Comrise Machinery





200MM-4000MM LARGE DIAMETER WINDING PIPE MACHINES

- ◆ Large Diameter PE Hollow Wall Winding Pipe Machine
- ◆ PE Solid Wall Spiral Winding Tank Machine
- ◆ Spiral Winding Corrugated Pipe Machine
- ◆ Steel Reinforced HDPE Spiral Winding Pipe Machine







青岛合瑞斯机械有限公司

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QINGDAO COMRISE MACHINERY CO., LTD

Our team will provide specific technical consultation and advice to customers based on their requirements, provide sufficient company information and product technical parameters, and help customers choose the most suitable machines and solutions.

During the product manufacturing process, every step is rigorously inspected and the progress is promptly updated to the customer. The equipment undergoes comprehensive testing before delivery until it is 100% avalified.

After the equipment arrives at the customer's site, dispatch technical personnel to install the machine on site and provide training to the

Quickly respond and solve problems, equipped with a professional after-sales service team, respond within 12 hours after customers raise issues, and solve problems as soon as possible.

Proactively push product upgrades and updates to customers, helping them understand the latest features and improvements of the product.

Regularly dispatch professional technical personnel for product inspection and maintenance to ensure the normal operation and stability of the equipment.



EXHIBITIONS























CUSTOMER PHOTOS & DELIVERY PICTURES























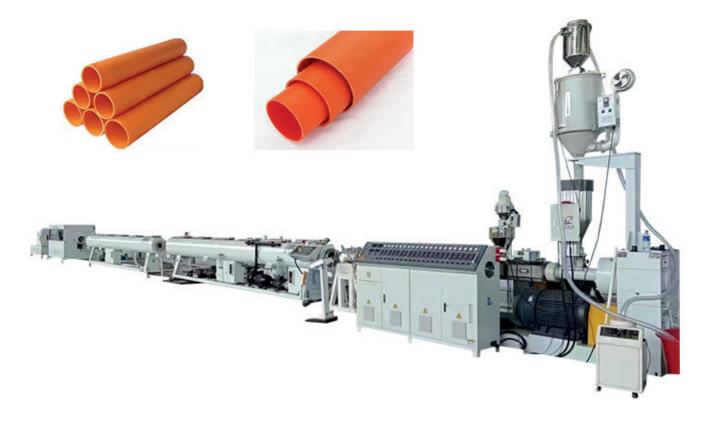


75-250mm MPP MPP 电力保护管设备

MPP power cable protection pipe production line, also known as MPPD power pipe, MPP jacking pipe, MPP direct buried pipe, divided into corrugated shape and straight pipe two kinds, pipe diameter is generally 75-250mm, (75, 90,110,125,140,160,180,200,225,250mm) according to different configurations, there are Ordinary and high-speed lines.

MPP 电力电缆保护管生产线,又称 MPPD 电力管、MPP 顶管、MPP 直埋管,分为波纹状和直管两种,管径一般为 75-250mm (75、 90、110、125、140、160、180、200、225、250mm)。根据不同配置,分为普通生产线和高速生产线。

Extruder 挤出机型号	Material 材料	Output 挤出量
RT75×38	PE	500-550kg/h
RT30×25	PE	8-10kg/h

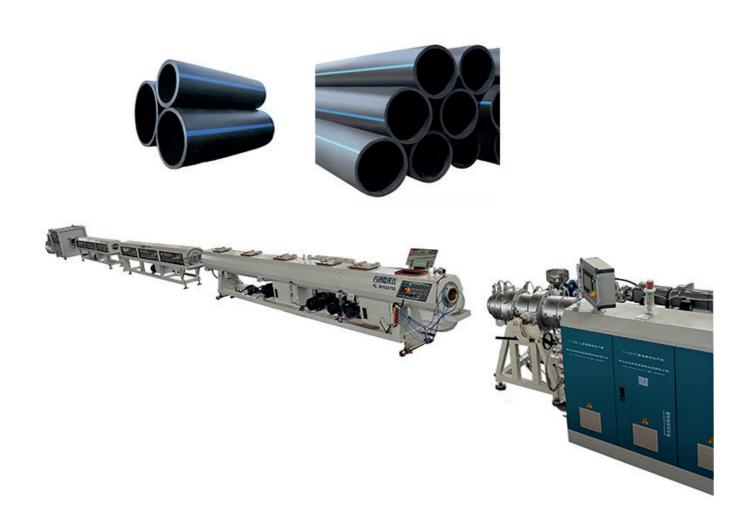


High efficient HDPE water/oil/gas/insulation pipe machine 高效 HDPE 水 / 油 / 气 / 保温管生产线

Qingdao Comrise Machinery manufacture new technology high speed PP/ PE gas/water pipe production line, and MPP electric pipe production line, it has reliable performance and high production efficiency. The finished pipes are mainly used in agricultural water supply and drainage, building water supply and drainage, cable laying, etc.

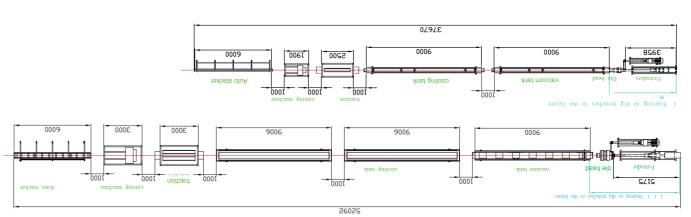
The production line is composed of high efficiency single screw extruder, vacuum sizing water tank, tractor, cutting machine, and pipe bracket.

青岛合瑞斯公司生产的 PE、MPP 电力管、PP 燃气给水管材生产线,主要用于生产农用给排水、建筑给排水、线缆敷设等方面。 该机组由真空定性台、牵引机、切割机、翻料架等组成。



Specifiation Parameters

Model 型号	Pipe diameter(mm) 管径	Extruder Model 主机型号	MainMotor Power(kw) 主机功率	Max Capacity(kg/h) 最大挤出量
HRS-63	Ф20-63mm	SJ60/38	90	450
HRS-110	Ф20-110mm	SJ60/38	110	500
HRS-160	Ф40-160mm	SJ60/38	132	580
HRS-250	Ф50-250mm	SJ75/38	160	680
HRS-400	Ф160-400mm	SJ90/38	250	1000
HRS-630	Ф280-630mm	SJ90/38	280	1100
HRS-800	Ф315-800mm	SJ120/38	315	1300
HRS-1200	Ф500-1200mm	SJ120/38	355	1400
HRS-1600	Ф1000-1600mm	SJ90/38&SJ90/38	250+250	2000
HRS-2000	Ф1000-2000	SJ90/38&SJ90/38	280+280	2200



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PVC/UPVC/CPVC Pipe production line

PVC/UPVC/CPVC 管材生产线

PVC plastic pipe produced by this PVC/UPVC/CPVC Pipe Production Line can be widely used for water supply and drainage system. The MAX.UPVC pipe diameter can be produced is OD.800mm. This production line is equipped with conical twin screw extruder or parallel twin screw extruder. The haul off machine has two-claw, three-claw, four-claw, six-claw types, eight-claws, etc. The cutting machine has saw cutter, no-dust cutter and planetary cutter. We also supply all kinds of PVC dies.

本 PVC/UPVC/CPVC 管材生产线生产的 PVC 塑料管可广泛应用于给排水系统。最大可生产的 UPVC 管材直径为 OD800mm。该 生产线配备有锥形双螺杆挤出机或平行双螺杆挤出机。牵引机有双爪、三爪、四爪、六爪、八爪等多种类型。切割机有锯切式、 无尘切割和行星切割等多种选择。我司还提供各种 PVC 模具。

Specifiation Parameters

Model 型号	Pipe Diameter 管材直径	Extruder 主机	Output(kgs/h) 挤出量	Total Power(KW) 总功率
PVC-63	Ф20-50	SJ51/105	130	50
PVC-160	Ф75-160	SJ65/132	220	85
PVC-250	Ф75-250	SJ65/132	220	95
PVC-315	Ф200-315	SJ80/156	350	150
PVC-450	Ф200-450	SJ80/156	380	180
PVC-630	Ф315-630	SJ92/188	750	230



Steel reinforced hdpe spiral winding pipe machine

钢带增强缠绕管道设备

The steel-reinforced polyethylene spiral winding pipe machine typically consists of an extruder, a molding die, a haul-off device, a cutting device, and a winding device. Its working principle involves feeding both polyethylene raw material and steel strip into the extruder simultaneously. Through the heating and shearing action of the screw in the extruder, the raw material is melted and extruded into shape. During the molding process, the steel strip is embedded into the polyethylene material, forming a steel-reinforced structure. Subsequently, the pipe is stretched and shaped by the haul-off device, ultimately resulting in the steel-reinforced polyethylene spiral winding pipe.

钢带增强聚乙烯螺旋缠绕管机通常由挤出机、成型模具、牵引装置、切割装置、收卷装置等部分组成。其工作原理是将聚乙烯原料和钢带同时送入挤出机,通过挤出机的加热和螺杆的剪切作用,将原料熔融并挤出成型。在成型过程中,钢带被嵌入聚乙烯材料中,形成钢带增强的结构。随后,经过牵引装置的拉伸和定型,最终得到钢带增强聚乙烯螺旋缠绕管。



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HDPE Hollow wall winding pipe production line

HDPE 中空壁缠绕管生产线

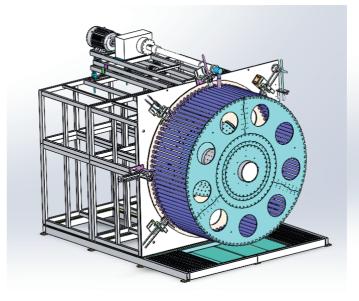
HDPE hollow-wall winding pipes have been successfully used as drainage pipes instead of cement pipes and cast iron pipes, and have broad market prospects. Our company is the authoritative manufacturer of large diameter hollow wall winding pipe production line in China. It has strong technical advantages and rich experience in production and installation. The equipment is advanced in design, high-end configuration, reliable operation, long service life, the output of the same model is far higher than the level of the same industry, especially has rich experience in super large diameter models, and can meet the needs of large scale high-end customers at home and abroad. The performance index of the production line has reached the international advanced level.

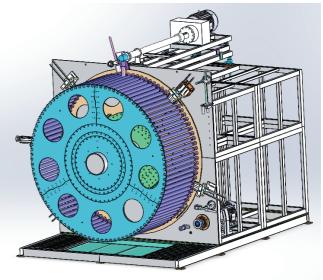
HDPE 中空壁缠绕管作为排水管代替水泥管和铸铁管获得成功,有着广阔的市场前景。我公司是国内权威生产大口径中空壁缠绕管生产线的厂家,拥有强大的技术优势和丰富的贯彻生产安装经验。设备设计先进,配置高端,运行可靠,使用寿命长,同等型号产量远远高于同行业水平,尤其对超大管径机型有丰富经验,能满足国内外大型高端客户的需求。生产线的性能指标达到国际领先水平。



Specifiation Parameters

型号 Model	管径范围(mm) Pipe range		出机 Extr 长径比 L\D	主电机功 率 Motor power	_生产线总装机容量 (KW) 负荷率 50% Installed power(kw) Loading factor 50%	最大产量 kg\h Max.Capacity	机组外形尺 寸长*宽* 高 Overall dimension (L*W*H)
HC-800	200-800	SJ75\33 SJ65\33	33:1	55 30	145	290	23*10*3.2
HC-1200	300-1200	SJ90\33 SJ65\33	33:1	75 37	175	380	24*10*3.5
HC-1600	800-1600	SJ100\33 SJ75\30	33:1	110 45	250	540	26*11*5
HC-2200	1200-2200	SJ100\33 SJ75\30	33:1	132 55	280	740	32*16*6
HC-2600	1400-2600	SJ120\33 SJ75\33	33:1	132 75	260	500	39*17*6.5
HC-3000	1800-3000	SJ120\33 SJ75\33	33:1	160 75	330	820	42*17*7
HC-4000	2000-4000	SJ150\33 SJ90\33	33:1	250kw 90kw	440	1200	48*20*7.5





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HDPE Solid wall winding pipe machine

实壁缠绕管设备

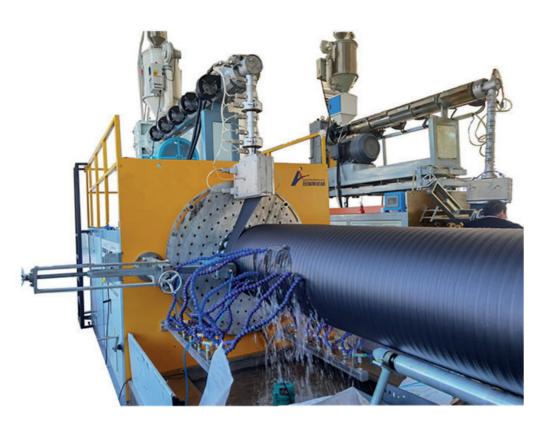
The solid wall winding pipe machine produced by Qingdao Comrise Machinery is mainly used for the production of underground pipe jacking, hollow wall winding pipe joint, inner tube joint, continuous carat pipe joint, double plastic composite pipe joint, insulation pipe; if for jacking or joint usage the pipe is thick wall, if for insulation the pipe is thin wall. The thickness of the tube can be adjusted by adjusting the thickness of the sheet and distance. The operation is flexible and simple, and tubes of different thicknesses and diameters can be produced arbitrarily.

青岛合瑞斯机械有限公司生产的实壁缠绕管设备主要用于生产地下顶管,中空壁缠绕管、内勒管、仿克拉管、双塑复合管接头, 保温管;前两种应用主要采用厚壁管,后一种应用采用薄壁管,管子厚度可通过调节片材厚度和距离等来调节,操作灵活简单, 可任意生产不同厚度和管径的管子

The production line including: winding forming machine, single screw extruder, sheet die head, cutting machine, unloading bracket; pipe diameter range can be produced: 200-3000mm; customized according to customer needs.

设备包含:成型机,单螺杆挤出机,片材机头,切割机,卸料托架;管径范围可生产:200-

3000mm;根据客户需求定制



HDPE Krah Pipe machine

克拉管设备

The continuous carat pipe production line manufactured by Qingdao Comrise Machinery can produce diameter range from 200mm to 3000mm. This production line can also make hollow wall winding tube and inner rib tube by changing molds.

This production line must be equipped with one set single wall corrugated pipe production line, or the customer prepare the single wall corrugated pipe by themselves.

青岛合瑞斯机械克拉管生产范围为 200-3000mm. 该生产线通过更换模具也可以生产中空壁缠绕管和内肋管。

Equipment composition:

1. forming machine --1set1、成型机 1 台2. extruders-- 2sets2、挤出机两台3. coating head--1set3、包覆机头 1 台4. sheet die head--1set4、片材机头一台



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HDPE Rib Reinforced Corrugated pipe machine

内肋增强波纹管设备

PE inner rib pipe winding sewage pipe machine can produce hollow wall winding pipe, inner rib pipe and carat pipe at the same time;

The product ring stiffness is 4/6/8/12.5/16

Product diameter range: 300-1200, 800-2200, 1000-3000mm; according to customer requirements;

内肋管缠绕排污管设备可同时生产中空壁缠绕管,内肋管,克拉管;

制品环刚度为 4/6/8/12.5/16

制品管径范围: 300-1200,800-2200,1000-3000mm; 根据客户定制;

Machine line composition

设备组成:

- 1、单螺杆挤出机 Single screw extruder
- 2、机头模具 Die head&molds
- 3、真空定型平台 / 真空定型箱 Vacuum sizing water tank
- 4、牵引机 Tractor

- 5、成型机 Winding forming machine
- 6、切割机 Cutting machine
- 7、成品管托架 Finished pipe bracket

The above production line can produce HDPE hollow wall winding pipe by replacing the molds. 以上设备可以通过更换模具生产中空壁缠绕管;



Successful Cases

成功案例

200-800mm winding pipe machine VIETNAM



2000mm Solid wall pipe machine for DUBAI



800-2000mm winding pipe machine for Russica



4000mm HDPE Hollow wall pipe machine for AUSTRALIA



3600mm HDPE Hollow wall pipe machine for Russia 2000mm hollow wall pipe for Philippines





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Single-wall corrugated pipe machine

单壁波纹管机

The single-wall corrugated pipe machine developed by our company adopts the gear running module and template, so as to realize the circulating water cooling and air cooling of the product.thus ensuring the production speed is fast, the waveform is uniform, the seam is consistent.

我们公司开发的单壁波纹管机械采用了齿轮运行模块和模板,从而实现了产品的循环水冷却和风冷,确保了生产速度快、波形均匀、接缝一致。

Model 型号	SJ45	SJ50	SJ65	SJ75
Pipe diameter 管直径	4-9mm	9-32mm	16-50mm	63-110mm
Mold quantity 模具数量	Depend on sample	Depend on sample	Depend on sample	Depend on sample
Line speed m/min 生产速度	8-15	8-15	8-12	8-12
Mold cooling way 模具冷却方式	Air/water	Air/water	Air/water	Air/water
Pipe cooling way 管子冷却方式	Air/water	Air/water	Air/water	Air/water



High speed single wall corrugated pipe machine

高速单壁波纹管机

The high speed design technology is import from Germany design, which have 72 pairs or 80 pairs as to different requirement.

高速设计技术是从德国引进的,根据不同需求,它有72对或80对模具。

The corrugated pipes are widely used in automotive wire protection, wire transmission pipelines, machine tool circuits, lamp wire protection tubes, as well as air conditioning and washing machine pipelines.

Model 型号	SJ65	SJ75
Pipe diameter 管直径	12-50mm	50-110mm
Mold block quantity 模具块数量	72	72
Line speed m/min 生产速度	20-30	15-25
Mold cooling way 模具冷却方式	Water/air	Water/air
Pipe cooling way 管子冷却方式	Water/air	Water/air
Fan cooling power(KW) 风扇冷却功率	0.5*3	0.5*4
Winder power(KW) 收卷机功率	10-18.5	10-35
Auxiliary power(KW) 辅助功率	2.2	5
weight(kg) 重量	4500	5500



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40-110mm Double Wall Corrugated pipe extrusion line 双壁波纹管挤出生产线

The main machine adopts special designed high efficiency screw which is specially used for HDPE, it has the features of stable performance and high efficient. The machine has two independence extruder , which can realize both inside and outside layer with different material and colors.

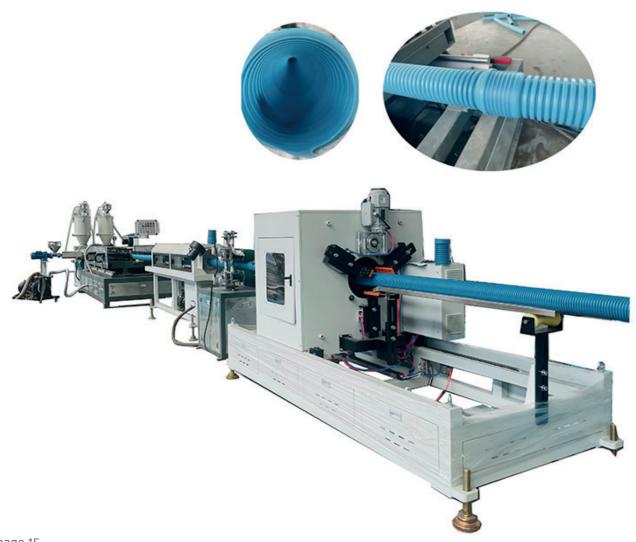
Composite extrusion die head with specially helical structure to make the wall thickness uninfom and stable production.

The corrugated forming system is in combination with water cooling and air cooling to ensure high production speed.

主机采用专为高密度聚乙烯(HDPE)设计的特殊高效螺杆,具有性能稳定、效率高的特点。该机配备两台独立挤出机,可实现内外层使用不同材料和颜色。

复合挤出模头采用特殊螺旋结构,使壁厚均匀,生产稳定。

波纹成型系统结合了水冷和风冷,确保高生产速度。



High speed HDPE double wall corrugated pipe extrusion line with aluminum mold

高速 HDPE 双壁波纹管铝模机生产线

double wall corrugated pipe extrusion line Divided into horizontal and vertical two designs, it produces double layer corrugated pipes from ID200mm to ID800mm, ID600mm to ID1000mm.All the moulds have cooling water inside for continuous cooling, horizontal structure ensures lower operation center height which achieves easier operation.

DWC 波纹管挤出生产线分为水平和垂直两种设计,可生产内径从 200mm 到 800mm,以及从 600mm 到 1000mm 的双层波纹管。 所有模具内部都装有冷却水以实现持续冷却,水平结构确保了较低的操作中心高度,从而更容易进行操作。

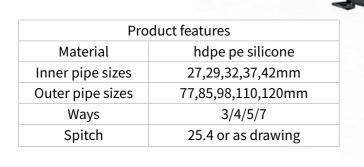


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Underground Fiber Cable HDPE Microduct Extrusion Machine



HDPE communication bundle pipe extrusion line including:
Coil discharging → Guiding device → Coating die → 75/33
Extruder → Vacuum tank → Tractor → winding machine for rolls .



High speed patch-type drip irrigation tape production line

Main advantages of production line

- Double pot screening device, one open and one spare, single pot capacity of 2500 pieces per minute, Patch without interruption
- Integrated water tank transportation with patent design
- Automated integrated decentralized control, easy to operate.
- MES digital standardized production ensures equipment reliability and stability
- Production speed reaches 300-400 meters per minute

Main technical parameters

Pipe specification		Φ1C ma ma		Wall	0.15-	0.15-	0.15-	0.2.0.0000
mm	Ф16mm			thickness	0.2mm	0.2mm	0.2mm	0.2-0.6mm
Wall thickness mm	nm 0.15 0.2		0.3	Dripper	300mm	200mm	100mm	50mm
wall tillckiless illill	0.13	0.2	0.5	space	300111111	200111111	100111111	3011111
wall thickness	+0.05	+0.05	+0.05	Line speed	320-400m/	320-400m/	240m/min	100m/min
tolerance mm	±0.05	±0.05	±0.05	Line speed	min	min	2 4 0111/111111	100111/111111











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Plastic Blister sheet extrusion machine

塑料吸塑片材设备

PP/PS blister thermoforming sheet production line

Pp/ps single-layer sheet, PS coextrusion two-color sheet, PP double-sided high transparent sheet and other sheets used in blister packaging industry

PP stationery sheet production line

PP transparent sheet, frosted sheet (coarse sand, fine sand), two-color sheet and other sheets used in stationery packaging industry.

PP/PS 吸塑热成型片材生产线

吸塑包装行业使用的 pp/ps 单层片材、PS 共挤双色片材、PP 双面高透明片材等片材

PP 文具片材生产线

PP 透明片材、磨砂片材(粗砂、细砂)、双色片材等文具包装行业使用的片材。



Plastic Thick board machine

塑料厚板设备

PP/PE/PVC thick board has advantages of light, uniform thickness, smooth surface, good heat resistance, high mechanical strength, excellent chemical stability and electrical insulation, non-toxic and other characteristics. Widely used in chemical containers, electronic appliances, machinery, medicine and water treatment and other fields.

PP/PE/PVC 厚板具有重量轻、厚度均匀、表面光滑、耐热性好、机械强度高、化学稳定性优异及电气绝缘性良好、无毒等特点。 广泛应用于化工容器、电子电器、机械、医药及水处理等领域。

Technical data

120-180mm
33:1
132-280kw
3-30mm
1200-3000mm
600-1000kg/h
200-580kw



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Plastic profile machine

塑料型材设备

YF series profile machine mainly for producing pvc window door profiles, pvc wpc decking profiles, pvc corner profiles, pvc marble profiles etc.

YF 系列型材机主要用于生产 PVC 门窗型材、PVC/WPC 地板型材、PVC 角线型材、PVC 仿大理石型材等。

Production line composite of double-screw-stem extruder, vacuum shaping table,hall-off machine, cutter, film lamination machine, just change molds and extruder capacity to meet different customer requirements or usage.

该生产线由双螺杆挤出机、真空定型台、牵引机、切割机、覆膜机等组成,只需更换模具和挤出机容量即可满足不同客户要求或 使用场景。

 Model 型号	RT-300					
Width of ceiling panel (mm) 吊顶面板宽度	100, 180, 200	100, 180, 200, 250, 300 for option				
Extruder model 挤出机型号	48/117	51/105	55/120	65/132		
Main motor power 主电机功率	15kw	15kw	22kw	37kw		
Length of vacuum table(mm) 真空台长度	3000 / 4000 /6000/8000/ 10000mm for option					



PP Hollow grid sheet production line

PP 中空格子板生产线

PP Hollow grid sheet is lightweight, impact and oil resistant, and waterproof. Applications include packaging containers, display panels, daily use items, stationery, and protective packaging for building materials. PP can be formed into any shape and type of product such as turnover boxes, component boxes and plastic partitions. This is excellent material widely used for protecting electronic parts.

PP中空网格板具有重量轻、耐冲击、耐油、防水的特点。其应用范围包括包装容器、展示面板、日用品、文具以及建筑材料的保护包装。PP可以制成任何形状和类型的产品,如周转箱、元件箱和塑料隔板。这是保护电子元件的优质材料。

Extruder model 型号	SJ120	SJ100
Product width 产品宽度	2100mm	1220mm
Product thickness 产品厚度	2-8mm	2-8mm
Main motor power 主电机功率	132kw	110kw
Capacity(max.) 最大产能	350kg/h	200kg/h



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Plastic PP PVC Hollow Construction Formwork Building Template Production Line

塑料 PP/PVC 中空建筑模板、施工模板生产线

Plastic PP hollow building formwork building formwork making machine made of recycled PP material 塑料 PP 中空建筑模板制造机,采用回收 PP 材料制成

Model 型号	Board width 板材宽度	Board thickness 板材厚度	Extruder model 挤出机型号	Motor power 电机功率
HRS-1400	1250mm	12-18mm	100/36	55-75kw
HRS1800	1700mm	12-18mm	120/36	75-90kw
HRS2300	2150mm	12-18mm	120/36	90-110kw
HRS2600	2450mm	12-18mm	120/36	90-110kw
HRS3000	2800mm	12-18mm	150/36	132kw



XPS Foam Board Extrusion Machine

XPS 挤出聚苯乙烯发泡板生产线

Brief Introduction

xPS foamed board production line is has advantages of fast board production,low wastage,large capacity, low density and long life span. XPS foamed board is one kind of good insulating materials with continous even surface and beehive structure. It has superior advantages of heat preservation, heat insulation, waterproofness and high compression resistance. XPS board has been widely used in the fields of heat preservation and insulation for roof and outer wall, low temperature storage facilities, surface and undersurface of roads.



Main Technical Parameter

型号 Model	组合形式 Connection type	挤出机直径 / 长径比 Screw diameter and L/D ratio	生产板 材宽度 (mm) Width	生产板材厚 度 (mm) Thickness	生产能力 Capacity (m³/24h)	功率 Power (Kw)	装机容量 Installed power (Kw)	机组外形尺寸 长×宽×高 Overall dimension (L×W×H)
SFBZ- 100/120	单螺杆 / 单螺杆 纵列串联式 Double tandem	单螺杆 100-32D Single screw 单螺杆 120-42D Single screw	600	20-70	180	55 37	180	38mx6mx5m
SFBZ- 135/150	单螺杆 / 单螺杆 直角连接式 Direct connection	单螺杆 135-32D Single screw 单螺杆 150-42D Single screw	600 900 1200	20-120 20-80 20-60	270-350	75 55	260	48mx10mx5m
SFBZ- 75/150	双螺杆 / 单螺杆 直角连接式 Direct connection	双螺杆 75-40D Twin screw 单螺杆 150-42D Single screw	600 900 1200	20-120 20-80 20-60	300-360	75 55	280	48mx10mx5m
SFBZ- 170/200	单螺杆 / 单螺杆 纵列串联式 Double tandem	单螺杆 170-30D Single screw 单螺杆 200-34D Single screw	600 900 1200	20-150 20-150 20-80	400-450	200 160	520	58mx8mx5m

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3PE/2PE Anti Corrosion Coating Pipe Machine

3PE/2PE 防腐涂层管材机

3PE anti-corrosion pipe generally consists of three layers of structure:

- First layer epoxy powder (FBE>100um)
- Second layer adhesive (AD) 170~250um
- Third layer polyethylene (PE) 1.8~3.7mm

The 3PE anti-corrosion coating for steel pipes is a corrosion-resistant structure composed of a bottom layer of epoxy powder, an intermediate layer of adhesive, and an outer layer of polyethylene composite. It has the advantages of strong corrosion resistance, high mechanical strength, excellent electrical insulation performance, high mechanization degree of production lines, relatively stable process parameters, and no environmental pollution. It



has been widely used in pipeline anti-corrosion engineering at home and abroad.

钢管 3PE 防腐层是由底层环氧粉末、中间层粘合剂和外层聚乙烯复合材料组成的耐腐蚀结构。 它具有耐腐蚀性强、机械强度高、电气绝缘性能优异、生产线机械化程度高、工艺参数相对稳定、无环境污染等优点。 它在国内外管道防腐工程中得到了广泛的应用。

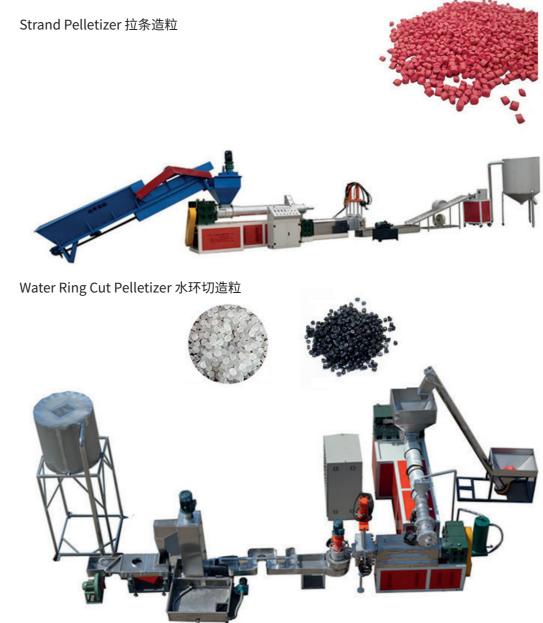


Plastic recycling& granulator machine

塑料回收造粒机

Comrise recycling machine lines including wast plastic crushing and washing line, SJ series granulator lines like pull strand pelletizers and water ring cut pelletizers, for recycling various types of wastage such as woven bags, films, mulch films, mineral water bottles, shampoo bottles, and oil cans (PP, PE, PET, PS, ABS, PA, PVC, PC, POM, EVA, PMMA).

合瑞斯回收机生产线包括废塑料破碎和洗涤生产线,SJ 系列造粒机生产线,如拉条造粒机和水环切造粒机,用于回收各种类型的废料,如编织袋、薄膜、地膜、矿泉水瓶、洗发水瓶(PP、PE、PET、PS、ABS、PA、PVC、PC、POM、EVA、PMMA)等。



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