



Longkou Haiyuan Plastic Machinery Co.,Ltd
龙口市海元塑料机械有限公司

Ellie's WeChat /WhatsApp : 008613780912769

E-mail : manager@ythaiyuan.com

全自动发泡快餐盒生产线 Fully automatic foam food container production line (详见第 2-7 页) (Page 2-7)	PS 发泡片材机 PS foam sheet extrusion machine	
	全自动成型机 Fully automatic forming machine	单工位 Single worktable style
		双工位 Double worktables style
		吸水 Absorbent style
回收造粒机 recycling machine		
半自动发泡快餐盒生产线 semiautomatic foam food container production line (详见第 8-14 页) (Page 8-14)	PS 发泡片材机 PS foam sheet extrusion machine	
	半自动成型机 Semiautomatic forming machine	
	冲裁机 Cutting machine	
	回收造粒机 Recycling machine	



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全自动产线： 片材机+成型机+回收造粒机（详见第 2-7 页）

Fully automatic production line : （Page 2-7）

sheet machine + fully automatic forming machine + recycling machine

1. **PS 发泡片材机组**是采用国际上最常用的冈田式双级串联高发泡片材生产设备，本设备以通用级聚苯乙烯原料在挤出过程中高压注入发泡剂，经模头挤出后，发泡、冷却、定型、牵引后，收卷成 PS 成品片材，该片材经真空吸塑成型后，可制成各种包装容器：一次性快餐盒、水产盘、超市盘等系列产品，广泛用于食品、水果、广告宣传、工业产品包装等。本机具有结构先进、性能稳定、操作简便、自动化程高等优点。

PS foam sheet extrusion machine adopts Gentian type double-stage series high foam technology. The raw material is general polystyrene granule. In the extruding process, vesicant is injected at high pressure. After extruding, foaming cooling, shaping and hauling off, it is winding to finished PS foam sheet rolls .After vacuum forming system, the finished PS foaming sheet can be made into variety of packaging vessels such as fast food box, aquatic plate, supermarket tray, cake tray ,KT board, instant noodle bowl, foam tray etc. It is widely used in the packing of food, fruit advertising ,industrial products and so on. This equipment adopts high speed non-stop hydraulic filter changer and PLC controller.



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Sheet machine HS code : 8477209000

片材机型号 **PS foam sheet extrusion machine Model**

参数 Parameter	Unit	HY-75/90	HY-105/120	HY-110/130	HY-135/150
生产能力 Capacity	kgs/h	80-100	200-240	230-260	280-360
片材厚度 Sheet thickness	mm	1--4	1--4	1.5--5	2--5
制品宽度 Sheet width	mm	640-1080	640-1080	800-1080	900-1080
发泡倍率 Foaming rate	10--22				
冷却方式 Cooling method	风冷&水冷 wind&water cooling				
剖切方式 Cutting method	单剖 single cutting/双剖 double cutting				
丁烷气压力 Butagas pressure	Mpa	0.9-1.2			
装机容量 Installation power	kw	160	200	260	320
安装尺寸 Installation Dimension	m	24x6x3	30x6x3	32x6x3	35x8x3
电源电压 Power supply	/	三相 380V 50HZ/220V60Hz/meet customer need 3 Phase 380V 50HZ /220V60HZ/ meet customer need			



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2.全自动真空成型机是一种集成型和剪裁一体的新型热成型机组，它集真空型，跟踪剪裁为一身，可加工几乎所有的热成型塑料片材，机组采用全电脑数字成型系统，PLC 机电一体化全自动控制，触摸屏控制各种动作程序，操作方便、节约材料、生产效率高。具有可靠的稳定性、成型面积大、裁切方便易操作、成形速度快、自动化程度高，节约人工等特点。

Fully Automatic Vacuum Forming Machine have three kinds :

A: Single worktable normal fully automatic forming machine

B: Double worktables normal fully automatic forming machine

C: Single or double worktables Absorbent tray fully automatic forming machine

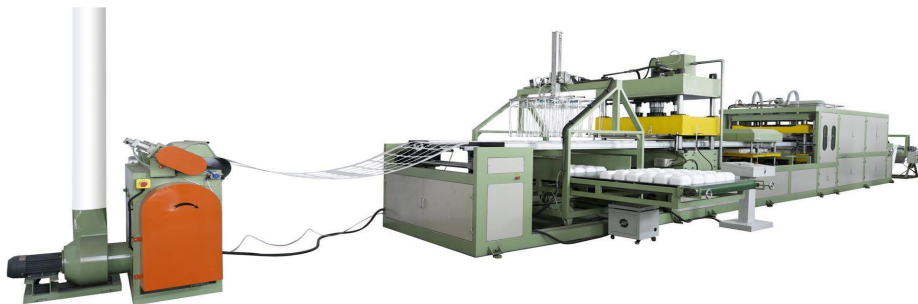
It integrates forming ,cutting off and stacking at the same time. It is vacuum forming as well as press forming and synthetic forming.It can be used for processing all kinds of plastic sheet. It adopts PLC controller and touch screen to control the working program. It is easy to operate and features high degree of automation.



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Forming Machine HS code : 8477409000

Mold HS code : 8480790090

参数 Parameter	Unit	全自动成型机型号 fully automatic forming machine Model		
		HY-1100x1100	HY-1100x1250	HY-1100x1400
成型面积 Forming area	mm ²	1100×1100	1100x1250	1100x1400
冲裁高度 Cutting height	mm	160	160	160
生产效率 Production efficiency	Die/ S	3-4		
安装尺寸 Installation dimension	m	19x6x3	21x6x3	24x6x3
装机容量 Installation power	kw	150 Actual: 75	160 Actual: 80	180 Actual: 90
电源电压 Power supply	三相 380V 50HZ /三相 220V 60HZ/根据客户需求 3 Phase 380V 50HZ/3Phase 220V 60HZ/meet customer need			



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3.回收造粒机主要用于高发泡聚苯乙烯及高发泡聚乙烯制品的再回收造粒，是废料回收的理想设备。本机结构紧凑，操作简便，高发泡塑料经过粉碎可直接进行再生造粒，是目前节能降耗最理想的机型。

Recycling Machine

This machine is mainly used to recycle the high foam polystyrene and high foam polyethylene products. It is the ideal equipment to recycle the waste materials. This equipment features compact structure and easy operation. The high foam plastic can be directly used to make granulation without comminuting. At present ,it is the ideal energy-saving equipment.



Crusher HS code : 8479820090 ; recycling machine HS code:8477201000

参数 Parameter	回收造粒机型号 recycling machine Model
Parameter	HY-125
螺杆直径 Screw diameter	125mm
装机容量 Installation power	30kw
安装尺寸 Dimension	8x3x2m
重量 Weight	1.5t
电源电压 Power supply	三相 380V 50HZ/三相 220V 60HZ/根据客户需求 3 Phase380V50HZ/220V60HZ/meet customer need



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半自动产线：片材机+半自动成型机+冲裁机+回收造粒机（详见第 8-14 页）

Semiautomatic production line : (Page 8-14)

sheet machine +semiautomatic forming machine + cutting machine +recycling machine

1.PS 发泡片材机组是采用国际上最常用的冈田式双级串联高发泡片材生产设备，本设备以通用级聚苯乙烯原料在挤出过程中高压注入发泡剂，经模头挤出后，发泡、冷却、定型、牵引后，收卷成 PS 成品片材，该片材经真空吸塑成型后，可制成各种包装容器：一次性快餐盒、水产盘、超市盘等系列产品，广泛用于食品、水果、广告宣传、工业产品包装等。本机具有结构先进、性能稳定、操作简便、自动化程高等优点。

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Sheet machine HS code : 8477209000

片材机型号 **PS foam sheet extrusion machine Model**

参数 Parameter	Unit	HY-75/90	HY-105/120	HY-110/130	HY-135/150
生产能力 Capacity	kgs/h	80-100	200-240	230-260	280-360
片材厚度 Sheet thickness	mm	1--4	1--4	1.5--5	2--5
制品宽度 Sheet width	mm	640-1080	640-1080	800-1080	900-1080
发泡倍率 Foaming rate	10--22				
冷却方式 Cooling method	风冷&水冷 wind&water cooling				
剖切方式 Cutting method	单剖 single cutting/双剖 double cutting				
丁烷气压力 Butagas pressure	Mpa	0.9-1.2			
装机容量 Installation power	kw	160	200	260	320
安装尺寸 Installation Dimension	m	24x6x3	30x6x3	32x6x3	35x8x3
电源电压 Power supply	/	三相 380V 50HZ/220V60Hz/meet customer need 3 Phase 380V 50HZ /220V60HZ/ meet customer need			



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2.半自动 PS 快餐盒真空成型机是一种全能型热成型机组，它集真空成型、模压成型及综合成型为一身，可加工几乎所有的热成型塑料片材，机组采用全电脑数字控制系统，PLC 机电一体化全自动控制，触摸屏控制各种动作程序，操作方便、节约材料、生产效率。具有可靠的稳定性、成型面积大、易操作、成型速度快、自动化程度高等特点。

Semiautomatic Vacuum Forming Machine:

PS fast food box vacuum forming machine is an all-powerful thermal forming machine with integration of vacuum forming Press forming and synthetical forming. It can be used for processing many kinds of plastic sheet. The machine adopts digital system, fully automatic PLC mechanical and electronic integration control, touch screen to control the working programme .It is easy to operate and of high efficiency. It features reliable stability, large forming area, fast speed ,highly automation and economic on manpower.



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Forming Machine HS code : 8477409000

Mold HS code : 8480790090

半自动成型机型号 Semiautomatic forming machine Model				
参数 Parameter	Unit	HY-640/900		HY-1100/1250
成型面积 Forming area	mm	640x900		1100x1250
成型深度 Forming depth	mm	100		
生产效率 Production efficiency	S/Die	3--4		
加热面积 Heating area	mm	750x1700		1200x2800
装机容量 Installation power	kw	90		130
安装尺寸 Installation Dimension	m	14x5x3		16x5x3
调温点 Adjusting temperature points	Point	34		64
电源电压 Power supply	三相 380V 50HZ/三相 220V 60HZ/根据客户需求 3 Phase380V50HZ/ 3Phase220V60HZ/meet customer need			



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3.双工位液压冲裁机是目前国际广为流传的一种剪切设备，主要用于真空成型制品的一次性整模高效冲剪，也可用于包装、装饰品、EPE 深加工等制品的冲剪，采用日本三菱 PLC 机电一体化控制，可作单、双工位冲剪，具有更换模具简单、技术准确、冲剪速度快、应用广泛等优点。

Double Worktables Hydraulic Cutting Machine:

The machine is the most popular cutting off machine all over the world ,It is mainly used to cut the vacuum forming products (one time dishes)as well as packing ,decoration, EPE deep processing products .It adopts the Mitsubishi brand PLC mechanical and electronic integration. Owing to its features of easily changing mould, counting accurately, cutting off quickly, it is widely used in many fields.



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Cutting machine HS code : 8477800000

冲裁机型号 cutting machine Model			
参数 Parameter	Unit	HY-750/950x2	HY-1100/1350x2
冲裁面积 Cutting off area	mm	750x950	1100x1350
冲裁高度 Cutting off height	mm	150	
冲裁速度 Cutting speed	S/Die	3--8	
装机功率 Installation power	kw	7.5	15
冷却水压力 Cooling water pressure	Mpa	0.2	
安装尺寸 Installation dimension	m	6x5x3	8x5x3
冲裁压力 Cutting pressure	T	60	120
电源电压 Power supply	三相 380V 50HZ/三相 220V 60HZ/根据客户需求 3 Phase 380V 50HZ/220V 60HZ/meet customer need		



4.回收造粒机主要用于高发泡聚苯乙烯及高发泡聚乙烯制品的再回收造粒，是废料回收的理想设备。本机结构紧凑，操作简便，高发泡塑料经过粉碎可直接进行再生造粒，是目前节能降耗最理想的机型。

Recycling Machine is mainly used to recycle the high foam polystyrene and high foam polyethylene products. It is the ideal equipment to recycle the waste materials. This equipment features compact structure and easy operation. The high foam plastic can be directly used to make granulation without comminuting. At present ,it is the ideal energy-saving equipment.



Crusher HS code : 8479820090 ; recycling machine HS code:8477201000

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Parameter	HY-125
螺杆直径 Screw dimeter	125mm
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安装尺寸 Dimension	8x3x2m
重量 Weight	1.5t
电源电压 Power supply	三相 380V 50HZ/三相 220V 60HZ/根据客户需求 3 Phase380V50HZ/220V60HZ/meet customer need