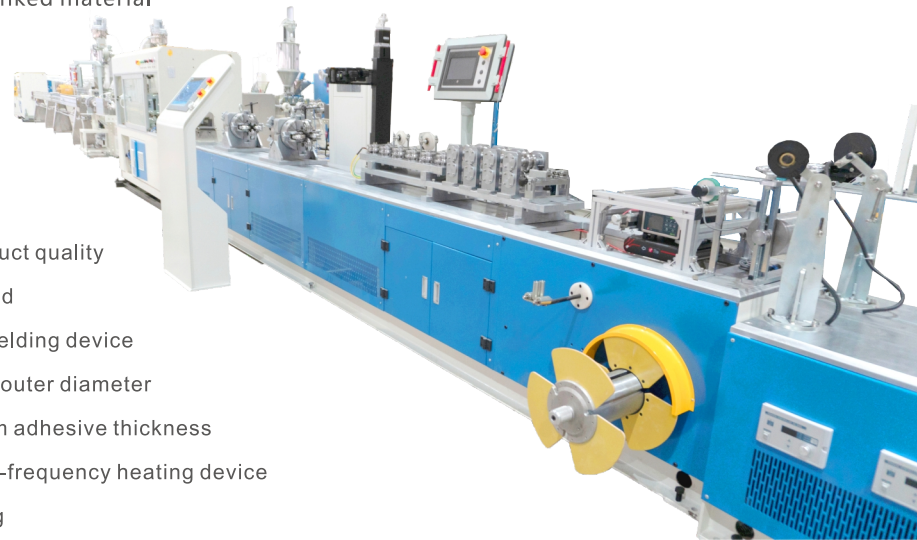
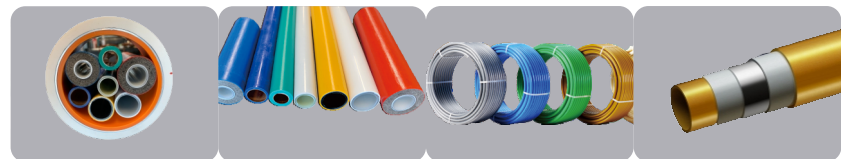
- Five multi layers structure
- Inner pipe can be many kinds heat-resistant cross-linked material
- Heat resistant adhesive
- Butt welding formed aluminum pipe
- Heat resistant adhesive
- Outer pipe can be PE, PE-X or PERT

Technical features:

- The Higher running speed combined with high-level product quality
- Specialized cross-linking extruder and inner pipe die head
- High speed aluminum strip forming device and reliable welding device
- Strict tolerance assurance system for wall thickness and outer diameter
- Professional coating molds with thinner and more uniform adhesive thickness
- A more energy-efficient and efficient aluminum tube high-frequency heating device
- Laser butt welding connector as high-quality for choosing
- Fully automatic packing and winding machine for choosing

主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLAP-YA32	Φ16-Φ32	18	260	56
SLAP-YA32H	Φ16-Φ32	30	350	80
SLAP-YA63	Φ40-Φ63	8	300	60
SLAP-YA110	Φ75-Φ110	3	350	85



搭接焊铝塑复合管生产线

Overlap Welding PAP Composite Pipe Production Line

(PEX-AL-PEX PERT-AL-PERT PE-AL-PE)

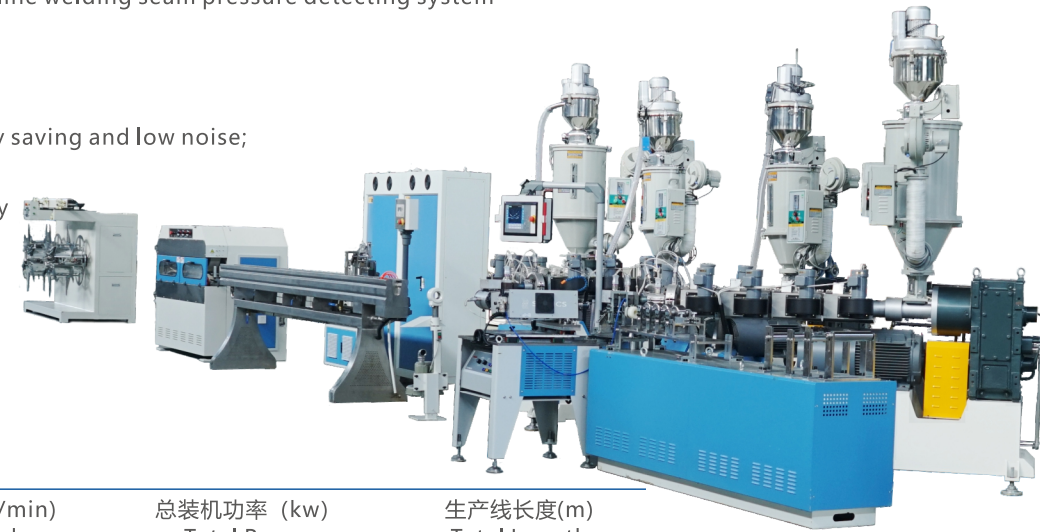
技术特点:

Technical Characteristic:

- 可使用PE-Xb、PE-RT、HDPE等塑料作为主料，兼容各种牌号热熔胶，方便灵活安排订单和生产。
- The extrusion system can use PE-Xb、PE-RT、HDPE materials as well as different model adhesive agents, benefit on production flexible management by marketing requirements.
- 确保生产连续运行的双盘放带和储带装置；
- AL accumulation and connection system ensure the reliable AL connections while continuous production
- 保证可靠焊接的精细铝加工和滚压成型工艺；
- Reliable aluminum forming and welding at high precision by ODM welding horn;
- 稳定可靠的超声波铝带焊接技术；
- Advanced ultrasonic welding technology at high speed with on-line welding seam pressure detecting system
- 粘接工艺前精确的塑性成型工艺；
- Accurate plastic forming process before bonding process;
- 高效、节能、低噪的稳定塑化挤出工艺；
- Stable plasticizing extrusion process with high efficiency, energy saving and low noise;
- 在线保压和全自动收卷技术。
- Online pressure clamping and full automatic winding technology

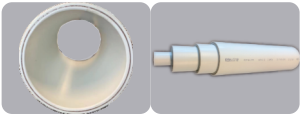
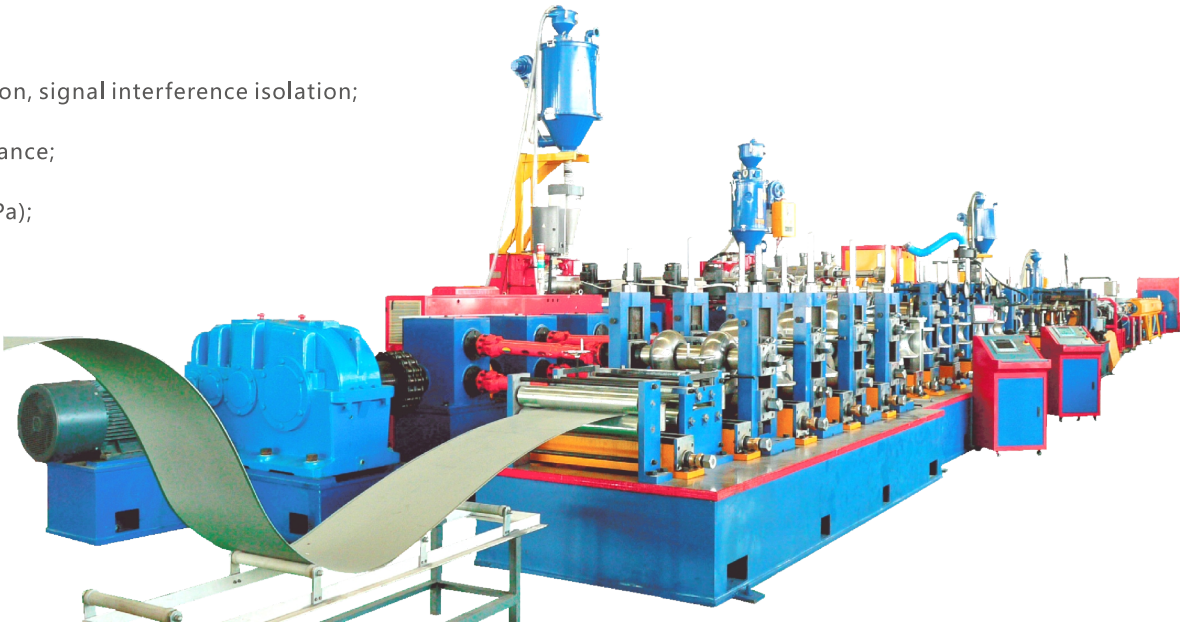
主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLAP-CH32	Φ16-Φ32	15	95	40
SLAP-CH63	Φ40-Φ63	6	180	48
SLAP-CH110	Φ75-Φ110	2	220	60



PSP对接焊钢塑复合压力管生产线
PSP Butt Welding Steel-Plastic Composite Pipe Production Line

PSP管材优点:
具有阻氧、抗菌、高比重吸音、抗干扰屏蔽;
具有较高的刚性和强度;
具有抗冲击性及低膨胀系数和抗蠕变性能;
具有埋地管承压好、容易探测、自示踪性好;
具有适应高压等级和特殊使用条件的要求 (>2.5MPa) ;
PSP Pipe advantages:
With oxygen resistance, antibacterial, high density, sound absorption, signal interference isolation;
High ring stiffness and strength;
Good impact resistance, low expansion coefficient and creep resistance;
High inner pressure, easy detection and good self tracing;
It is suitable for high pressure level and special conditions (> 2.5MPa);
应用范围:
高层建筑冷、热给水主力管道;
医药、食品、化工腐蚀性管道;
高架、快速路穿线屏蔽管道;
建筑集中供热、中央空调采暖管道;
消防管道;
Applications:
Cold and hot water supply in especially for vertical piping;
Pharmaceutical, food, chemical corrosive pipe;
Overhead and expressway shielding pipe;
Building central heating, central air conditioning heating pipe;
Fire fighting pipe;
成型创新技术:
钢管、铝管、不锈钢管、铜管成型焊接技术;
金属层与内外塑料层的粘结复合工艺。
Innovative molding technology:
Steel pipe, aluminum pipe, stainless steel pipe, copper pipe forming and welding technology by on line inspection;
Composite process on metal and plastics reliable adhesion.



暖通/卫浴管生产线
HVAC/ Washroom Pipe Extrusion Line



交联聚乙烯管优点
Advantages of cross-linked polyethylene pipes :
与未交联聚乙烯管相比的产品性能
Improved product properties compared with uncrosslinked PE pipes:
更高的耐热性
- Higher temperature resistance
更高的耐化学性
- Higher chemical resistance
更高的抗冲击性
- Higher impact resistance
更高的耐磨性
- Higher abrasion resistance
更高的抗应力开裂能力
- Higher resistance to stress cracking
更好的减缓裂纹增长
- Higher resistance to slow crack growth

主要技术参数 Main Technical Parameters:

交联PE管 Cross-linked PE pipe	交联类型 Type of cross-linking	交联度 Degree of cross-linking in %	挤出机类型 Extruder type	交联过程 Crosslinking process
PE-Xa	过氧化物化学交联 Chemical cross-linking with peroxide	>70	双螺杆挤出机 Twin-screw extruder	挤出过程中使用在线红外交联 On-line cross-linking using infrared radiation
PE-Xb 一步法b管 PE-Xb one step Spherisil® process	一步法硅烷交联 Chemical cross-linking using silane (direct metering of liquid silane)	>65	专用32D交联料螺杆32D Special cross-linking material screw	下线后使用热水或蒸汽交联 Off-line cross-linking using hot water or steam
PE-Xb 两步法b管 PE-Xb two steps Sioplas® process	用硅烷交联料 Chemical cross-linking with silane	>65	专用32D交联料螺杆 32DSpecial cross-linking material screw	下线后使用热水或蒸汽交联 Off-line cross-linking using hot water or steam
PE-Xc	物理高能量电子束交联 Physical cross-linking using high-energy electron beams	>60	专用双螺杆挤出机30D Twin-screw extruder	下线后使用电子放射交联 Off-line cross-linking using electron irradiation

主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	最大挤出量(kg/h) MMax.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLPE-Xa-32	Φ16-Φ32	30	240	160	50
SLPE-Xb-32-1 (一步法)	Φ16-Φ32	35	280	160	50
SLPE-Xb-32-2 (二步法)	Φ16-Φ32	35	280	160	50
SLPE-Xc-32	Φ16-Φ32	30	240	160	50
SLPE-RT-32	Φ16-Φ32	60	400	180	50
SLPERT/EVOH-32	Φ16-Φ32	45	350	180	50



冷水水聚丙烯双层四出(PP-R)管生产线
 Two Layers PP-R 4 Cavity Pipe Extrusion Line



主要技术特点
 Technical Charateristis

我公司依据多年塑料机械开发设计生产经验，研制出双林“高速双层四出PP-R管生产线”是“一出二 PP-R管生产线”的升级产品。该生产线采用高效节能单螺杆挤出机配合专用模具，生产效率比双管生产线提高50%以上，能耗比降低20%以上，有效的减少设备数量投入，节省厂房地使用面积，同时有效的减少了人力成本。

可根据生产需要更换口模、芯模，同时生产四根不同口径或不同压力等级的管材。

该机采用PLC控制与彩色大屏幕液晶显示屏组成的控制系统，操作简便，全线联动，单机调整，故障自动报警，整线外形美观，生产稳定可靠。

Based on more than 30 years of pipe extrusion machinery manufacturing experience, Shuanglin company has developed "high speed two layers PP-R 4 cavity pipe extrusion line" as an upgraded line of 2 cavity one. The production line uses high efficiency and energy saving single screw extruder with special die, the production efficiency is increased by more than 50% compared with the 2 cavity line, and the energy consumption ratio is reduced by more than 20%. It effectively reduces machinery coverage ,investment amount and labor cost.

The die can be replaced according to production requirements, as well as producing four different sizes or wall thickness pipes at the same time.

The control system composed of PLC control and large colorful LCD screen, which is easy to operate, both full line synchronization and single unit machine adjustment functions, automatic fault alarm, beautiful appearance, stable and reliable production.



主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	最大挤出量(kg/h) MMax.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLPPR-H2-32	Φ20-Φ32	18*2	400	200	55
SLPPR-H4-32	Φ20-Φ32	18*4	700	300	55
SLPPR-H1-75	Φ20-Φ75	18	300	160	55
SLPPR-H1-110	Φ40-Φ110	10	400	180	55
SLPPR-H1-250	Φ75-Φ250	5	600	250	55

聚氯乙烯高效一出四（PVC）管生产线
 High Speed 4 Cavity PVC Pipe Extrusion Line



主机技术：高效主机产量实际生产可提至550Kg/h

定型技术：采用低能耗快速定型，可低至2Kw/h

切割技术：采用无皮带整体式切割电机，可延长寿命10年以上

包装技术：可选配自动套袋包装技术

Extruder: High efficiency extruder 550kg/h

Calibration: Fast calibration lower vacuum power consumption, 2kw/h

Cutting: Integrated direction driving cutter, lifetime 10 years more.

Packing: Full automatic packing with auto stackers.



主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	最大挤出量(kg/h) MMax.Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLPVC-U4-32	Φ16-Φ32	4*15	375	80	20
SLPVC-U4-32	Φ20-Φ32	4*20	550	110	25

聚氯乙烯一出二(PVC)管生产线
PVC 2 Cavity Pipe Extrusion Line



主要技术特点

Technical characteristics

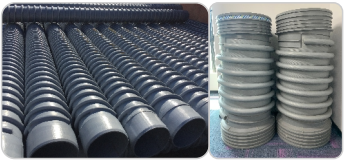
聚氯乙烯一出二UPVC管材生产线，用于生产各类给水、排水、电工穿线管等。
该机采用高效节能锥形双螺杆挤出机，通过专用模具一次性挤出二根PVC管材,有效的节约能源、提高生产产能和效率、节省占地面积和人力成本。
专为一出二PVC管材设计的无尘切割机，采用变频独立调速,可根据切割需要调整切割速度，使用哈夫式夹紧装置，使夹具使用寿命更长、制品切割面平整、无毛刺,解决了PVC切屑粉尘污染问题,采用增量编码器计长切割，确保制品长度切割一致性。
专为喷码机开发的双管喷码移动装置，利用一只喷头喷印双管字符，减少客户对喷码机的资产投入。
专为PVC粉料设计的强制喂料装置，采用双螺杆强制喂料装置,有效防止粉料在喂料过程中架桥和缺料现象发生。
控制系统采用智能分布式最新方案，可单机调整，全线同步联动,故障自动报警,操作简便，自动化程度高，生产稳定可靠。
Two cavity PVC pipe extrusion line produces water supply and drainage pipes, cable coating pipes.
Specially designed conical twin screw extruder equips with two cavities extrusion die head, high speed, obviously saves power, water, workshop coverage and labor.
Unique dust free cutting machine, adopts independent frequency control, precision cutting length setting. Strong huff clamp fixer guarantees the smooth and tidy cutting ends. It ends the PVC dusty cutting history, which helps the factory clean and material saving .
Dual printing system helps one printing nozzle shots working on 2 pipes.
A forced feeding device specially designed for PVC powder, using the double screws forced feeding device, effectively preventing bridging and material shortage during the feeding process of the powder.
SIEMENS PLC Auto control systems, intelligent distribution solutions, supports synchronization and independent control. Multi alarm system of malfunctions, stable and reliable.

主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLPVC-U2-50	Φ20-Φ50	16	100	23
SLPVC-U2-110	Φ50-Φ110	8	120	26
SLPVC-U1-200	Φ50-Φ200	8	150	35
SLPVC-U1-315	Φ110-Φ315	4	150	40
SLPVC-U1-630	Φ315-Φ630	0.8	210	46



HDPE/PP大口径缠绕增强聚烯烃管生产线
HDPE/PP Spiral Wall Winding Pipe Extrusion Line



缠绕技术：可采用主机移动和模具移动高速缠绕技术

挤出技术：可采用单机，双机，三机，四机等几种挤出技术

加热技术：可采用高效节能助燃加热技术和红外加热技术

切削技术：可采用伺服进刀自动化切削技术

吊装技术：可采用自动吊装、移模和脱模技术

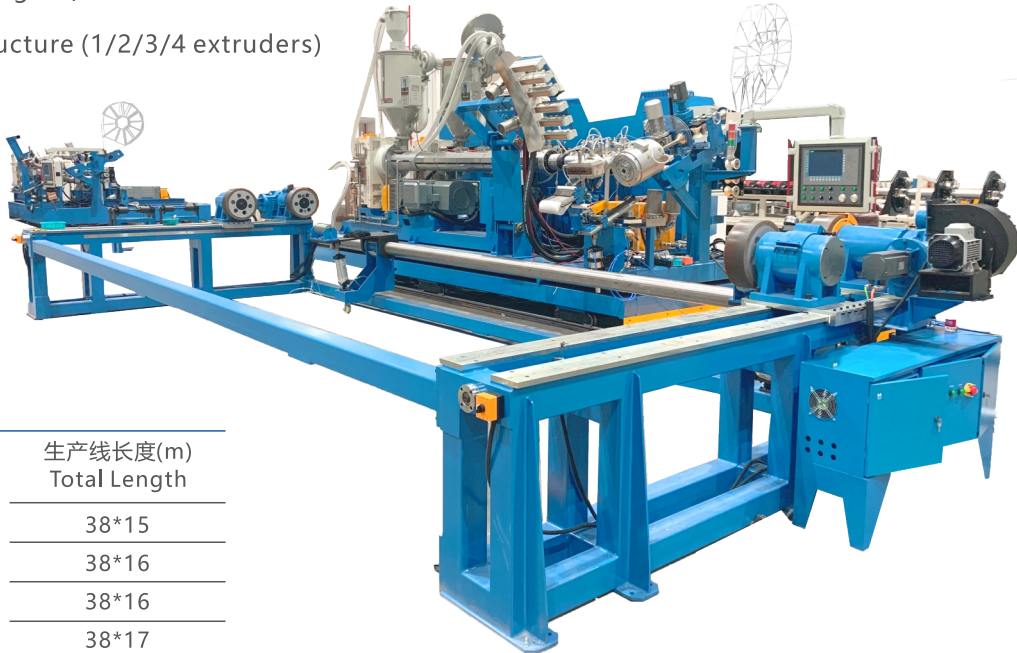
Winding: Mould moving method & Extruder moving method (output 30% higher)

Extrusion: Flexible extruders combination designed for varieties of pipe structure (1/2/3/4 extruders)

Heating: Energy saving and combustion-supporting heating

Chamfering Cutter: Auto cutting by Servo driving

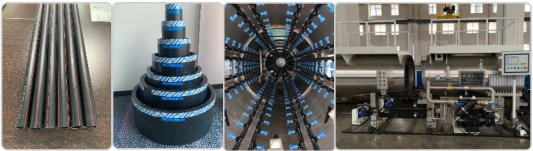
Lifting: Automatic lifting, mold moving, and demolding



主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max.Speed	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLKRP-1200	Φ200-Φ1200	0.4	320	38*15
SLKRP-2000	Φ300-Φ2000	0.35	320	38*16
SLKRP-3000	Φ1500-Φ3000	0.35	450	38*16
SLKRP-4000	Φ2000-Φ4000	0.10	640	38*17

聚乙烯（PE）管生产线
HDPE Pipe Extrusion Line



Main technical charateristics

主要技术特点

依据多年塑料机械开发设计生产经验，在引进国外先进技术并消化吸收的基础上，自行研制开发的HDPE供水管及燃气管生产线。具有结构独特，设计新颖，设备整线布局合理，操控性能强等优点。制品用途广泛、安装方便，目前已经成为城市燃气输送管和室外给水管的首选产品。

生产线采用高效单螺杆挤出机，通过螺旋或篮式模具由多履带牵引机经真空定径冷却而成。众所周知，大口径PE管存在牵引管品种多的问题，双林为此专门研制开发了快速牵引切换装置，从而解决了这个难题。该机经适当变换部分单元，即可实现二层或多层共挤，可根据使用需要更换各挤出层原料或添加特殊材料，如阻燃、抗静电、耐腐蚀、纳米抗菌等原料，大大提高了管材用途，减少了原料的使用量，从而降低管材成本。

生产线采用PLC控制系统，人机对话界面，操作简便，单机调整，全线联动，自动故障报警，生产稳定可靠。

Based on 20 years of plastic extrusion machinery development and design experience, SHUANGLIN combined the advanced technology to prompt this HDPE water and gas pipe extrusion line. Its unique structure design and high efficiency performance been satisfied by the users quickly.

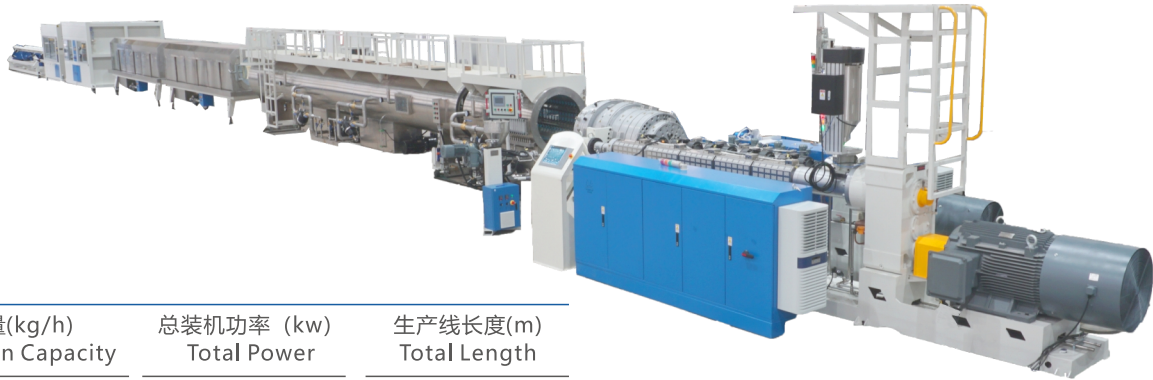
The extrusion line consists of high efficiency single screw extruder, vacuum calibration, spraying water cooling tank, multi-claw hauling machine, planetary cutting machine , pipe stacker and trolley.

HDPE Pipe widely using in the gas and water transportation. The extrusion line can be used to produce two layers or three layers HDPE pipes, which takes the recycled material on the outer layer or middle layer to decrease the cost.

It adopts PLC control system and HMI for whole extrusion line, synchronization function realized, which helps the whole line machine production management and quality control.

主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max. Speed	最大挤出量(kg/h) Max. Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLPE-H32	Φ16-Φ32	60	360	140	40
SLPE-H63	Φ20-Φ63	45	360	150	40
SLPE-H110	Φ40-Φ110	15	360	160	45
SLPE-H160	Φ50-Φ160	8	600	200	45
SLPE-H250	Φ75-Φ250	6	600	250	50
SLPE-H315	Φ90-Φ315	5	640	280	50
SLPE-H630	Φ315-Φ630	3	1000	560	65



PE 2600大口径聚乙烯管道技术
PE 2600 large diameter polyethylene pipe Technic



应用范围:

陆岸线的深海排海工程；
大量发电站的海水冷却工程；
沙漠、岛链的长距离供水工程；
大容量城市雨污收集和内涝整治工程。

Application fields:

Deep sea outfall
Sea water intake and cooling piping for power stations
Long distance water transportation project
Rainwater harvesting and flood management

设备竞争优势：

双切刀厚壁管切割技术
防熔垂技术

Machine advantages:

Dual blade cutter for thick wall pipe cutting
Sagging free die head design

管材竞争优势：

厚壁 卫生 可靠 环保 连续 安全

Pipe advantage:

Thick wall, Health, Reliability ,Environmental Friendly , Continuous, Safety

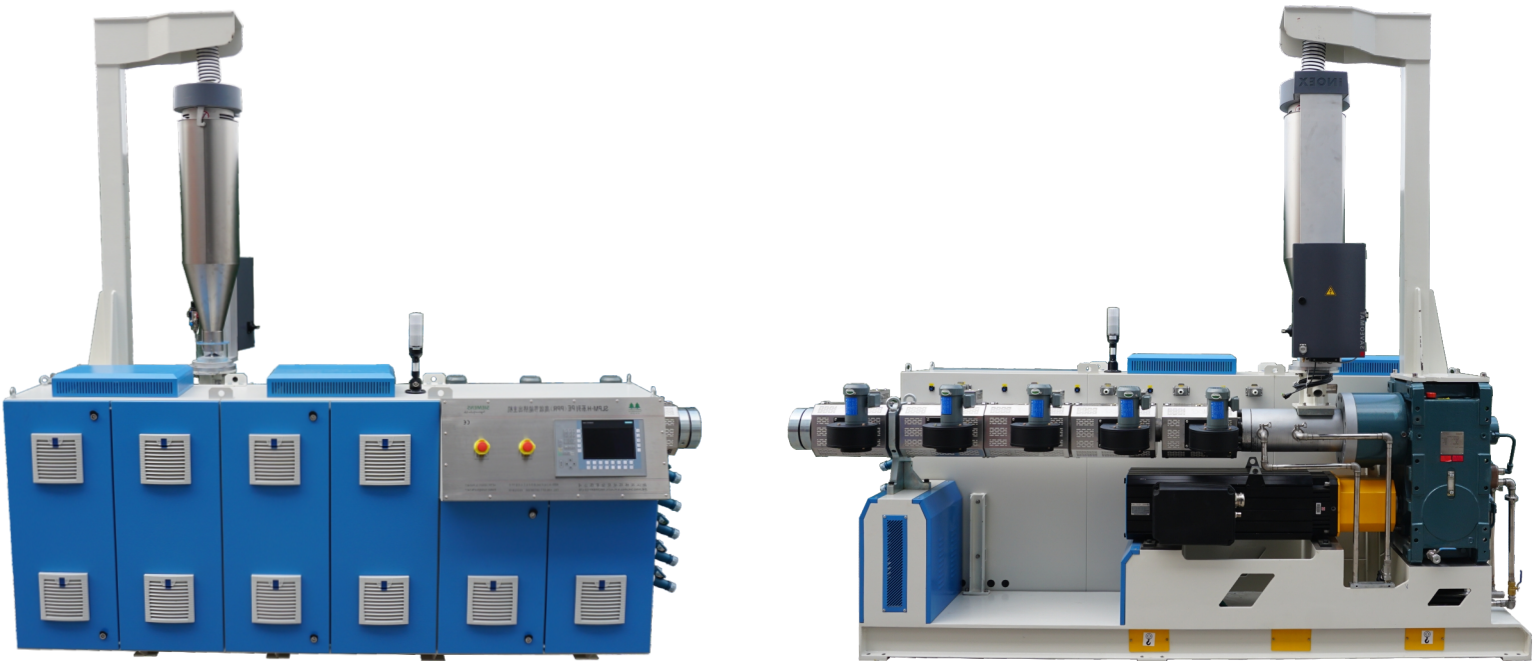


主要技术参数 Main Technical Parameters:

型号 Type	管材规格 (mm) Pipe Size	最高线速度(m/min) Max. Speed	最大挤出量(kg/h) Max. Extrusion Capacity	总装机功率 (kw) Total Power	生产线长度(m) Total Length
SLPE-H800	Φ355-Φ800	1.2	1500	880	75
SLPE-H1000	Φ500-Φ1000	1	1500	900	75
SLPE-H1200	Φ630-Φ1200	0.8	1500	950	75
SLPE-H1600	Φ800-Φ1600	0.6	1900	1200	90
SLPE-H2600	Φ1800-Φ2600	0.2	3000	2000	120

PPR/PE高效节能挤出机

PPR/PE High Efficiency Speed Extruder



- 螺杆技术:单位用电产能提升到4.2Kg/kw.h

Screw design: Output power rate 4.2kg /kw. h

传动技术:传动能效转化率最高提升至 $\eta=9.8T$

Reducing: the highest conversion rate of transmission energy efficiency raise ton=9.8T

动力技术:同步伺服降噪节能，效率提升至95%，节能10%

Driving: synchronous servo motor, noise reduction, energy saving, efficiency up to 95%
- 加热技术:高效保温和红外纳米最高降低能耗30%

Heating : high efficiency insulation and infrared nano reduces energy consumption 30%

模头技术:解决市场PE100级管材和MPP管材合流线

Die head :Eliminate confluence line of PE100 and MPP pipe

控制技术:整套控制系统采用西门子核心元件并通过西门子认证

Control system: The control system adopts Siemens components and has certified by Siemens Standard.

主要技术参数 Main Technical Parameters:

型号 Type	螺杆参数 (mm) Screw Parameter	驱动功率 (kw) Driving Power	加热功率 (kw) heating Power	最大挤出量(kg/h) Maximum Extnusion Volumc	适用原料 Driving Power
SLPM-H60/38	60/38	55	25	220	PE/PPR
SLPM-H60/38	60/38	75	25	300	PE/PPR
SLPM-H60/38	60/38	90	25	360	PE/PPR
SLPM-H60/38	60/38	110	25	440	PE/PPR
SLPM-H75/38	75/38	132	30	520	PE/PPR
SLPM-H75/38	75/38	160	30	640	PE/PPR
SLPM-H90/38	90/38	250	42	1000	PE/PPR
SLPM-H90/38	90/38	280	42	1100	PE/PPR
SLPM-H120/38	120/38	355	56	1300	PE/PPR

管材全自动收卷机

Full automatic pipe winder



管材全自动包装机

Full automatic pipe packing machine

