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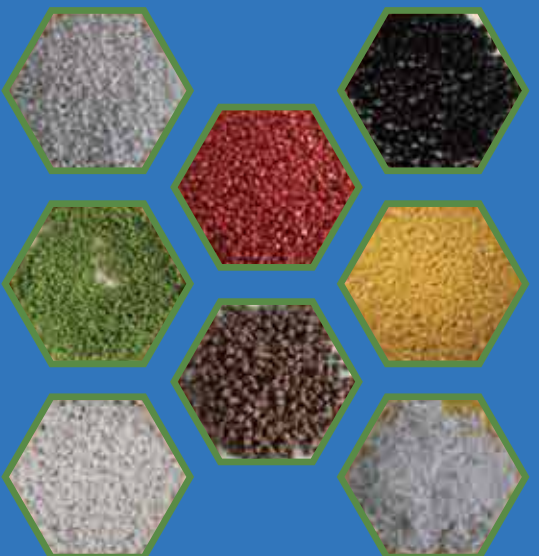
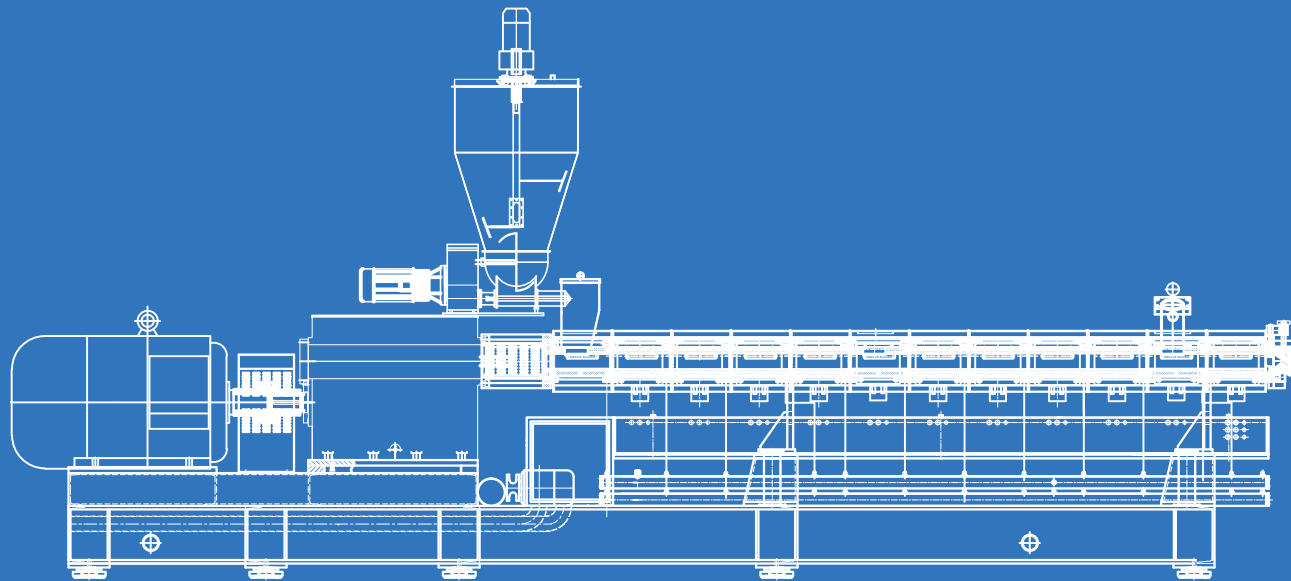
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About MQ

MQ 是一家专业的机械设计制造企业。
MQ 的产品专注于橡塑类造粒设备和橡塑类挤出成型设备。
MQ 始终以解决市场需求为导向，例如针对现在的世界性环境难题 -- 白色污染，我们研发并推出了降解设备系列：降解颗粒造粒设备，降解料吹膜制袋设备，降解料片材挤出设备，降解料吸塑注塑设备，降解料吸管设备等等。
MQ 以国家利益为前提，以人才为根本，以技术为核心，以客户利益最大化为宗旨，始终走在世界潮流的前列。您正好需要，而我们正好专业，欢迎您选择 MQ。

MQ is a professional machinery design and manufacturing company. MQ products focus on rubber and plastic granulation equipment and rubber and plastic extrusion equipment. MQ is always guided by solving the market demand. For example, in view of the current worldwide environmental problem -- white pollution, we have developed and launched a series of degradation equipment: degradation granules granulation equipment, degradation material film blowing and bag making equipment, degradation material sheet extrusion equipment, degradation material suction molding equipment and injection equipment, degradation material straw equipment and so on. MQ takes national interests as the premise, talents as the foundation, technology as the core, and customer benefit maximization as the purpose, and always walks in the forefront of the world trend. You just need it, and we are professional, you are welcome to choose MQ.



产品目录 PRODUCTION CONTENT

A	生物降解塑料造粒机组 Biodegradable Plastic Granules Production Line	
	介绍 Introduction.....	01
	型号 Model.....	02
	应用 Application.....	03
	特点 Features	05
B	生物降解片材生产线 Biodegradable Sheet Production Line	
	介绍 Introduction.....	06
	型号 Model.....	07
	组成部分及说明Components and descriptions.....	08
C	生物降解吸塑成型机 Biodegradable Blister Machine	
	介绍 Introduction.....	09
	型号 Model.....	10
	工艺流程 Process flow diagram.....	11
	案例 Case.....	12
	用途 Usage.....	13
D	生物降解吹膜机 Biodegradable film blowing mahcine	
	介绍 Introduction.....	14
	主要技术参数 Main Technical Variables.....	15
	用途 Usage.....	16
E	生物降解制袋机 Biodegradable bag-making machine	
	介绍 Introduction.....	17
	主要技术参数 Main Technical Variables.....	18
	用途 Usage.....	19
F	PLA 注塑生产线 PLA Injection molding production line	
	介绍 Introduction.....	20
	型号 Model.....	21
	用途 Usage.....	22
G	PLA 流延膜生产线 (设备交钥匙工程) PLA casting film production line (equipment turnkey project)	
	介绍 Introduction.....	23
	特点 Features	24
	型号 Model.....	25
H	可生物降解PLA淋膜机 Biodegradable PLA Laminating Machine	
	介绍 Introduction.....	26
	型号 Model.....	27
	特点 Features	28
	用途 Usage.....	29
I	PVA水溶性制粒机 PVA Water Soluble Granules Making Machine with conveyor	
	介绍 Introduction.....	30
	型号 Model.....	31
	应用 Application.....	32



生物降解塑料造粒机组

Biodegradable Plastic Granules Production Line



平行同向高扭矩双螺杆挤出机，具有良好的混合性能和自洁性能，加长长径比，使材料可以完全塑化，保持产能稳定，最后的颗粒无气孔。

淀粉和聚乳酸 PBAT 混合后可降解，在农业上主要用作农膜和园艺材料；在餐饮业的应用主要是用作快餐盒、一次性杯子、盘子、刀叉等；包装材料主要是日常物品的包装，包括各种购物袋、袋子、垃圾袋、食品袋等。

Parallel co-rotating high-torque twin-screw extruder with excellent mixing and self-cleaning performance, elongated aspect ratio so that,the plastic can be plasticized totally,keep the capacity steady and without air hole in the final gran-ules.

Starch and PLA PBAT are degradable after mixing,and it is mainly used as ag-ricultural film and horticultural material in agriculture; the application in catering industry is mainly used as fast food boxes, disposable cups, plates, and knives and forks; the packaging materials are mainly the packaging of daily items, including various shopping bags, Bags, garbage bags, food bags, etc.



型号

Model

设备型号 Types	齿轮箱型号 Gearbox series	螺杆直径 Dia(mm)	螺杆长径比 L/D	螺杆转速 N(r/min)	主电机功率 P(kw)	产量 Q(kg/h)
MQ35	B	35.6	32-60	600	15	15-55
MQ50	B	50.5	32-60	600	55	100-150
MQ65	B	62.4	32-60	600	90	200-300
MQ75	B	71	32-60	600	132	300-500



MQ-35 实验型可降解双螺杆风冷拉条造粒机组

MQ-35 LAB Biodegradable twin screw extruder air cooling strand pelletizing line

双螺杆风冷拉条造粒机基本构成：10L 高混机 - 双螺杆挤出机 - 抽真空系统 - 液压换网器 - 6 米风冷输送带 - 切粒机

应用于：PLA+ 淀粉、PLA+CaCO₃、PBAT+ 淀粉、PBAT+CaCO₃ 造粒配方测试，学校或实验室教学。

Composition of Twin screw extruder air cooling strand pelletizing line : 10L High speed mixer - Twin screw extruder - Vacuum system - Hydraulic screen changer - 6m Fan cooling conveyor belt - Pelletizier.

Used in:PLA+Starch、PLA+CaCO₃、PBAT+Starch、PBAT+CaCO₃ granulation formula test, university or laboratory teaching.



MQ-65B 可降解双螺杆风冷拉条造粒机组

MQ-65B Biodegradable twin screw extruder air cooling strand pelletizing line

双螺杆风冷拉条造粒机基本构成：300L 高混机 - 双螺杆挤出机 - 抽真空系统 - 液压换网器 - 18 米风冷输送带 - 切粒机 - 振动筛 - 料仓 - 电柜

应用于：PLA+ 淀粉、PLA+CaCO₃、PBAT+ 淀粉、PBAT+CaCO₃ 填充造粒

Composition of Twin screw extruder air cooling strand pelletizing line : 300L High speed mixer - Twin screw extruder - Vacuum system - Hydraulic screen changer - 18m Fan cooling conveyor belt - Pelletizier - Vibration screen - Silo - Electric cabinet.

Used in:PLA+Starch、PLA+CaCO₃、PBAT+Starch、PBAT+CaCO₃ filler compound granules.





特点 Features

1. 交钥匙工程：MQ 提供交钥匙工程。从设备到材料产品的整条流程都能系统性的交付客户，大大的缩减客户的工作量，提高了工作效率。MQ 有自己的工厂，生产各种全生物降解产品，经验充足。可以为您解答实际生产中会遇到的问题。
2. 更加精确：所有的关键部件，包括齿轮、轴、螺杆和机筒都是由 MQ 加工的。这将保证我们的机器有更稳定的运行状态。机器配有远距离控制和故障诊断、维修、超差报警等功能。
3. 灵活的螺杆配置：使用 MQ 挤出机，您可以根据不同的应用改变螺杆配置。这要归功于灵活的螺杆设计，它将帮助你非常容易地做到这一点。
4. 定制化设计：MQ 首先为那些需要根据以往经验对挤出机进行特殊设计的客户提供服务。
5. 技术支持：MQ 常年与中国的各大院校和研究所保持着密切的联系，充分的做到技术共享和技术互助，每每新技术发现的同时都能最快得知，真正的做到专业和专注。



1. Turnkey Projects : MQ offers turnkey projects. The entire process from equipment to material products can be delivered systematically to the customer, significantly reducing the customer's workload and increasing efficiency. MQ has its own factory, producing a wide range of fully biodegradable products, and has plenty of experience. We can provide answers to the questions you may encounter in actual production.
2. More Accurate : All the key parts including gears, shafts, screws and barrels are processed by MQ. That will guarantee our machines a more stable running condition. The machine have functions such as long-range controlling and trouble diagnosing, repairing , ultra difference alarms and so on.
3. Flexible Screw Configuration : With MQ extruder, you can change the screw configuration for different applications. That thanks to the flexible screw design, it will help you very easily to do so.
4. Customized Design : MQ firstly gives the service to customers who need special design for their extruders based on their previous experience.
5. Technical support : MQ maintains close contact with major universities and research institutes in China throughout the year, so that we can fully share technology and technical mutual assistance, and we can learn about new technologies as soon as they are discovered, so that we can truly be professional and dedicated.



生物降解片材生产线 Biodegradable Sheet Production Line



PLA 聚乳酸 \ 淀粉基生物降解材料是一种新型的生物基及可再生物完全降解材料，使用可再生的植物资源（如玉米等）所提出的淀粉原料制成。淀粉原料经由糖化得到葡萄糖，再由葡萄糖及一定的菌种发酵制 成高纯度的乳酸，再通过化学合成方法合成——定分子量的聚乳酸。其具有良好的生物可降解性，使用后能被自然界中微生物在特定条件下完全降解，最终生成二氧化碳和水，对土壤和空气不造成污染，并可增加土壤肥力，回归大自然，不污染环境，这对保护环境非常有利，是公认的环境友好材料。

生物降解片材机由 SHJ 普通型和 SHJ-A 新型高扭矩、高转速、高产量的双螺杆挤出机以及辅机构成，该种设备还可以于电线电缆料、工程塑料、改性塑料、弹性体、高填充母粒、色母粒、型材、包装带及薄膜等行业。常规的材料为：PLA、PET、PP、PE、PS、PET、EVA、ABS 等塑料片材。

PLA polylactic acid is a new bio-based and completely biodegradable material made from starch derived from renewable plant resources (e.g. corn). Glucose is obtained by saccharification of starch raw materials, and then glucose and certain strains of bacteria are fermented to produce high purity lactic acid, and then polylactic acid of certain molecular weight is synthesized by chemical synthesis. It has good biodegradability and can be completely degraded by microorganisms in nature under specific conditions after use, eventually producing carbon dioxide and water, which does not cause pollution to soil and air, and can increase soil fertility, return to nature, and do not pollute the environment, which is very beneficial to the protection of the environment, and is recognized as an environmentally friendly material.

The biodegradable sheet machine consists of SHJ ordinary type and SHJ-A new type high torque, high speed, high output twin-screw extruder and auxiliary machine, and the modified equipment can also be used in wire and cable materials, engineering plastics, modified plastics, elastomers, highly filled masterbatches, color masterbatches, profiles, packaging tape and film industries. The conventional materials are: PLA, PET, PP, PE, PS, PET, EVA, ABS and other plastic sheets.



型号
Model

型号 Model	MQ 50/65/75/95
适用原料 Materials	PLA/PBS/PBAT
制品宽度 Width	400-2000mm
制品厚度 thickness	0.15-2.5mm
挤出机规格 Extruder specification	Φ50.5,Φ62.4,Φ71,Φ93
挤出产量 Capacity	50-900Kg

优势
Advantages

1. 智能化的先进控制系统，网络传输速度迅速，使信息的传送误差大大减少，使设备的速度、压力、物料输送更加稳定。
2. 收卷部分采用伺服控制，更加准确，和整机具有速度同步功能，让收卷更方便简单，也更具有安全性。
3. 全套采用国际一线品牌西门子变频伺服控制，以太网传导技术控制，实现高效率、高精度、高稳定、高安全性。在设备故障时快速定位错误并能够进行远程维护,可通过 HMI 实现通道级诊断和错误分析,大大减少调试与生产停机时间。高数字化的系统使调试更简单，维护更便捷。
4. 完备的售后服务体系，从设备安装调试到高质量产品的生产制造，并提供终身技术支持，让客户无后顾之忧。

1. Intelligent advanced control system, rapid network transmission speed, so that the transmission error of information is greatly reduced, so that the speed, pressure, material conveying equipment more stable.
2. The winding part of the servo control, more accurate, and the whole machine has a speed synchronization function, so that the winding is more convenient and simple, but also more secure.
3. A full set of international first-class brand Siemens frequency conversion servo control, Ethernet conduction technology control, to achieve high efficiency, high precision, high stability, high security. In case of equipment failure, we can quickly locate errors and perform remote maintenance, and we can realize channel-level diagnosis and error analysis through HMI, which greatly reduces debugging and production downtime. The high digital system makes debugging easier and maintenance more convenient.
4. Complete after-sales service system, from equipment installation and commissioning to the manufacture of high-quality products, and provide lifelong technical support, so that customers have no worries.



组成部分及说明
Components And Descriptions

1. 生物降解原料干燥罐：一套 → 2. 真空上料机：一套 → 3. 真空负压系统：一套 → 4. 双流道过滤器：一套 → 5. 熔体计量泵：一套 → 6. 生物降解专用型模具 → 7. 涂硅油烘箱装置：一套 → 8. 边料剪切装置：一套 → 9. 牵引机：一套 → 10. 双工位收卷机：一套 → 11.SIEMENS 人机界面控制系统

- 1.iodegradable raw material drying tank : one set → 2.Vacuum loading machine : one set → 3.Vacuum negative pressure system : one set → 4.Double flow channel filter: one set → 5.Melt metering pump: one set → 6.Biodegradable special type mold → 7.silicone oil coating oven device: a set → 8.Side material shearing device: one set → 9.Traction machine: one set → 10.Duplex winder: one set → 11.SIEMENS human-machine interface control system





生物降解吸塑机

Biodegradable film blowing mahcine

生物降解吸塑机又叫生物降解热塑成型机，是将加热塑化的 PLA 等热塑性塑料卷材吸制成各种形状的高级包装装璜盒、框等产品的机器。利用真空泵产生的真空吸力，将加热软化后的 PLA 等热可塑性塑料片材经过模具吸塑成各种形状的真空罩、吸塑托盘、泡壳等。

其机器主要构造是由给料、拉料、上下电加热炉、下闸、多功能可调尺寸、下模盘、上模、上闸、刀闸、切片、放片及配以真空装置等构成。

Biodegradable blister machine, also called biodegradable thermoforming machine, is a machine that blisters heated and plasticized PLA and other thermoplastic coils into various shapes of advanced packaging and decoration boxes, frames and other products. The vacuum pump generates the vacuum suction, and then the heated and softened PLA and other thermoplastic sheets are sucked into various shapes of vacuum covers, blister trays and blisters through the mold.

The main structure of the machine is composed of material feeding, material pulling, upper and lower electric heating furnace, lower gate, multi-functional adjustable size, lower die plate, upper die, upper gate, knife gate, slicing, sheet release and with vacuum device.



型号

Model

型号 Model	MQX 61A/61B/61C
适用原料 Materials	PLA/PBS/PBAT
设备宽度 Width	400-2000mm
制品厚度 thickness	0.15-2.5mm
挤出机规格 Extruder specification	Φ50.5,Φ62.4,Φ71,Φ93
挤出产量 Capacity	Adjustable

特点

Features

1. 其主要特点在于采用了真空成型机构，运用塑料片材成型工艺技术，是集机、电、气一体化设计，采用微电脑及工控可编程器 PLC 控制，整个系统 HMI（人机界面），自动化程度高。
 2. 专用于热成型和产品自动收卷的流水式生产线。加工高透明、高拉伸、浅拉伸、圆型、方型、不规则、上下双向拉伸、翻边等产品，生产各种生物降解盒、碟、托盘、碗、盖、工业包装类等包装制品。
1. Its main feature is the adoption of vacuum forming mechanism, the use of plastic sheet forming process technology, is a set of machine, electricity, gas integrated design, the use of microcomputer and industrial control programmable PLC control, the whole system HMI (human-machine interface), a high degree of automation.
 2. A flowing production line dedicated to thermoforming and automatic product winding. Processing high transparent, high stretch, shallow stretch, round, square, irregular, up and down bi-directional stretch, flanging and other products, producing various biodegradable boxes, plates, trays, bowls, lids, industrial packaging and other packaging products.





生物降解热成型工艺流程图解

Biodegradable thermoforming process flow diagram

生物降解塑料片材 → 切割 → 片材固定 → 加热 → 成型 → 脱模 → 去料边 → 成品

Biodegradable plastic sheet → cutting → sheet fixing → heating → forming → Demoulding → Dematerial edge → Finished product

吸塑成型对材料的要求：

1. 吸塑成型只能生产壁厚比较均匀的产品 ,(一般倒角处稍薄), 不能制得壁厚相差悬殊的塑料制品。

2. 吸塑成型的壁厚一般在 1 到 2 毫米范围之内或更加薄（小包装用吸塑包装的片材最常用的厚度为 0.15 到 0.25 毫米）。

3. 吸塑成型制品的拉伸度受到一定的限制，吸塑成型的塑料容器直径深度比一般不超过 1，极端情况下亦不得超过 1.5。

4. 吸塑成型的尺寸精度差，其相对误差一般在百分之一以上。





Material requirements for blister molding：

1.Suction molding can only produce products with relatively uniform wall thickness, (generally slightly thin at the chamfer), can not be made of plastic products with a wide range of wall thickness

2.The wall thickness of blister molding is generally within the range of 1 to 2mm or thinner (the most common thickness of blister packaging sheet for small packages is 0.15 to 0.25mm)

3.The stretching degree of blister molding products is limited to a certain extent, and the diameter to depth ratio of blister molding plastic containers generally does not exceed 1, and in extreme cases, it should not exceed 1.5

4.The dimensional accuracy of blister molding is poor, and the relative error is generally more than one percent.



案例

Case

编号 No.	名称 Name	参数 Specification & Model	编号 No.	名称 Name	参数 Specification & Model
1	形成方法 Forming method	正面和负面 Positive and negative	8	拉进系统 Pull-in system	台湾 " 台达 "3KW 伺服马达 Taiwan "Delta" 3KW Servo motor
2	成型尺寸 Forming size	成型宽度：50-2000 毫米 Forming length：350mm-550mm; Forming width：410mm-600mm	9	成型单元 Forming unit	上、下模：由 "Delta " 伺服电机驱动 3KW 连杆结构 Upper 、lower die：3KW drive by "Delta" servo motor connecting rod structure
3	成型高度 Forming height	≤100 毫米 ≤100mm	10	裁切单元 Cutting unit	上、下模：5.5KW，由 "Delta " 伺服电机连杆结构驱动。 Upper 、lower die：5.5KW drive by "Delta" servo motor connecting rod structure
4	材料和厚度 Material&thickness	生物降解片材 / 0.15 毫米 -2.0 毫米 PVC、PET、PS、PP And so on. 0.15mm-2.0mm	11	堆叠单元 Stacking unit	产品未完全切开，用三角伺服电机配合吸盘将产品自上而下堆放。 产品可以完全切割，用机械手抓取和堆放 使用机械手（两用）在传送带上抓取和堆放。 The product is not completely cut, using delta servo motor with suction cup to stack the product top down. The product can be completely cut and used to grab and stack the conveyor belt with a manipulator (dual purpose).
5	送料系统 Feeding system	由电机自动送料，最多可送 200 公斤一卷材料。可选择增加硅胶注射系统 Automatic feeding by motor，up to 200KG a roll of material.Optional addition of silicone injection system	12	回收系统 Recycling system	德国 "JSCC " 可调节扭矩的充电马达 Germany "JSCC" Adjustable torque motor recharging
6	加热系统 Heating system	上、下加热炉采用 54 块 600W 的节能 600W 的加热砖，上、下层加热分为两部分。 The upper and lower heating furnace adopts 54 energy saving heating bricks of 600W, and the upper and lower heating is divided into two sections.	13	控制系统 Control system	台湾 " 台达 "10.1 英寸触摸屏，PLC：台湾 " 台达" Taiwan "Delta" 10.1"inch touch screen，PLC：Taiwan "Delta"
7	温控系统 temperature control system	采用上海 " 奥一 " 温控模块，逐一控制温度，具有快速加热和快速调节功能 Adopt Shanghai "AOYI" temperature control module to control the temperature one by one, can quickly heat and quickly adjust the function			

用途 Usage



生物降解吸塑机生产线被广泛应用于可降解的餐盘，杯子和容器的生产。

Biodegradable film blowing machine molding line is widely used in the production of biodegradable plates, cups and containers.

生降解吹膜机 Biodegradable film blowing machine

挤出机、机筒、螺杆均采用优质合金钢经渗氮处理，硬度好，耐腐蚀，经久耐用。特殊设计的螺杆塑化质量好，有利于提高生产能力。

用途：适用于吹制热塑性生物降解塑料。广泛适用于可降解食品袋、可降解服装袋、可降解垃圾袋、可降解背心袋等包装袋的生产。

Its extruder, cylinder and screw rods are made of quality alloy steel that have been nitriding, So it is sound in hardness, durable in corrosion resistance. The specially-designed screw is of sound quality in plasticizing, which helps increase the production capacity.

Uses: Suitable for blowing thermoplastic biodegradable plastics. It is widely used in the production of packaging bags such as biodegradable food bags, biodegradable clothing bags, biodegradable garbage bags, and biodegradable vest bags.

机器主要部件

鼓风机 3.7kw
旋转模头，两个
单唇气环
手动 T 型连接
压花辊
双收卷机，力矩电机控制器
科强温控器

Machine Main parts

Blower 3.7kw
Rotary die head, two pcs
Single Lip air ring
Manual T connection
Embossing roller
Double rewinder, Torque motor controller
Chinese Brand electric parts like KeQiang Temperature controller





主要技术参数
Main Technical Variables

型号 Model	MQ-50/MC600	MQ-55/MC800	MQ-60/MC1000	MQ-65/MC1200
螺杆直径 Screw Diameter (mm)	Φ50	Φ55	Φ60	Φ65
螺杆长径比 Screw Length (L/D)	28:1	28:1	28:1	28:1
薄膜宽度 Film Width(mm)	200-600	300-800	400-1000	600-1200
薄膜厚度 Film Thickness(mm)	0.006-0.10	0.006-0.10	0.006-0.10	0.006-0.10
最大挤出量 Max.Extrusion Output (kg/h)	45	55	60	70
模具尺寸 Die Size(mm)	Φ60/100	Φ100/150	Φ100/200	Φ120/250
气缸冷却 Cylinder Cooling (Kw)	0.25	0.25X2	0.25X2	0.25X3
驱动电机 Driving Motor(kw)	11	15	18.5	22
总功率 Total power(kw)	28	36	42	48
尺寸 Cover Dimension(m)	5.0*2.1*4.5	5.0*2.3*4.8	5.5*3.3*5.5	5.8*3.6*6
机器重量 Weight of Machine(kg)	1500	2000	2300	2600



用途
Usage



冰棒袋
Popsicle bag



服装袋
Garment bag



快递袋
Courier bag



奶茶袋
Milk tea bag



生物降解制袋机

Biodegradable bag-making machine

用于生产可降解背心袋和平口袋。主电机采用台湾变频电机，更省电，调速更自如。放卷机为台湾设计，与主机速度相同，所有电器均为名牌。寿命也更长。全自动，节省工人，保护环境。

It is used for producing Biodegradable vest bags and flat-opening bags. The main motor adopts Taiwan frequency conversion motor to save more electricity and regulate speed more freely. The unwinder is Taiwan design, Same speed as main machine. And All electric parts is Famous brand. Longer life also. It is fully automatically, save worker and protect environment.

机器主要部件

单伺服电机，中国品牌 2kw
主电机 1.5kw，台湾品牌
逆变器 Delta，放卷逆变器
温度控制器 - 欧姆龙
台湾 Airtag 电动阀
电器配件 --- 施耐德、松下光电
10mm 厚钢板机身，非常稳定

Machine Main parts

Single Servo Motor, Chinese brand 2kw
Main motor 1.5kw, Taiwan brand
Inverter Delta ,Unwinder Inverter
Temperature controller-Omron
Airtag Electric Valve fromTaiwan
Electrci parts---Schneider, Panasonic Photocell
10mm thickness steel as mahine body, very stable



主要技术参数

Main Technical Variables

型号 Model	MQ-DL600C	MQ-DL800C	MQ-DL1000C	MQ-DL1200C
封切宽度 Width of sealing &cutting(mm)	550*2 260*4	750*2 360*4	950*2 460*4	1150*2 560*4
封切长度 Length of sealing & cutting(mm)	1500	1500	1500	1500
制袋速度 Speed of bag-making (pc/min)	240-480	240-480	240-480	240-480
电机功率 Power of motor(kw)	1.5	1.5	1.5	2.2
重量 Weight(kg)	1000	1300	1500	1700
尺寸 Outline dimension(m)	4.8*1.4*1.9	4.8*1.4*1.9	4.8*1.6*1.9	4.8*1.8*1.9

用途 Usage



可制作超市背心购物袋
It can make t shirt bag for supermarket



可做用于垃圾袋的扁平袋
It can do flat bag, which is used as garbage bag

PLA 注塑生产线 PLA Injection molding production line

注塑机又名注射成型机或注射机。她是将热塑性塑料活热固性塑料利用塑料成型模具制成各种各样的塑料制品的主要机器。

Injection molding machine also known as injection molding machine or injection machine. She is the thermoplastic live thermosetting plastics using plastic molding mold into a variety of plastic products of the main machine.

工艺原理：PLA 料玉米淀粉料 → 单缸喷射装置 → 高刚性合膜装置 → 控制系统

Process principle: PLA material corn starch material → single cylinder injection device → high rigidity film device → control system



型号
Model

型号 Model	重量 Shot weight (g)	间距 Space between bars(mm)	型号 Model	重量 Shot weight (g)	间距 Space between bars(mm)	型号 Model	重量 Shot weight (g)	间距 Space between bars(mm)
MQ98	146	365*360	MQ300	913	610*585	MQ1080	5553	1160*1160
MQ118	196	380*380	MQ368	1243	685*685	MQ1400	7186	1350*1300
MQ140	217	420*420	MQ400	1512	745*705	MQ1680	7972	1555*1430
MQ158	289	430*430	MQ438	1788	765*765	MQ1850	9245	1655*1430
MQ168	361	467*467	MQ508	2018	805*715	MQ2400	12054	1800*1620
MQ178	411	485*465	MQ530	2263	820*800	MQ2600	23753	1860*1710
MQ218	518	510*510	MQ590	2437	845*830	MQ2800	40596	1900*1800
MQ238	642	530*530	MQ680	3164	915*915	MQ3400	50960	2160*1900
MQ256	710	585*565	MQ780	4018	985*985			

用途
Usage



PLA 注塑生产线被广泛应用于可降解的玩具、桌椅和文具等的生产。
PLA injection molding line is widely used in the production of biodegradable toys, tables, chairs and stationery.

PLA 流延膜生产线（设备交钥匙工程）

PLA casting film production line (equipment turnkey project)



本系类适用于生物降解塑料，生物降解塑料加淀粉等。包含单层、双层、多层共挤流延薄膜挤出生产线。整套设备由南京国塑挤出装备设计并研发，挤出系统采用计量泵进行闭环设计控制，可以有效的使薄膜成型稳定，厚薄均匀。多层共挤采用分配器进行分层。

This series is suitable for biodegradable plastic, biodegradable plastic add starch etc. It consists of a single layer, double layer, multi-layer co-extruded cast film extrusion line. The whole set of equipment is designed and developed by Nanjing GS-Mach Extrusion Equipment, and the extrusion systems uses a metering pump, closed-loop control can effectively stabilize the film formation and unifom thickness. Multi-layer squeeze with a distributor for statification.



特点 Features

螺杆采用渐变型单螺杆设计，专门针对聚乳酸，玉米淀粉熔融设计，同时针对材料的特殊性可开排气，挤出模具采用衣架式模具，结合静态混合器材料不易产生精点，成型台采用激冷流延设计具有分散性好，塑化均匀，机器加减速操作方便，便于调节，薄膜厚度采用 X 射线自动测厚仪完成反馈，并通过自动模头进行调节，整套设备的自动化设计非常之高，加上引膜装置，可以使生产更高效，更安全，收卷采用自动张力计算，松紧可调收卷平整。

the screw adopts the gradient type single screw design, which is specially designed for the polylactic acid and corn starch melting. At the same time, it can be opened and vented according to the speciality of the material. The extrusion die adopts a hanger mold and a static mixer. The material is not easy to produce fine spots, and the molding table adopts chilled casting design, which has good dispersion, uniform plasticization, convenient operation of machine acceleration and deceleration, easy adjustment. The thickness of the film measured by X-ray automatic thickness gauge and adjusted by automatic die. The automation design of the whole set is very high, plus the film loading. The production can make the production more efficient and safer, the automatic tension calculation is adopted for winding, and the elastic winding can be adjusted smoothly.



设备标准型号与定制

Equipment standard model with custom

设备型号 Equipment model	制品宽度 Product width (mm)	制品厚度 Product thickness (mm)	最大线速度 Maximum line speed (m/min)
1600/2000/2600	1100/1500/2100	0.02-0.1mm	60-200m

工艺原理

Process principle

PLA 玉米淀粉原料除湿干燥 → 单螺杆挤出机：原料熔融塑化 → 快换过滤网 → 计量泵 → 衣架式模具 → 流言成型台 → 纵向拉伸机 → 冷却定型装置 → 切边回收机构 → 电晕装置 → 牵引输送 → 张力反馈 → 收卷装置

PLA corn starch raw material dehumidifying and drying of plastic pellets → Single screw extruder: Raw material melting and plasticizing → quick change filter → metering pump → hanger mold → casting molding station → longitudinal stretching machine → cooling setting device → trimming recovery mechanism → corona device → Traction transport → Tension feedback → Winding device

产品用途：主要用于包装，印刷，电子包装膜等。

Products application: mainly used for packaging, printing, electronic packing film.



可生物降解 PLA 淋膜机

Biodegradable PLA Laminating Machine

机器主要部件：挤压式主机SJ-90*32，单板单工位过滤器，溶体静态混合器，1600mm型淋膜专用型模具，螺杆上料装置，料斗型干燥机，淋膜复合成型系统，模具上方抽油烟装置，X射线自动测厚仪，A双工位放卷系统，纠偏装置，胚布静电消除装置，LED照明观测装置，边料风送装置，牵引机，双工位自动卷绕系统，SIEMENS人机界面控制系统

Machine Main parts : SJ Extruder , Single board single station filter , Solution static mixer , Laminating Special Mould , Screw feeding device , Hopper dryer , Laminating composite molding system , Extruder top hood , X automatic measure thickness device , double station unwinding system , correction device , Fabric static elimination device , LED lighting observation device , Edge air conveying device , Tractor , Double station automatic winding system , SIEMENS human-machine interface control system





型号
Model

设备型号 Equipment model	制品宽度 Product width (mm)	制品厚度 Product thickness (mm)	最大线速度 Maximum line speed (m/min)
1600/2000/2600	1100/1500/2100	0.02-0.1mm	60-150m



工艺原理：将塑料熔融后通过高温熔融态挤出与纸张，牛皮纸，无纺布，铝箔，衬布系列进行高速淋膜复合从而达到理想的抗拉强度，致密性，阻隔性以及提高材料的防潮性。

Process Principle:Melts the PLA material and then passes through high-temperature molten state extrusion laminating with paper, kraft paper,non-woven fabric,aluminum foil and interlining series, thereby achieving the desired tensile strength,compactness, barrier properties, and improving the moisture resistance of the material.

产品用途：主要用于纸张类，防潮类，一次性衣物类。

Products application:Mainly used for paper ,moisture-proof, disposable clothing etc.



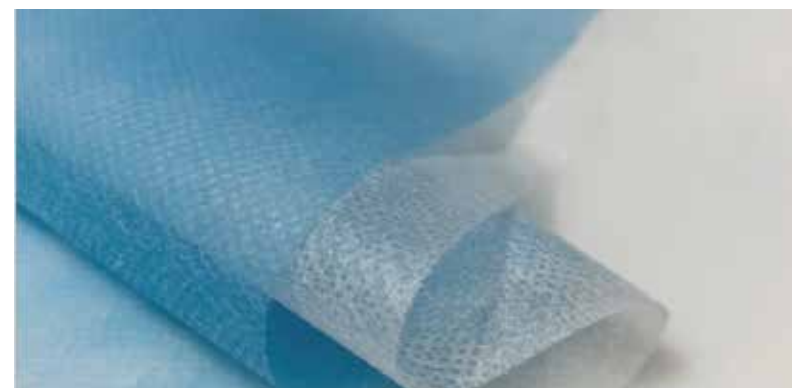
特点
Features

设备采用一放一收设计，放卷采用双工位自动接换卷，磁粉张力设计，恒张力控制，生产加减速速度可以同比率控制，边料破碎在线回收，生产浪费少，速度可以达到 50m/min, 100m/min, 150m/min, 三种设计。

The equipment adopts a one by one design, the unwinding adopts exchange volume, magnetic powder tension design, constant tension control, and the production acceleration and deceleration speed can be synchronized, Ratio control , edge material crushing online recycling, less production waste, speed can reach 50m/min, 100m/min, 150m/min , three designs .



用途 Usage



可生物降解 PLA 淋膜机主要用于纸张类，防潮类，一次性衣物类。

Biodegradable PLA Laminating Machine is mainly used for paper, moistureproof, disposable clothing.

PVA 水溶性制粒机 PVA Water Soluble Granules Making Machine

PVA 水溶性制粒机主要适用于用水溶性可生物降解木薯粉与可生物降解树脂的配方材料造粒，以获得最终的可生物降解产品，如购物袋、包装袋、薄膜、餐具、筷子、食品容器等。

最终产品在与水接触时会完全溶解并且是可生物降解的。它们不会在环境中持续存在，不会污染回收流或导致微塑料污染。这就是为什么许多领先的消费产品和零售公司对水溶性薄膜帮助他们减少环境足迹的潜力感到兴奋。

PVA Water Soluble Granules Making Machine is mainly used for granulating water soluble biodegradable tapioca with formula material that makes biodegradable resin in order to get final biodegradable products like shopping bags, packaging bags, films, dishes, chopsticks, food containers and so on.

The final products will dissolve completely upon contact with water and are biodegradable. They do not persist in the environment, contaminate the recycling stream or contribute to micro-plastic pollution. This is why many leading consumer product and retail companies are excited about the potential of water soluble films for helping them reduce their environmental footprint.





型号

Model

型号 Model	MQ-35	MQ-50	MQ-65	MQ-75	MQ-95
主电机 Main Motor	18KW	55KW	90KW	132KW	250KW
螺杆直径 Screw Diameter	30.5mm	50.5mm	62.4mm	71mm	93mm
产能 Capacity	30-50kg/h	100-200kg/h	200-300kg/h	300-500kg/h	500-800kg/h
切粒功率 Cutter Power	3KW	4KW	5.5KW	7.5KW	11KW
螺纹元件 Screw Element	W6MO5CR4V2	W6MO5CR4V2	W6MO5CR4V2	W6MO5CR4V2	W6MO5CR4V2



应用

Application

手提袋	Carrying Bag
可溶性洗衣袋	Soluble Laundry Bag
服装袋	Garment Bag
可冲散的宠物粪便垃圾袋	Flushable Pet Poop Waste Bag
农药化学袋	Pesticide Chemical Bag
建筑纤维袋	Construction Fiber Bag
彩色颜料包装袋。	Color Pigment Package Bag
种子包装膜	Seed Package Film
包装膜	Packaging Film
盘子	Plates
筷子	Chopsticks

机器组成

Machine Composition

1. 高速混合机 → 2. 传送带喂料机 → 3. 双螺杆挤出机 → 4. 真空系统 → 5. 风冷输送带 → 6. 切粒机 → 7. 振动筛 → 8. 料仓 → 9. 电柜 → 10.PLC 触摸屏

1.High Speed Mixer → 2.Conveyor Belt Feeder → 3.Twin Screw Extruder → 4.Vacuum System → 5.Fan Cooling Conveyor Belt → 6.Pelletizer → 7.Vibra-
tion Sieve → 8.Silo → 9.Electrical Cabinet → 10.PLC Touch Screen

客户案例

Client Case

之前美国客户购买了一台我们的 GS75B 双螺杆挤出机配风冷输送带切粒线，主要用于生产 PVA 水溶性塑料袋。我们为客户提供我们的机器的同时，也提供了详细的 PVA 水溶配方。

American customer before has bought one set of our GS75B Twin Screw Extruder with Air Fan Cooling Pelletizing Line, to mainly produced PVA water soluble plastic bags. We provide customer the detailed PVA water-soluble formula together with our machinery.