

LSP-1200PE Pipe line

Available pipe size: 630~1200mm

Machine Size: 58000 x 3300x 3300mm

Liansu
Liansu

Under Assembly

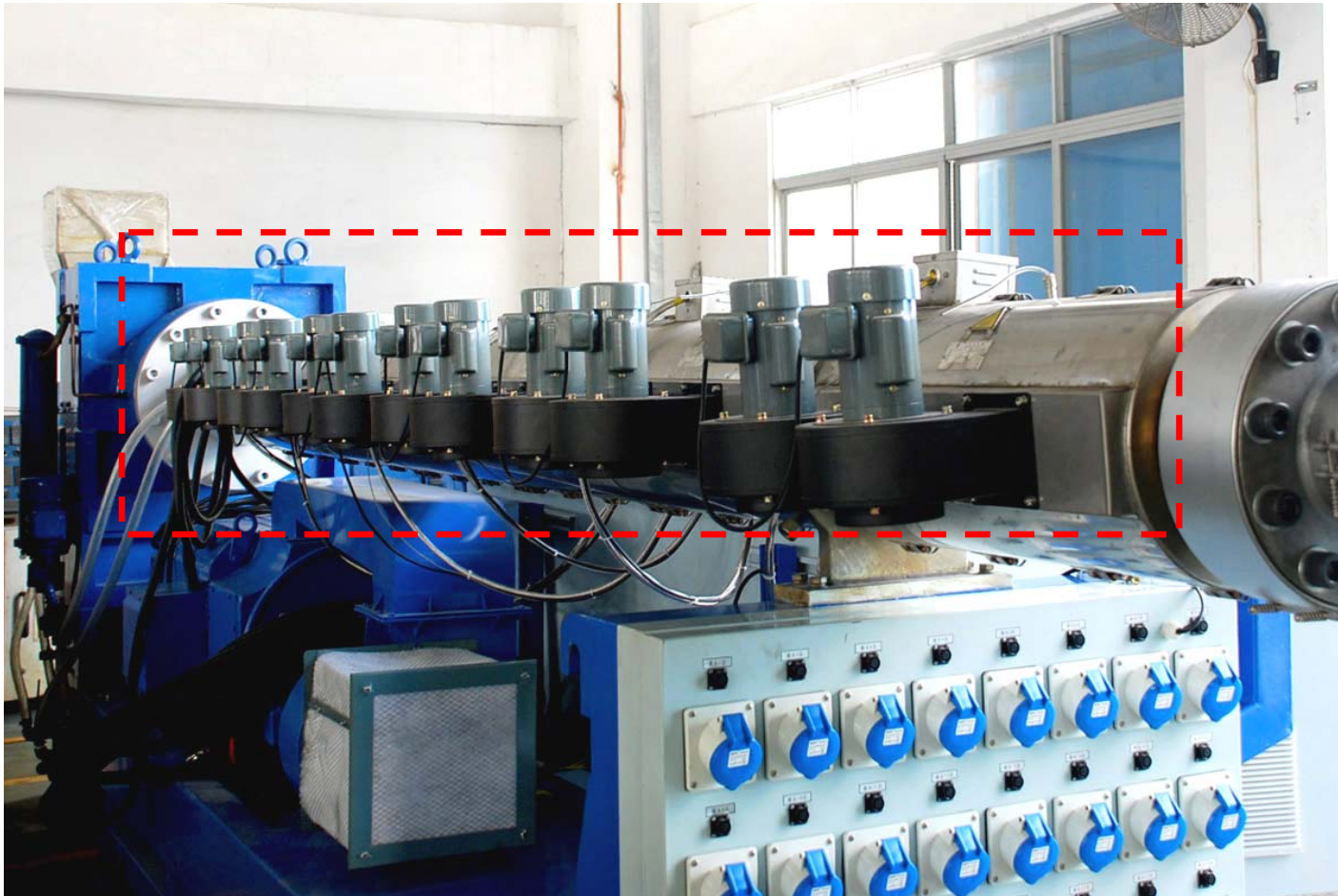


Under Assembly



Under Commissioning for 1200mm pipe





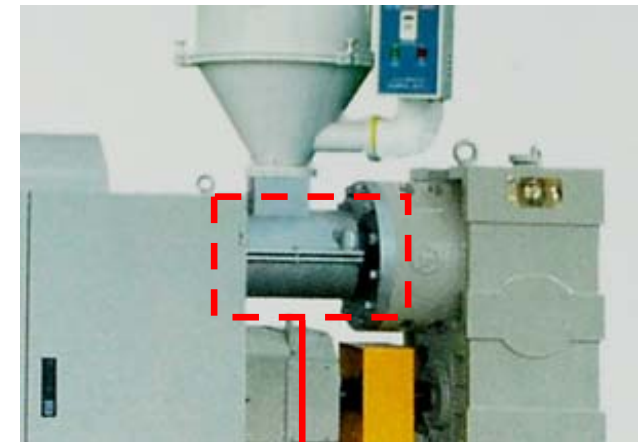
As for the extruder LSS-150-34, we have 6 heating zones with **6 heaters** and **12 electric fans** to control the temperature for barrel and screw.

Our Chinese competitor usually has 6 heating zones with 5 heaters and 5 electric fans only, which can reduce the cost a lot but not good for plastizing or precise temperature control.



As for the material of feeding block, Liansu uses 30CrMoAl, which is the same material as screw and barrel. And it is one piece structure.

Our competitor usually use Q235 steel or other material which is much cheaper but the stiffness is worse.



Some competitor use 2 pieces structure for easier production, but may come with leakage problem.



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LSS-150-34 EXTRUDER

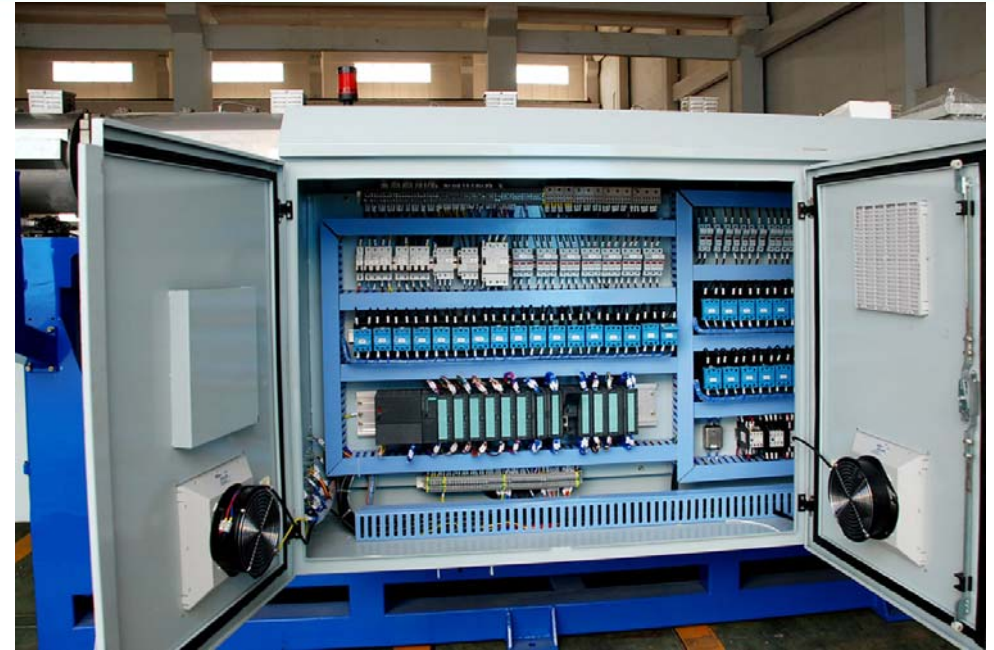


LiANSU's extruder has multiple heating plugs to control the extrusion die.



As for Simens HMC-II computer control, Liansu is using the best one as **300 series**, with **MP 277**, 10 inch key color operation panel.

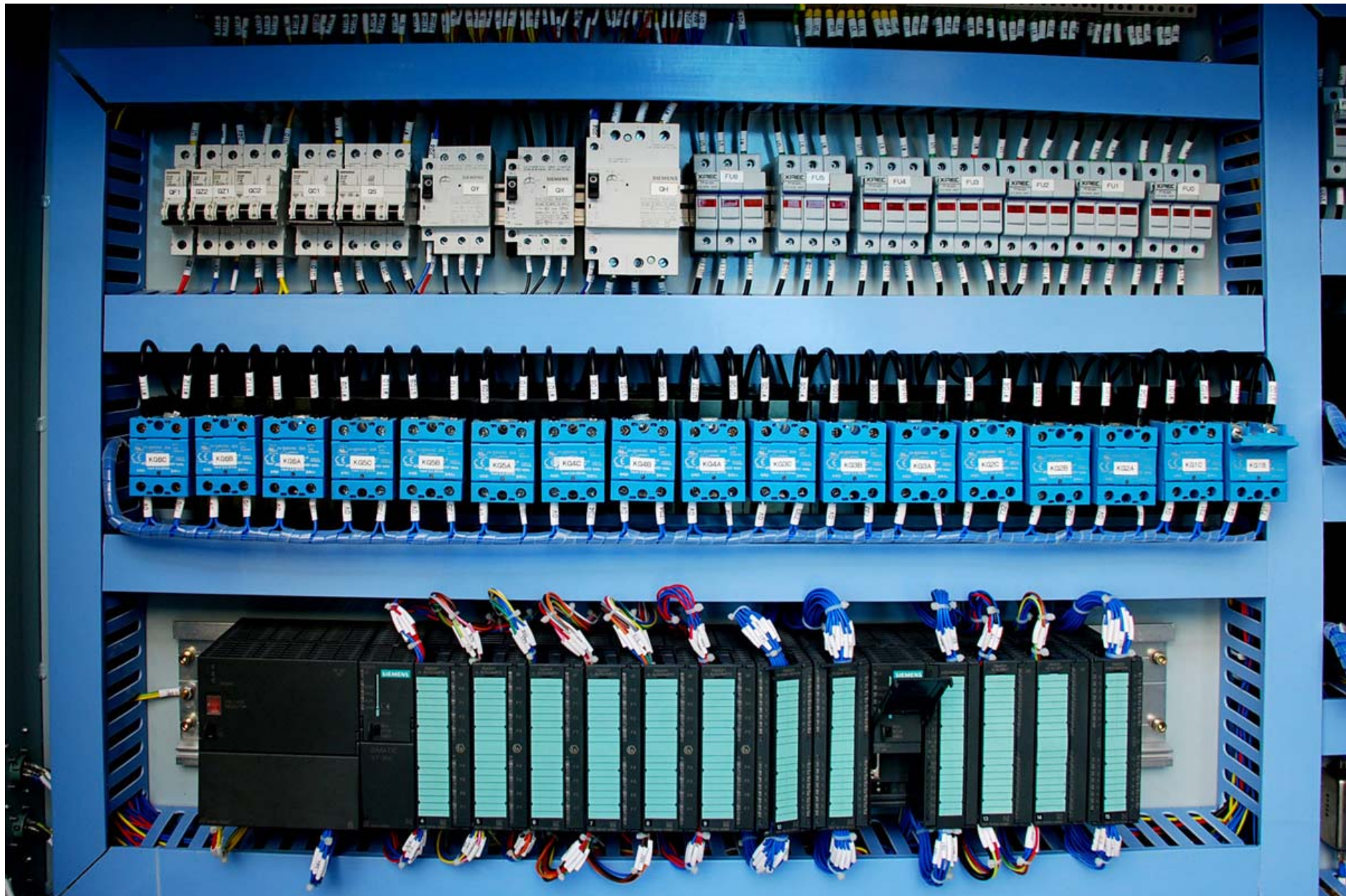
While our competitors usually don't show Simens' item number on specification. They usually use 200 series, sometimes even with smaller screen, which is almost half cost but with less function and lower speed.

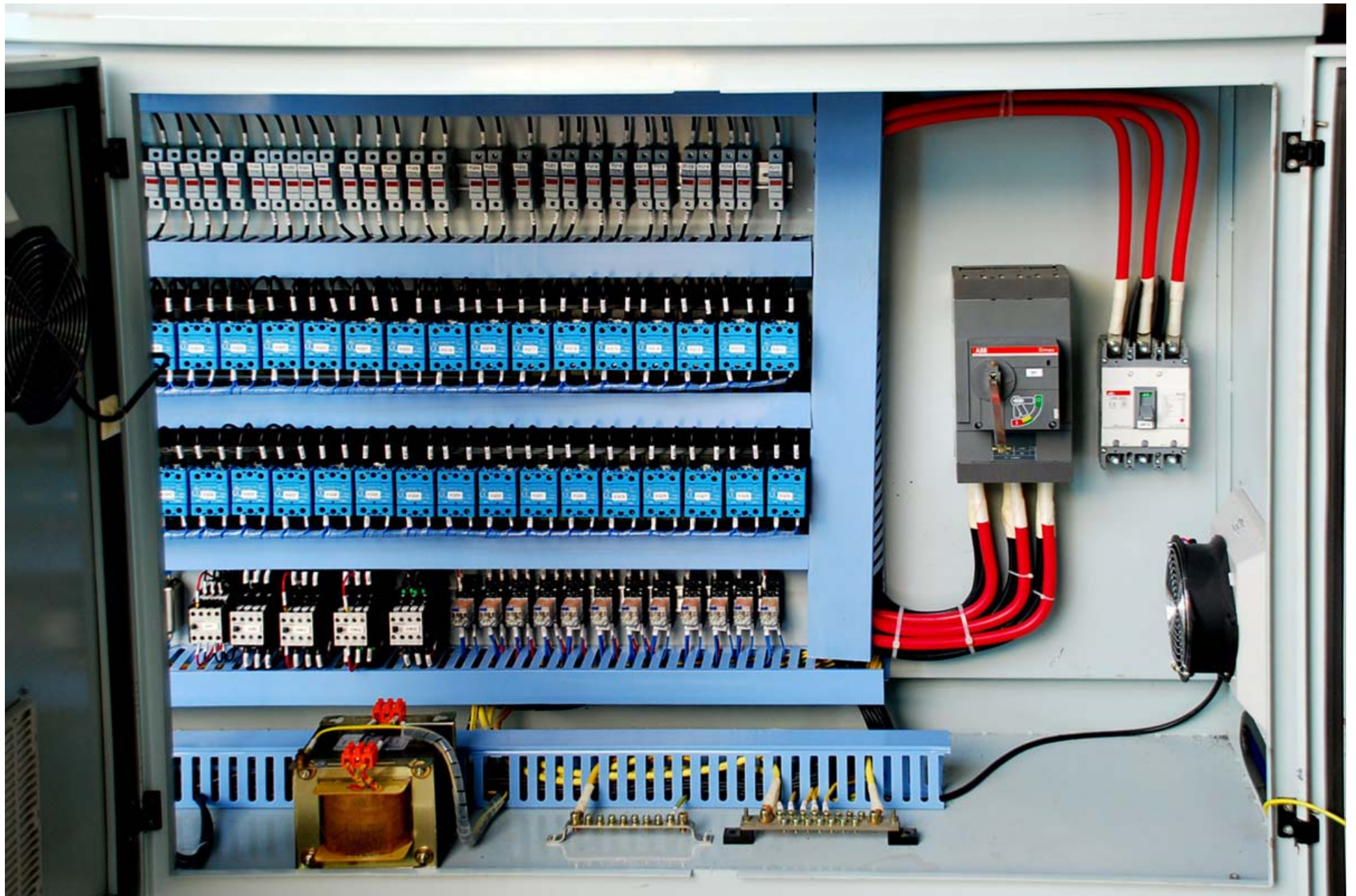


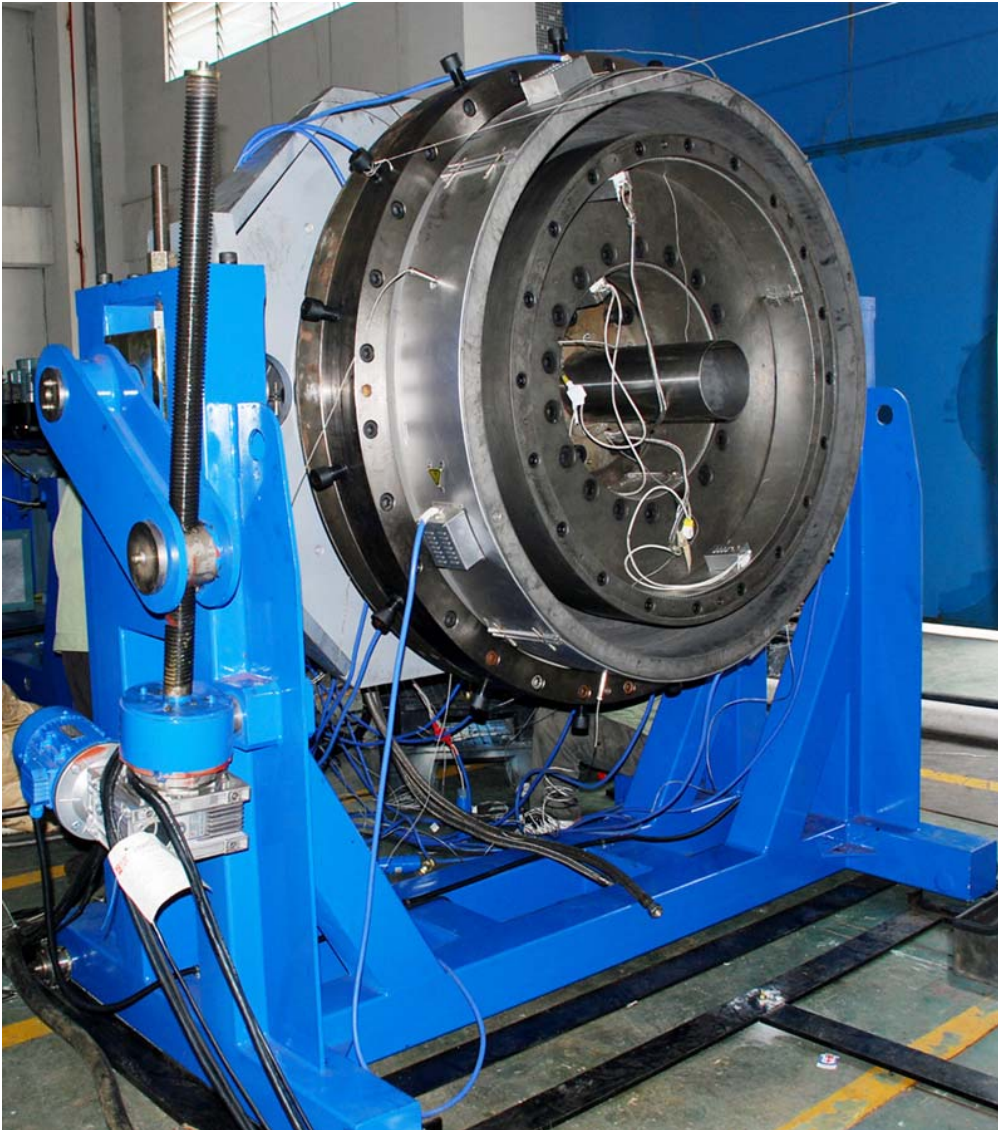
For electric parts in the electric cabinet,

- *Inverter of main motor : [ABB-DSC400](#)
- *Thermoregulation meter: [RKC/Omron](#)
- *Transducer of feeding motor: [ABB-350](#)
- *Contactor: [Siemens](#)
- *Breaker: [Siemens](#)
- *Solid state relay: [CELDUC](#) ,France

While our supplier uses magnetic conductor instead of solid state relay in order to save the cost. And they usually does not show the structure or the item number for electric parts.

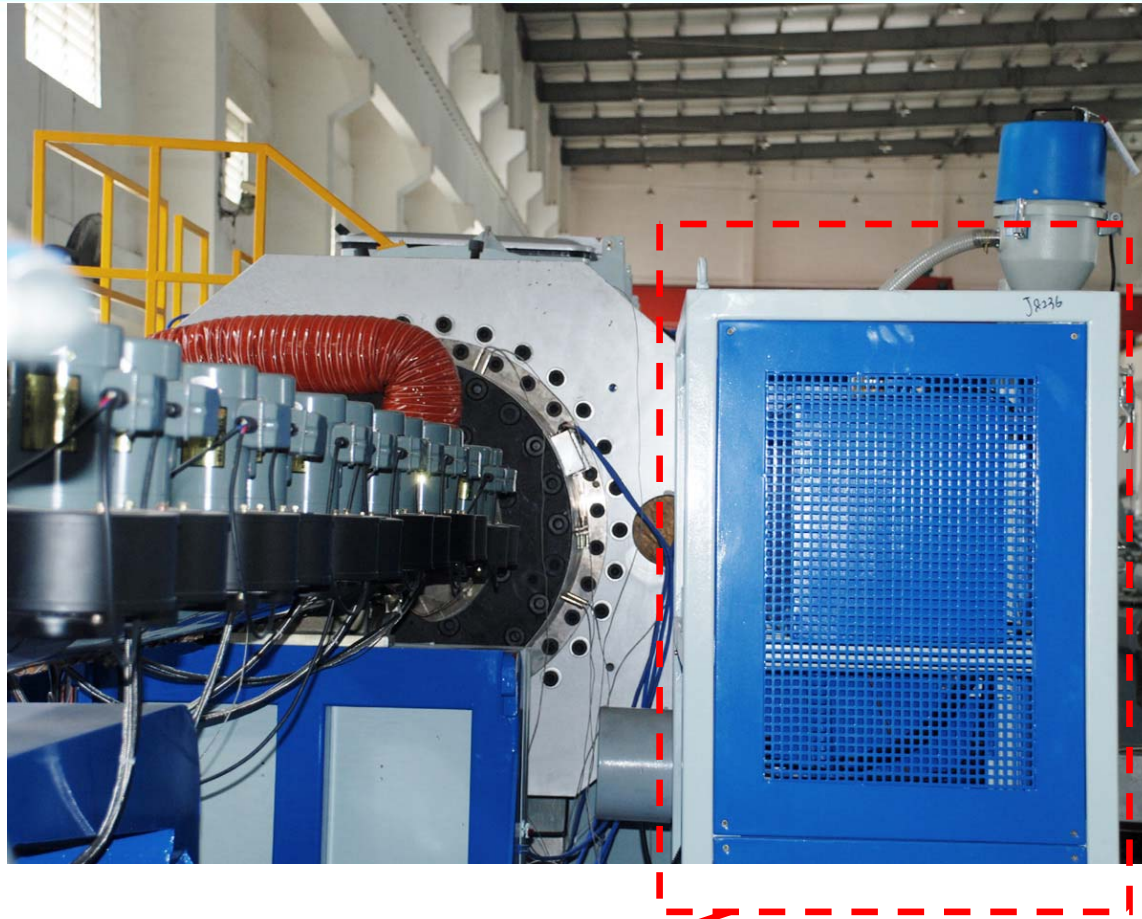






For extrusion die, we are using 40Cr material.

While our competitor usually use cheaper material but the stiffness is worse.



LIANSU uses [oil cycling system](#) to control the temperature of the extrusion die.

While our Chinese competitor usually use water to control the temperature to save cost, but it is not good for precise temperature control and the life of die will be shorter .



LIANSU 1200PE pipe line has 2 vacuum tanks(2+8 meter) and 3 water tanks(6+6+6 meter).

Wall thickness for vacuum tank is 8mm. And wall thickness for water tank is 4mm. Tank body is made by stainless steel.

While our competitor's tank will be much lighter and weaker than ours.



Two vacuum tank

The first one is 2 meter, and the second one is 8 meter.

Totally 10 meter.

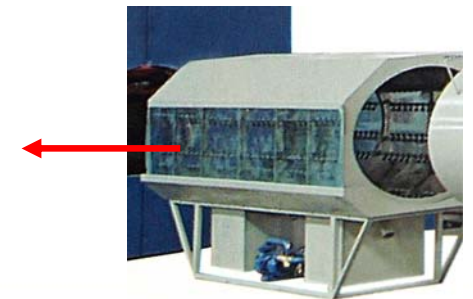


Three water tank

Each water tank is 6 meter.

Totally 18 meter.

Some Chinese competitors use PVC sheet to cover the body of water tank to save cost, but this structure is very weak and not durable.





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VACUUM & WATER TANKS





Under Assembly

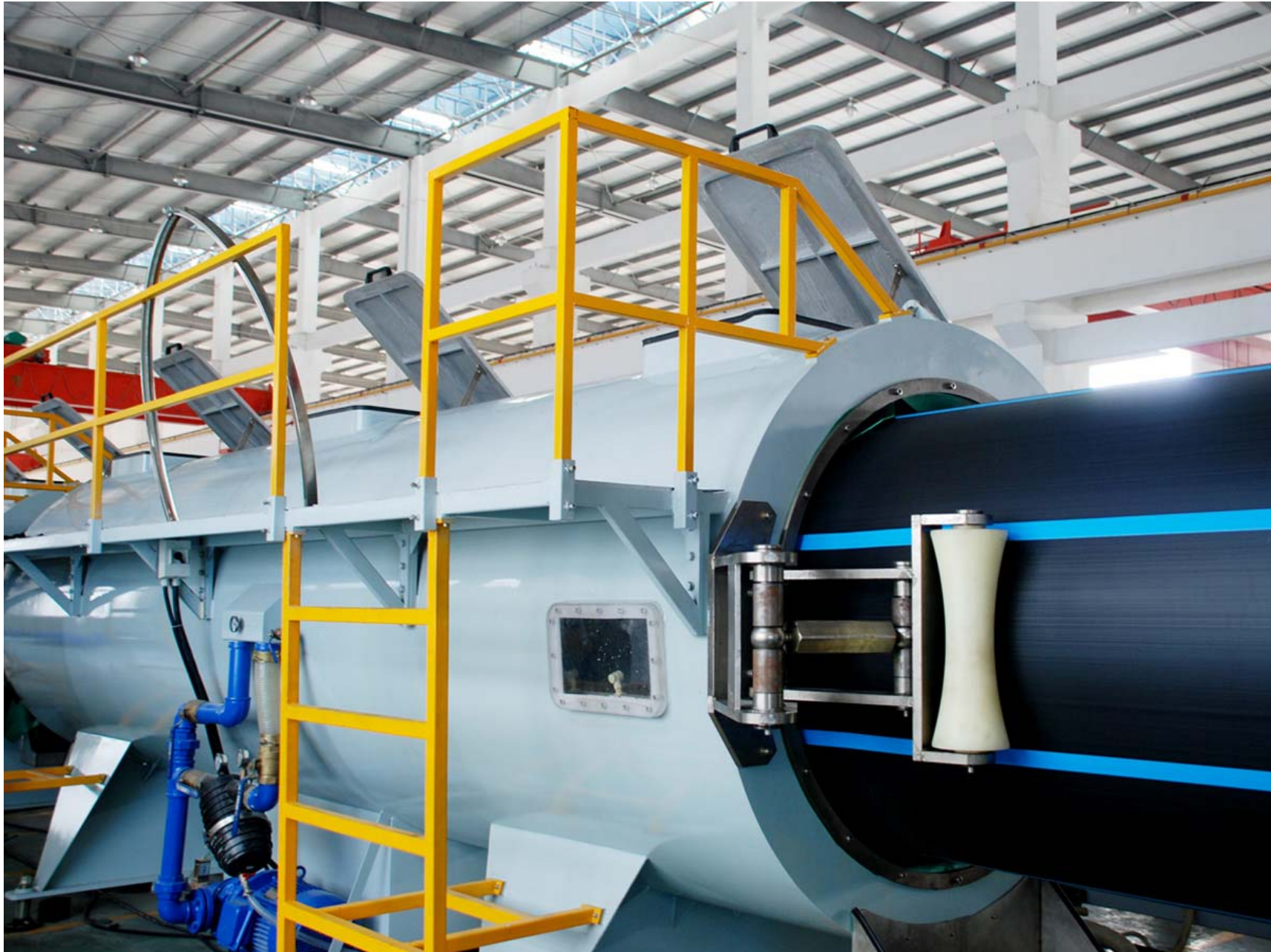


The 2 meter vacuum tank with calibrator under commissioning.

During Commissioning



During Commissioning





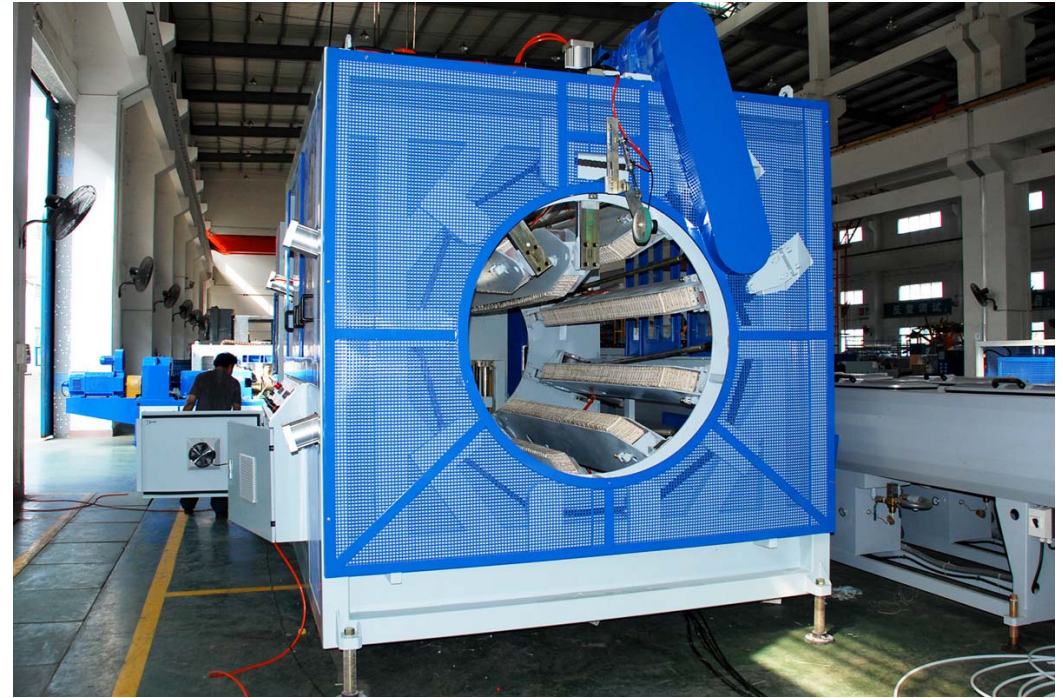
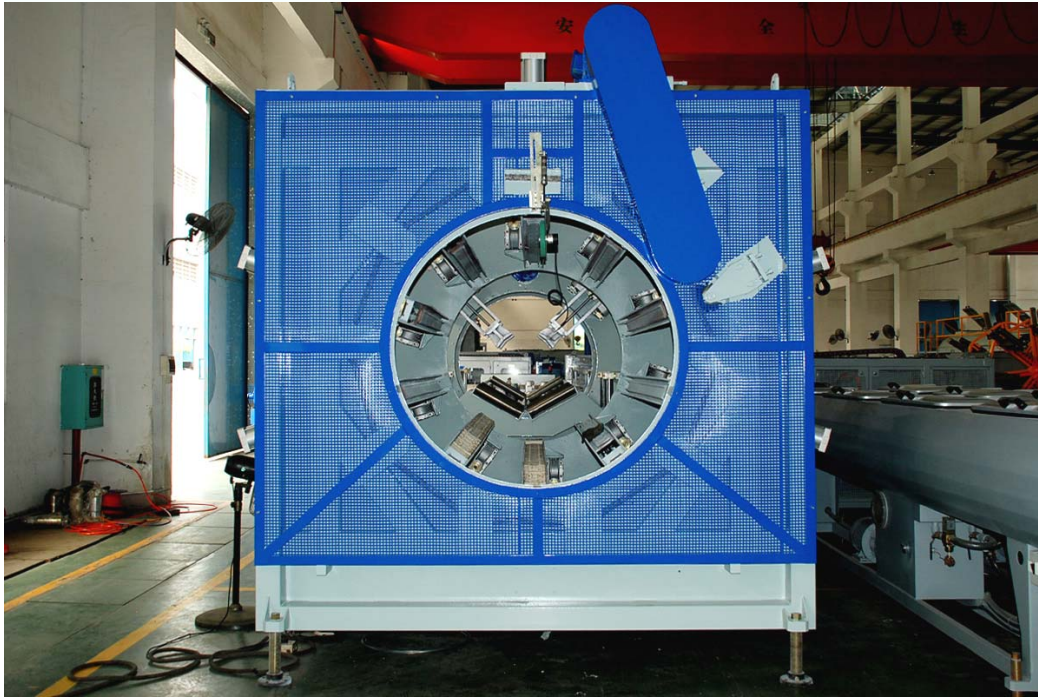
For spray nozzles,

Liansu has **1560** nozzles for 2 vacuum tanks

and **1920** nozzles for 3 water tanks.

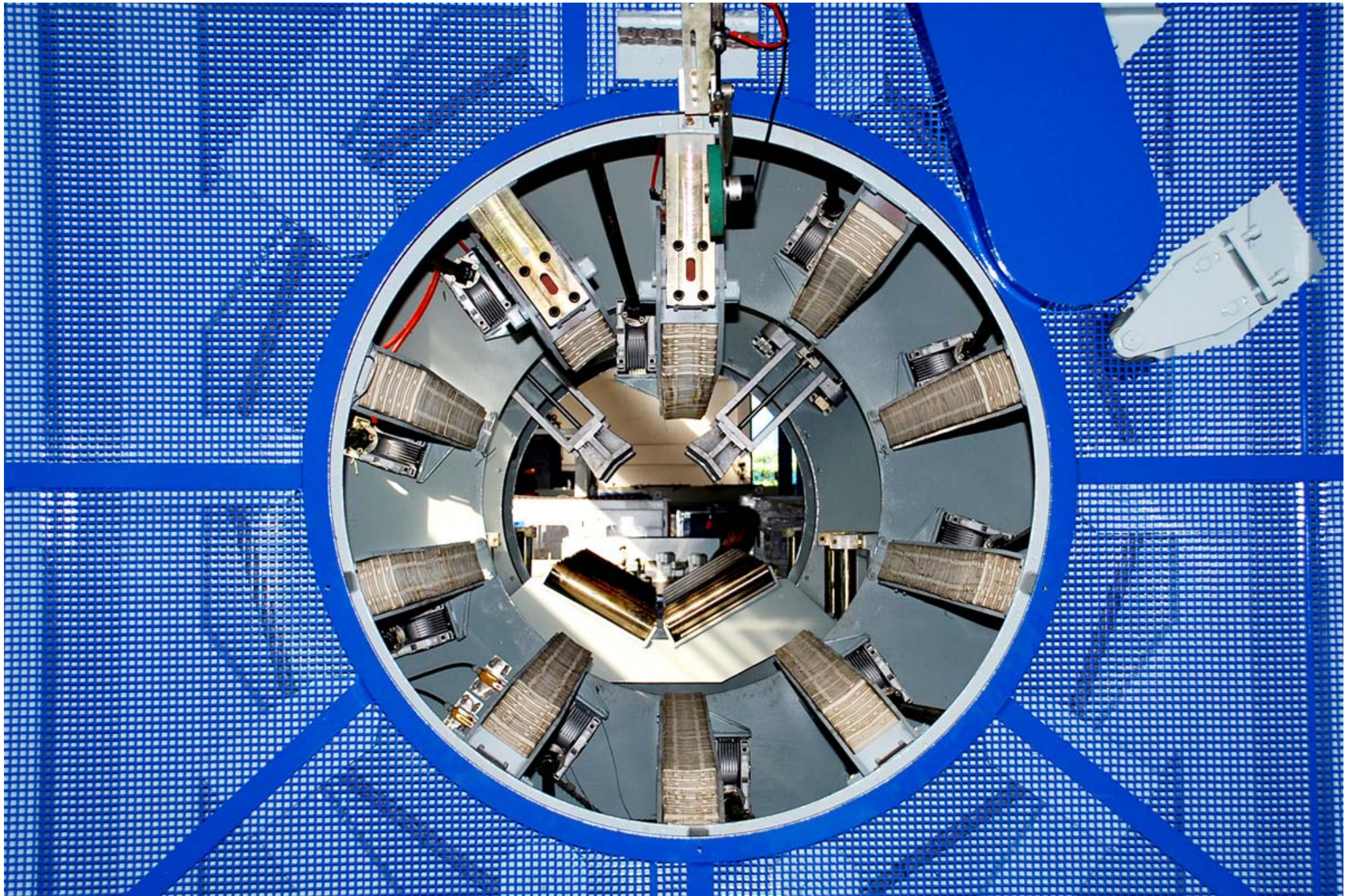
Our competitor has much less nozzles to save cost but not good for cooling.





Liansu's 1200PE pipe line is using **10 tracks** with totally **976pcs** rubber blocks.

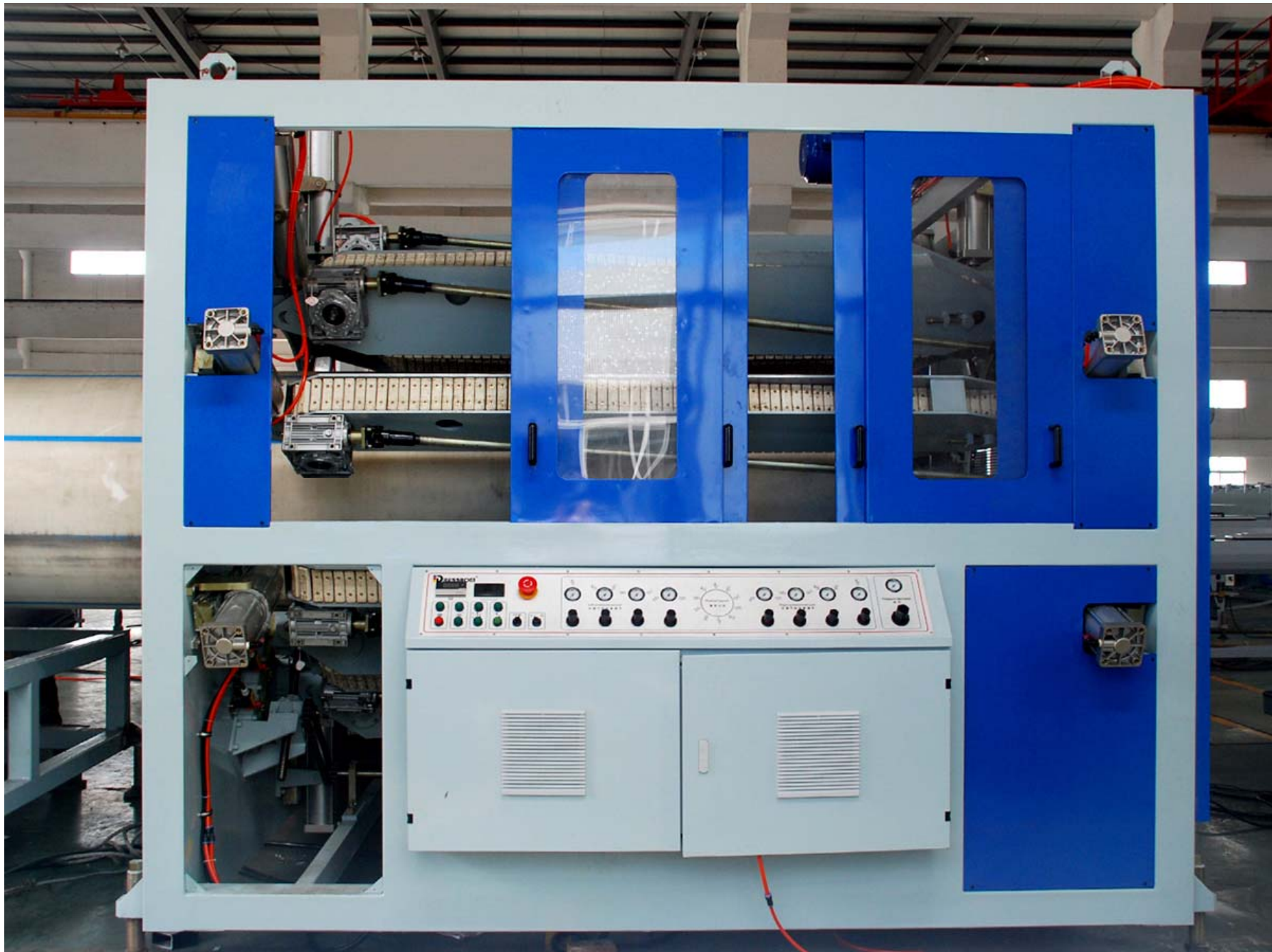
Our competitor may use 8 tracks. Even with 10 tracks, their rubber blocks are less than ours.





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TEN TRACK HAUL OFF UNIT



During Commissioning



During Commissioning







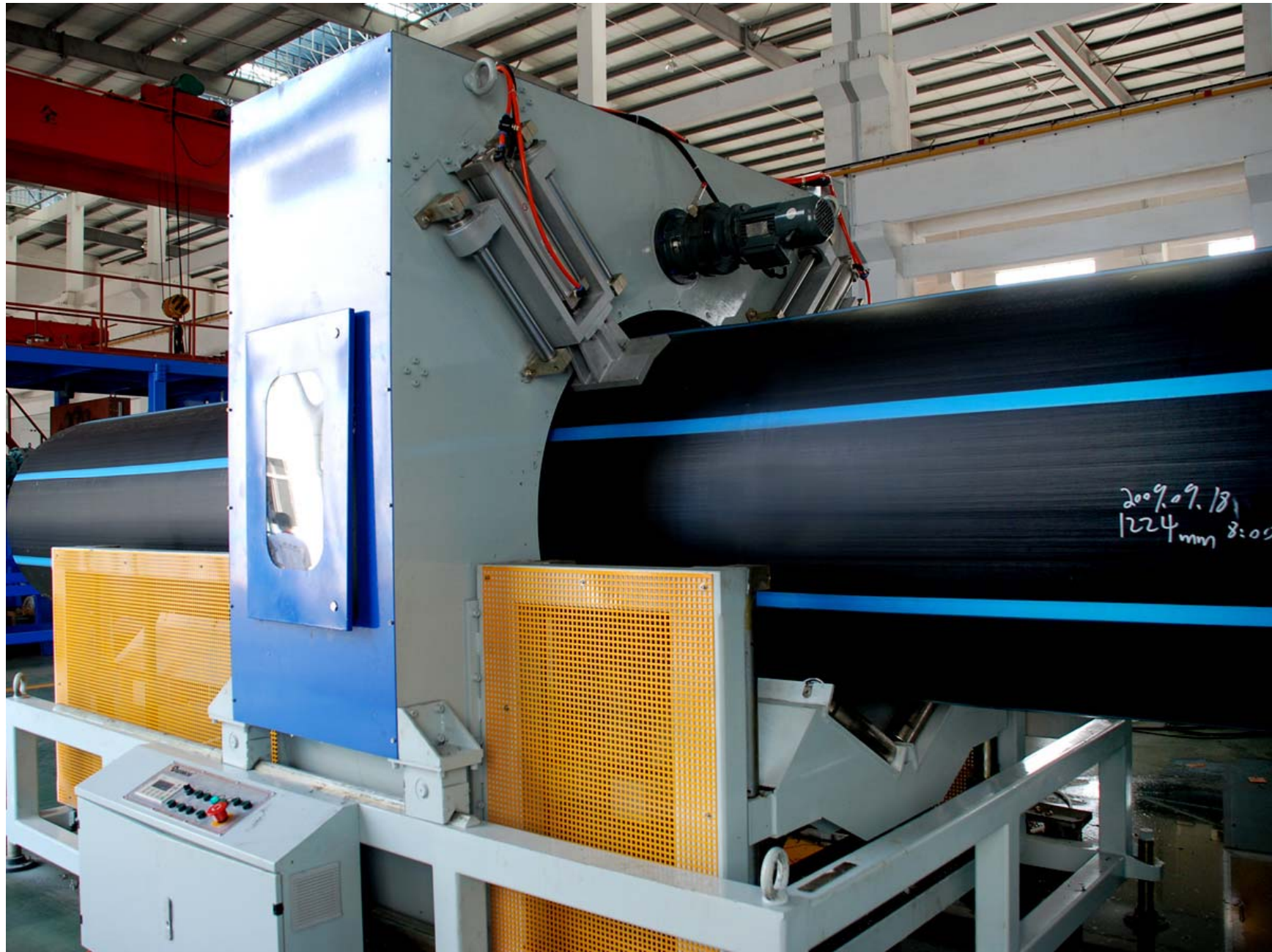
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PLANET CUTTING UNIT



- Planet cutting unit with strong frame and structure.
 - Clamping method: pneumatic
 - Movement of work table:
Synchronized movement with hauling unit, pneumatic reset
 - Saw movement: driven by oil cylinder
 - Length counting by encoder
(supplier: ELCO, Italy)
 - Cutting precision: $\pm 5\text{mm}$
 - Allowable maximum noise: less than 80(db)
 - Dust suction method: air suction:
MF9011B, 1kW , 2- \varnothing 200 dust suction hole
 - Air valve supplier: SMC, Japan

During Commissioning



During Commissioning





For piling unit, Liansu has strong frames and structures, and also bigger pneumatic cylinder, the material cost is usually double than our Chinese competitors.



Max output of main extruder -- 1.3 TON/hour

Max line speed for pipe size OD1224mm -- 80mm/minute (Tested on Sep 18th,2009)

As for actually production capacity, Liansu's pipe line production capacity is usually 20~30% higher than other Chinese competitors.

For other information of the machine, please refer to the machine specification.

Look forward to a Win-win business

