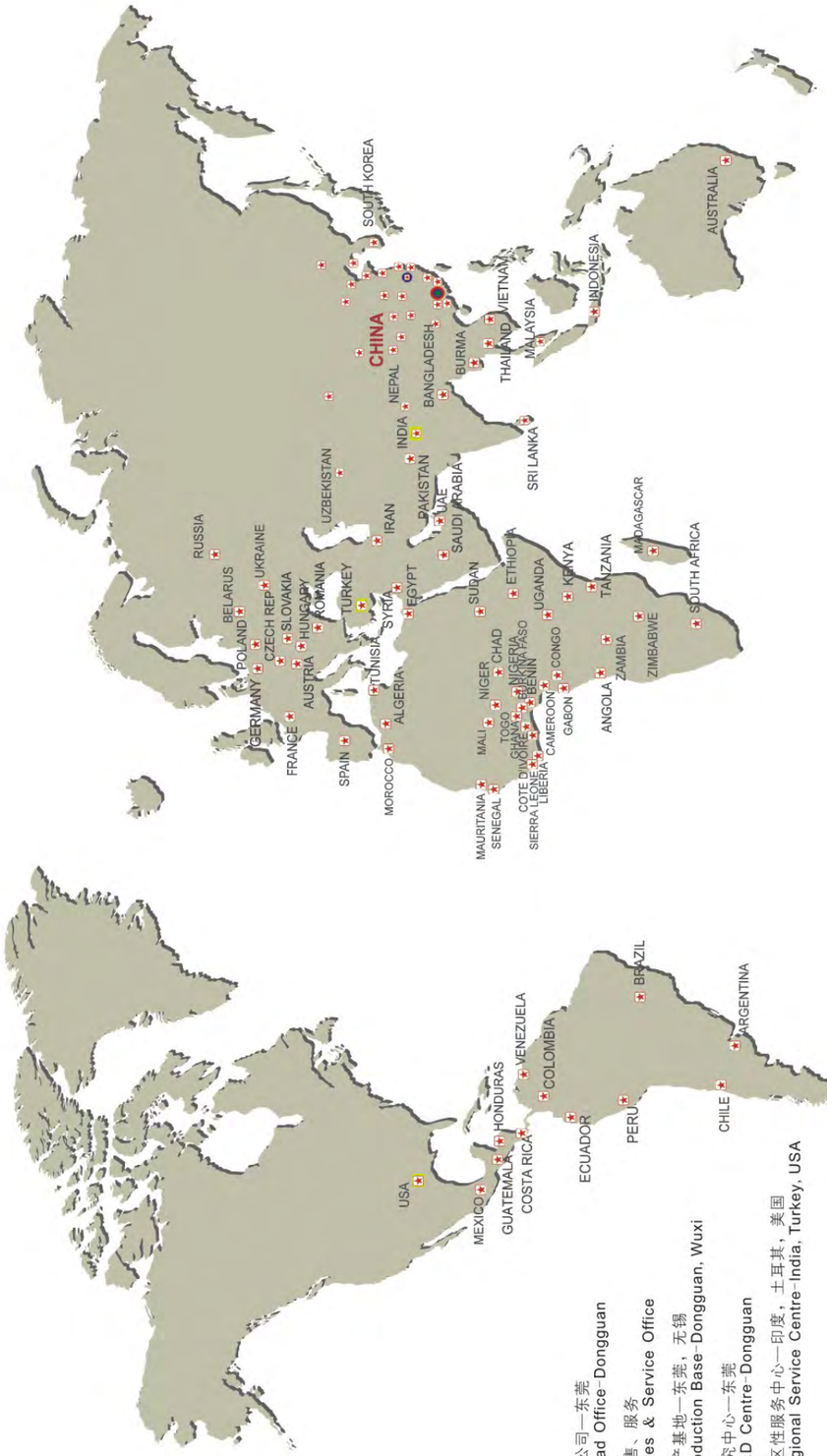

- 总公司—东莞 Head Office–Dongguan
- 销售、服务 Sales & Service Office
- 生产基地—东莞，无锡 Production Base–Dongguan, Wuxi
- 研究中心—东莞 R&D Centre–Dongguan
- 地区性服务中心—印度，土耳其，美国 Regional Service Centre–India, Turkey, USA

DEKUMA

德科摩橡塑科技(东莞)有限公司

DEKUMA RUBBER AND PLASTIC TECHNOLOGY(DONGGUAN)LTD.

(大同机械有限公司成员 Member of Cosmos Machinery Ltd.)

中国广东省东莞市东城区周屋工业区银珠路 523118

Yinzhu Road, Zhouwu Industrial Park, Dongcheng District,

Dongguan, Guangdong Province, China P.C.: 523118

Tel：+86-769-22667200

Fax：+86-769-22667227

Web: www.dekuma.com

E-mail: info@dekuma.com

*Version No.:DKM-E201105

DEKUMA

管材挤出生产线 EXTRUSION LINES

德科摩橡塑科技(东莞)有限公司

DEKUMA RUBBER AND PLASTIC TECHNOLOGY(DONGGUAN)LTD.

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DEKUMA

DKM高效塑料管材挤出生产线

▸公司简介

德科摩是国际知名的橡塑科技方案供货商，德科摩为顾客提供整套挤出技术、橡胶技术的交钥匙方案。

德科摩产品秉承欧洲标准，主要部件如挤出单元、螺杆、模具均由德国工程师主导设计，且所有原材料的选用及加工流程都严格遵循德国标准，从而使德科摩挤出机、模具及其下游设备均具极高的性价比和可靠性。

德科摩以卓越的技术及专业的服务，为客户创造最大价值，并矢志成为世界橡塑设备的领先品牌。

• Corporate Profile

DEKUMA is a well-known international solution provider of rubber and plastic technologies. DEKUMA provides total solution for customers, including extrusion technology, rubber technology.

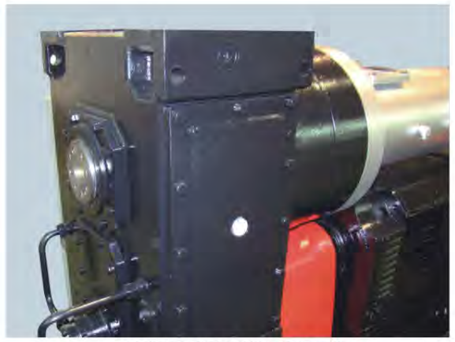
Products from DEKUMA possess the characteristics of European standard. The design of main components like extrusion unit, screws, moulds are leaded by German engineers, and all material sourcing and manufacturing processes are strictly controlled under the Germany procedures and quality standard. Thus DEKUMA Extrusion lines, Moulds and Down Stream equipments are world recognized as high cost-effective, high reliability.

By specialized team and professional service, DEKUMA helps customers to maximize their value and vows to be the worldwide leading brand of rubber and plastic technologies.

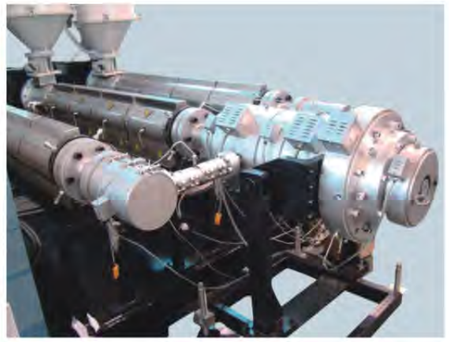
DEKUMA
高速、高效、耐用
High speed, high efficiency, high reliability

机器特点 Machine Characteristics

德科摩公司所有DKM单螺杆挤出机均采用最新德国DEKUMA挤出技术科技以保证让它们具有杰出的加工性能，我们对每一个部件都力求完美以使整机性能更加卓越，DKM单螺杆挤出机螺杆有：45、70、80、100、120及150六种标准直径和30D及33D两种有效长度。所有机型均采用先进的B&R–PCC或SIEMENS模块化控制系统，以实现对整条线的自动化控制和实时数据记录。它们都具有产量高、原料适应性广、能持续稳定地生产出高质量产品等一系列优点。



水冷强制加料和高强度传动系统
Power feeding techrology and high tension transmission system



The extrusion line from Dekuma adopts the latest German technology which guarantees the superior machine performance. Dekuma strives for the perfection of each single component to optimize the machine. DKM single screw extruder provides six different screw diameter: Φ45mm, 70mm, 80mm, 100mm, 120mm, 150mm, and the L/D ratio 30D and 33D. The advanced B&R–PCC or SIEMENS modular control system realizes the real time data recording function, the automatic control and the wide range of material application and high output.

机器特点 Machine Characteristics

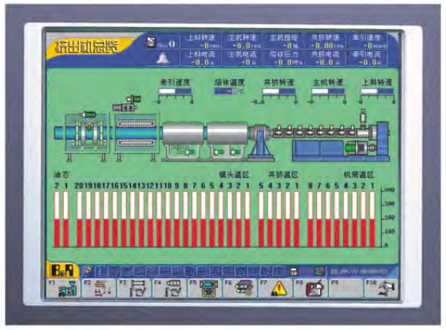
- 先进的PCC 电脑控制系统实现对整条线的自动控制
- 优化设计的屏障式螺杆适应多种原料和制品
- 性能卓越的温控系统确保不同转速下都有稳定的产量
- 与螺杆结构相匹配的强制喂料沟槽套筒设计确保生产均匀稳定
- 强劲的动力传动系统，经久耐用且保证了稳定的挤出量和优异的产品质量
- 高性能共挤机既可以单独控制，也可以与主机联动控制

- Advanced PCC control system realizes the automatic control of the whole line.
- The optimum barrier screw is applicable for a wide range of raw materials and articles.
- The precise temperature control system ensures the constant and stable output under different speeds.
- The specially designed groove feeding barrel suits the screw structure and ensures the steady and reliable production.
- The powerful and durable dynamic driving guarantees stable extrusion volume and superior article quality.
- The high-performance co-extruder could either be controlled independently or tandem drive controlled with the main extruder.

空气强力冷却和精确的温控系统
Air Power Cooling and Precise Temperature Control Device

- 低磨损螺杆设计
- 高物料熔融度
- 平缓的熔融过程
- 均匀的熔融物料
- 较低的能量消耗
- 较低的熔体温度
- 预混料制品色度均匀，效果优异

- Low wearing screw design
- High material melting performance
- Steady and smooth melting process
- Homogenous melts
- Low energy consumption
- Low plasticizing temperature
- Pre–mixed material with uniform color and excellent performance.



单螺杆挤出机技术参数 Technical Data of Single Screw Extruder

型 号		DKM-EI45/30A	DKM-EI60/33A	DKM-EI70/33(36A)	DKM-EI80/33(36A)	DKM-EI100/33(36A)	DKM-EI120/33(36A)	DKM-EII50/33A		Extruder type
驱动										**Drive**
额定驱动功率	kW	45	75	90(132)	110(160)	200(250)	315(355)	450	kW	Nominal drive capacity
最大驱动速度	1/min	1500	1500	1500	1500	1500	1500	1500	rpm	Max. Nominal driving speed
螺杆										**Screw**
螺杆直径	mm	45	60	70	80	100	120	150	mm	Screw diameter
长径比	L/D	30	33	33(36)	33(36)	33(36)	33(36)	33	L/D	Effective screw length
最大螺杆转速	1/min	300	220	180	160	132	120	95	rpm	Max.screw speed
机筒										**Barrel**
加热／冷却段数		4	4	4	4	5	6	6		No.of heating/cooling zones
机筒加热功率	kW	10	12	18	21.2	28	38	42	kW	Barrel heating capacity
连接体加热功率	kW	1.7	1.75	1.75	1.8	2.1	2.8	4	kW	Adapter heating capacity
产量										**Output rate**
HDPE／MDPE	kg/h	175-200	280	360(450)	480(600)	750(900)	1100(1350)	1500	kg/h	HDPE/MDPE – granulate
LDPE	kg/h	160	260	280	420	650	-	1000	kg/h	LDPE – granulate
PP	kg/h	140	220	260	420	580	750	1250	kg/h	PP – granulate
PB	kg/h	70	100	100	120	215	-	-	kg/h	PB – granulate
PS／ABS	kg/h	125	150	200	250	380	-	-	kg/h	PS/ABS – granulate
PE-RT	kg/h	180	260	320	420	700	1000	-	kg/h	PE-RT-granulate

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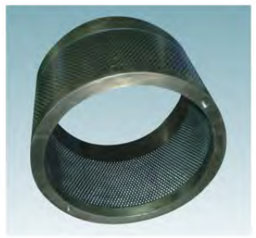
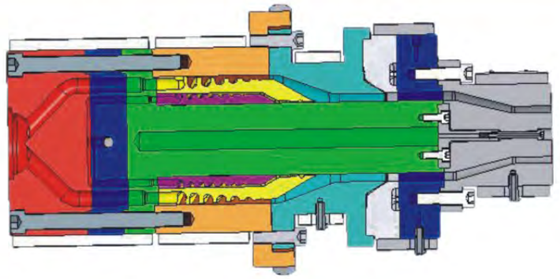
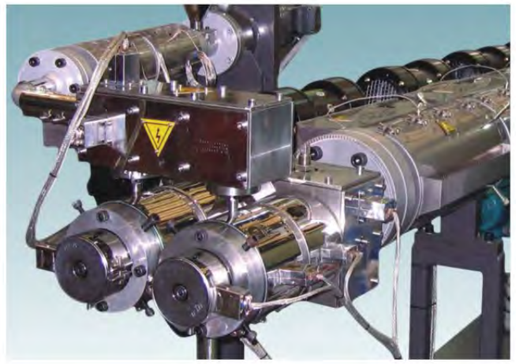
DKM 挤出模头 DKM Extrusion Die Head





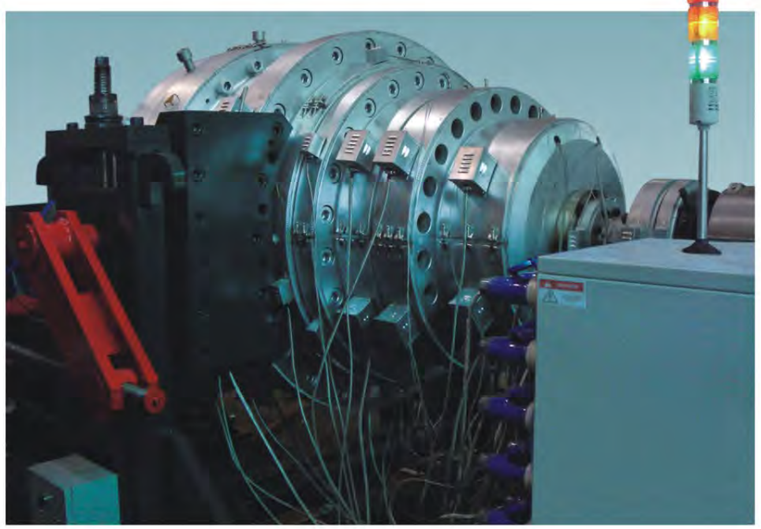


- 不受物料粘度变化的影响适应于HDPE/MDPE、PERT、PP/PP-R、PPR-FIBER、PB、PS/ABS及HMW-PE管材生产，并有极稳定的加工特性。
- 极低的压力损耗和低熔融体温度下的高挤出量
- 较低的熔体压力和熔体温度使管材内应力降至最低。
- 大容量的顺畅流道确保管材内应力降至最低
- 高品质陶瓷加热器使用寿命长
- 管材内外表面光滑无划痕

- Regardless of material viscosity variation, widely applicable for HDPE/MDPE, PERT, PP/PP-R, PPR-FIBER, PB, PS/ABS and HMW-PE pipe production, with reliable processing property.
- High output but rather low pressure drop and melt temperature.
- Small pipe stress due to the low melting pressure and temperature.
- Capacious and smooth runner reduces the pipe stress to the minimum.
- High quality ceramic heater with longer service life.
- Pipe with scratch-free smooth surface finishing.

专为DKM系列单螺杆挤出机开发的DKM篮式模头和篮式螺旋复合模头与DKM高速真空定型装置配套使用，您能在保证极高产量的同时，获得完美的产品质量，生产最大管径Φ1600mm。

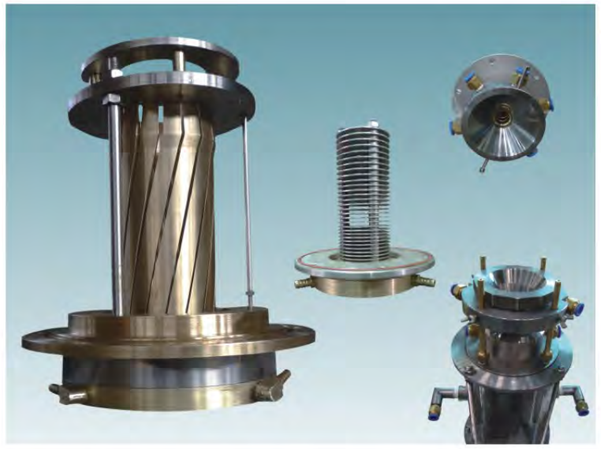
The specially designed DKM basket die head and sprial die head for the DKM series single screw extruder, fits well with the DKM high speed vacuum calibrator and guarantees the high output with excellent article quality. The max producible pipe diameter is Φ1600mm.



真空定径机 Vacuum Calibrator

- 优化设计的真空定径箱及水路系统均采用不锈钢制作
- 双回路供水系统配备独立的过滤元件预防堵塞喷嘴
- 快速真空控制系统确保真空度稳定
- 高效喷雾冷却，真空下快速均匀冷却定型
- 水温、水位自动控制
- 根据制品要求提供一室和两室真空定径机

- Optimum stainless steel vacuum calibrator and pipe works.
- Dual water cycle system with independent filter prevents the nozzle from being blocked.
- Quick response vacuum control system guarantees the reliable vacuum state.
- High efficiency spray cooling guarantees the quick shaping under vacuum condition.
- Automatic water temperature and level control.
- Single chamber and/or double chamber vacuum calibrator are available according to the article requirement.



真空定径机参数 Technical Data of Vacuum Calibrator

型号	Type		DKM-EDJ63	DKM-EDJ125	DKM-EDJ250	DKM-EDJ315	DKM-EDJ450	DKM-EDJ630	DKM-EDJ800	DKM-EDJ1200	DKM-EDJ1600
管径范围	Pipe Diameter	mm	Φ10-Φ63	Φ20-Φ125	Φ50-Φ250	Φ75-Φ315	Φ160-Φ450	Φ250-Φ630	Φ280-Φ800	Φ500-Φ1200	Φ710-Φ1600
水泵	Water Pump	kW	7.5	2X5.5	2X5.5	5.5+7.5	5.5+7.5	2X7.5	3X7.5	2X7.5+4X5.5	2X7.5+4X5.5
真空泵	Vacuum Pump	kW	3.0	4.0	2X3.0	2X3.0	3.0+4.0	2X4.0	3X4.0	2X5.0+4X4.0	2X5.0+4X4.0
真空箱长度	Vacuum Chamber Length	mm	9000 / 6000	9000 / 6000	9000 / 6000	9000 / 6000	9000 / 6000	12000 / 6000	12000 / 6000	12000 / 6000	12000 / 6000

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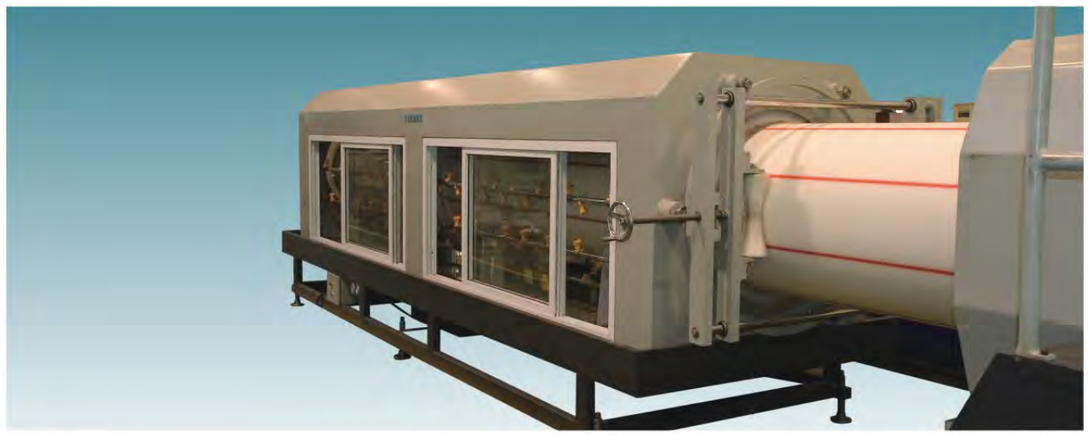
喷淋冷却箱 Spray Cooling Tank

喷淋冷却箱
Cooling Tank-Type Ⅰ

- 喷淋冷却箱（槽）及管路系统均采用不锈钢制作
- 优化设计的带过滤装置的双回路管道和优化分布的喷雾型喷嘴使管材快速均匀冷却
- 水温、水位自动控制
- 根据用户要求，可提供全不锈钢喷淋冷却箱和可视化不锈钢喷淋冷却槽两种配置。

- Stainless spray cooling tank (trough) and pipe works.
- Rapid and even pipe cooling is realized by the rationally distributed nozzle and the optimized dual-circuit water pipe with filter.
- Automatic water temperature and level control.
- Both stainless steel spray cooling tank and the visible stainless steel spray cooling trough can be available according to customer's requirement.



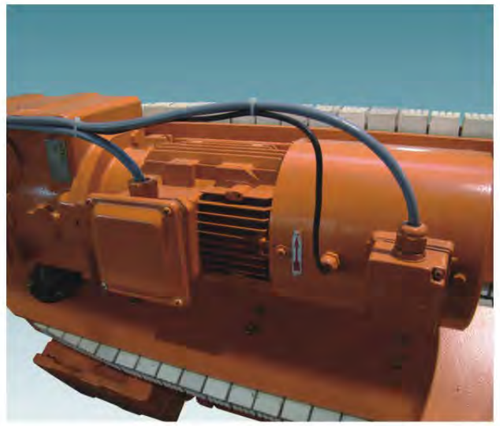
喷淋冷却箱参数 Technical Data of Spray Cooling Tank

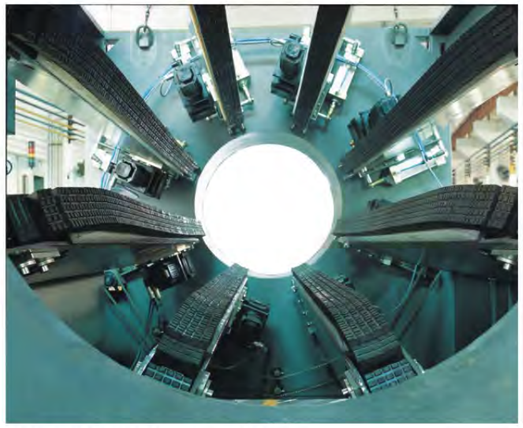
型号 Type		DKM-ELQ63	DKM-ELQ125	DKM-ELQ250	DKM-ELQ315	DKM-ELQ450	DKM-ELQ630	DKM-ELQ800	DKM-ELQ1200	DKM-ELQ1600
管径范围 Pipe Diameter	mm	Φ10-63	Φ20-125	Φ50-250	Φ75-315	Φ160-450	Φ250-630	Φ280-800	Φ500-1200	Φ710-1600
水泵 Water Pump	kW	5.5	5.5	5.5	5.5	7.5	2X5.5	2X5.5	2X7.5	2X7.5
冷却箱长度 Cooling Chamber Length	mm	6000	6000	6000	6000	6000	6000	6000	6000	6000

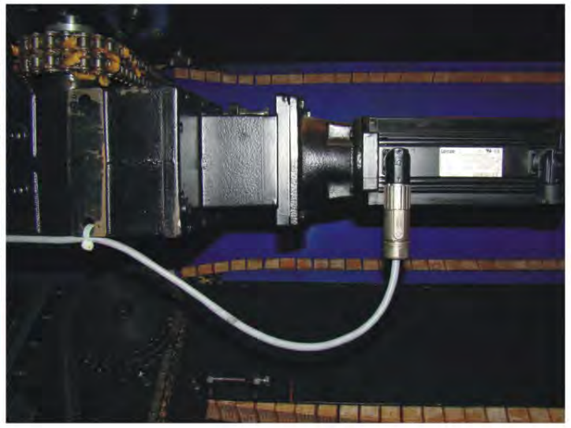
牵 引 机 Haul-off Unit

- 履带传动采用伺服电机精确同步驱动
- 上履带采用气缸柔性加紧，自动适应管材规格变化并与管材保持良好接触压力，下履带根据管材规格电动调节至所需牵引管径位置。
- 采用与链条直联的高摩擦系数橡胶块
- 有二、三、四、六、八、十、十二条履带多型号牵引机
- 适应管径范围：Φ10-Φ1600mm

- Caterpillar with servo motor realizes precise synchronization driving.
- With pneumatic flexible clamping, the upper caterpillar can adapt per the pipe specification variation and keeps good contact pressure with the pipe; the lower caterpillar can be electrically adjusted to the required haul-off position per the pipe specification.
- High friction rubber pads connects with the chain.
- Haul-off unit with 2, 3, 4, 6, 8, 10, 12 caterpillars.
- Applicable for pipe diameter: Φ10-Φ1600mm







伺服电机同步驱动 Servo Motor Drive

牵引机参数 Technical Data of Haul-off Unit

型号 Type		DKM-EQY63	DKM-EQY125	DKM-EQY250	DKM-EQY315	DKM-EQY450	DKM-EQY630	DKM-EQY800	DKM-EQY1200	DKM-EQY1600
牵引范围 Pipe Diameter	mm	Φ10-Φ63	Φ20-Φ125	Φ50-Φ250	Φ75-Φ315	Φ160-Φ450	Φ250-Φ630	Φ280-Φ800	Φ500-Φ1200	Φ710-Φ1600
履带数量 Number of Caterpillar		2	2	4	4	4	6	8	10	12
接触长度 Contact Length	mm	1200	1500	1500	1750	2300	1800	2350	2350	2350
最大牵引力 Max. Haul-off Force	N	10000	15000	20000	25000	30000	50000	60000	80000	80000
牵引速度 Haul-off Speed	m/min	0.6-30	0.5-23	0.2-10	0.1-5	0.1-5	0.1-5	0.05-2.5	0.05-1	0.05-1

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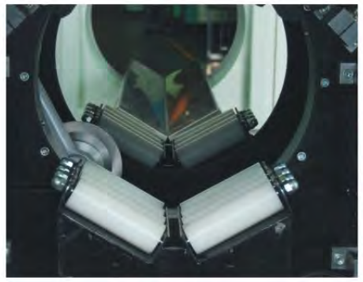
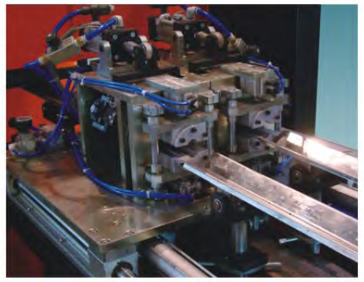
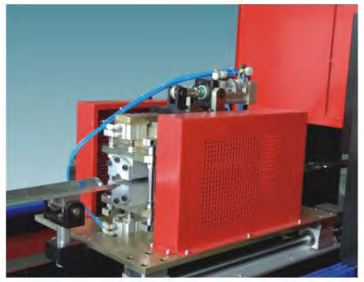
切 割 机 Cutting Unit

- 采用液压浮动进刀方式，特殊结构锯片适合厚壁PO管切割，切口光洁美观。
- PVC 切割和倒角可同步完成
- PLC 控制同步运行
- 有锯切割和刀片无屑切割两种形式

- Hydraulic fluctuating blade advancing method, special saw blade structure, suitable for cutting pipes of big wall thickness; smooth cutting profile.
- Simultaneous PVC cutting and chamfer
- PLC synchronization control
- Provide saw & swarfless cutting options.

切割机参数 Technical Data of Cutting Unit

型号 Type	单位 Unit	*DKM-EJX63S	DKM-EJX63	DKM-EJX125	DKM-EJX160	DKM-EJX250	DKM-EJX315	DKM-EJX450	DKM-EJX630	DKM-EJX800	DKM-EJX1200
最大管径 Max. Pipe Diameter	mm	2*Φ63	Φ75	Φ125	Φ160	Φ250	Φ315	Φ450	Φ630	Φ800	Φ1200
最小管径 Min. Pape Diameter	mm	2*Φ10	Φ10	Φ20	Φ20	Φ50	Φ75	Φ160	Φ250	Φ280	Φ500
切割功率 Cutting Power	kW	2*0.4	0.4	1.5	1.5	1.5	2.2	3	3	3	3
最大切割速度(▲) Max. Cutting Speed	m/min	2*30	30	23	20	10	8	5	5	2.5	1
切割厚度 Cutting Thickness	mm	15	15	28	30	30	35	45	65	70	70

＊ 适用于双管挤出生产线
For double strands extrusion line
▲整线切割速度需根据整体配置而定
The cutting speed of the whole production line depends on the overall machine configuration
本公司保留修改技术参数的权力，恕不另行通知。
DEKUMA reserves the right to change design and / or specifications without prior notice.

应 用 领 域 Application

聚烯烃管道可广泛应用于：

- 城镇自来水给水，尤其是分质供水和直饮水方面
- 煤气、液化气、天然气输配管道
- 排污水管道
- 饮料和食品工业、石油化工产业、化纤、林业、印染、制药、造纸冶金等工业的液体输送管道
- 水利和农田灌溉
- 泥浆和矿浆输送
- 工业和生活排污
- 邮电通讯线路、电气电缆保护套管
- 海水养殖业和海水输送等各领域

Polyolefine lene pipe can be widely applied for:

- Urban tap water supply, direct drinking water supply and different quality water supply.
- Coal gas, liquefied gas and natural gas distribution and transportation.
- Corrosive water drainage
- Liquid pipe transportation in beverage and food industry, petrochemical industry, chemical fiber, forestry, printing and dyeing, pharmacy, papermaking, metallurgy, etc.
- Water conservancy and farm irrigation works
- Mud and mine slurry transportation
- Industrial and living waste drainage
- Post and telecommunication line, electricity cable protection bushing.
- Seawater aquaculture and seawater transportation filed.

DEKUMA
高速、高效、耐用
High speed, high efficiency, high reliability

双锥形双螺杆挤出机 Double Conical Twin-Screw Extruder

DKM-EII 50/103 60/125 70/150
Special for PVC

- 螺杆采用双锥型、变螺距、加长螺杆等最新结构，因而使产量提高30%以上。
- 分配齿轮箱结构紧凑、拆装方便。推力轴承采用进口名牌轴承。
- 减速箱为硬齿面齿轮减速机，承载能力大、使用寿命长。
- 主机和加料机驱动为直流电机驱动，直流调速器采用世界名牌英国欧陆调速器，可实现主机、加料机和牵引机同步调速，使操作极为方便。
- 采用日本RKC温控表或PLC电脑温控系统，使温度控制更精确。
- 主要电器元件均采用进口或中外合资生产产品。
- 均装有熔融物料压力和温度传感器，使得物料情况一目了然，操作更为方便。
- 双锥形双螺杆挤出机主要适用于加工软、硬PVC管材、PVC异型材、PVC电缆线、PVC透明瓶料及一些聚烯烃塑料制品，尤其适合于塑料粉料直接成型。

- The longer screw with the newest double conical structure and variable pitch improve the output by over 30%.
- The compact distribution gearbox with the thrust bearings of the famous brand makes the convenient assembly and/or disassembly.
- The hardened gear surface of the gearbox guarantees the high loading capacity and long service life.
- The extruder and feeder are driven by the DC motor. The using of British EUROTHERM DC speed controller achieves the synchronization of the extruder, feeder and haul-off machine, which makes the operation more convenient.
- The Japanese RKC temperature control meter or PLC computer temperature control system,ensures precise temperature controlling.
- The main electric components are from the overseas suppliers or domestic joint ventures.
- The melt pressure and temperature transducers allow the obvious inspection of the melt and easy operation.
- The Double Conical Twin-Screw Extruder are mainly used for the processing of the soft/hard PVC pipes, PVC profiles, PVC cables, PVC transparent bottles as well as the other polyolefin products, especially the direct processing of the plastic/powder materials.

主要技术参数 Main technical data

型号 Type	Type		DKM-E Ⅱ 50/103	DKM-E Ⅱ 60/125	DKM-E Ⅱ 70/150
螺杆直径	Diameter of screw	(mm)	50/103	60/125	70/150
螺杆转速	Screw speed	(rpm)	40	38	38
螺杆有效长度	Effective length of screw	(mm)	1060	1300	1600
主电机工率	Main motor	(kw)	22	37	55
机筒加热功率	Barrel heating power	(kw)	16	24	35
生产能力	Max.output	(kg/h)	150	350	500
机器中心高度	Center height	(mm)	1000	1000	1000
外形尺寸	Dimension(l × w × h)	(mm)	3780X1280X2155	4170X1380X2350	3660X1380X2495

DEKUMA
高速、高效、耐用
High speed, high efficiency, high reliability

PO管模头/单螺杆挤出机的应用 Application

PE-HD DIN 8074

PP DIN 8077

PE-LD DIN 8072

直径Diameter / 壁厚Thickness（标准尺寸比率 SDR）

管径 Pipe dia. \ SDR	51	41	33	26	22	21	17.6	17	13.6	11	9	7.4	6	5
10	—	—	—	—	—	—	—	—	—	—	—	—	1.8	2.0
12	—	—	—	—	—	—	—	—	—	—	—	1.8	2.0	2.4
16	—	—	—	—	—	—	—	—	—	—	1.8	2.2	2.7	3.3
20	—	—	—	—	—	—	—	—	1.8	1.9	2.3	2.8	3.4	4.1
25	—	—	—	—	—	—	—	1.8	1.9	2.3	2.8	3.5	4.2	5.1
32	—	—	—	—	—	—	1.8	1.9	2.4	2.9	3.6	4.4	5.4	6.5
40	—	—	—	1.8	1.9	1.9	2.3	2.4	3.0	3.7	4.5	5.5	6.7	8.1
50	—	—	1.8	2.0	2.3	2.4	2.9	3.0	3.7	4.6	5.6	6.9	8.3	10.1
63	—	1.8	2.0	2.5	2.9	3.0	3.6	3.8	4.7	5.8	7.1	8.6	10.5	12.7
75	1.8	1.9	2.3	2.9	3.5	3.6	4.3	4.5	5.6	6.8	8.4	10.3	12.5	15.1
90	1.8	2.2	2.8	3.5	4.1	4.3	5.1	5.4	6.7	8.2	10.1	12.3	15.0	18.1
110	2.2	2.7	3.4	4.2	5.0	5.3	6.3	6.6	8.1	10.0	12.3	15.1	18.3	22.1
125	2.5	3.1	3.9	4.8	5.7	6.0	7.1	7.4	9.2	11.4	14.0	17.1	20.8	25.1
140	2.8	3.5	4.3	5.4	6.4	6.7	8.0	8.3	10.3	12.7	15.7	19.2	23.3	28.1
160	3.2	4.0	4.9	6.2	7.3	7.7	9.1	9.5	11.8	14.6	17.9	21.9	26.6	32.1
180	3.6	4.4	5.5	6.9	8.2	8.6	10.2	10.7	13.3	16.4	20.1	24.6	29.9	36.1
200	3.9	4.9	6.2	7.7	9.1	9.6	11.4	11.9	14.7	18.2	22.4	27.4	33.2	40.1
225	4.4	5.5	6.9	8.6	10.3	10.8	12.8	13.4	16.6	20.5	25.2	30.8	37.4	45.1
250	4.9	6.2	7.7	9.6	11.4	11.9	14.2	14.8	18.4	22.7	27.9	34.2	41.6	50.1
280	5.5	6.9	8.6	10.7	12.8	13.4	15.9	16.6	20.6	25.4	31.3	38.3	46.5	56.2
315	6.2	7.7	9.7	12.1	14.4	15.0	17.9	18.7	23.2	28.6	35.2	43.1	52.3	63.2
355	7.0	8.7	10.9	13.6	16.2	16.9	20.1	21.1	26.1	32.2	39.7	48.5	59.0	—
400	7.9	9.8	12.3	15.3	18.2	19.1	22.7	23.7	29.4	36.3	44.7	54.7	66.5	—
450	8.8	11.0	13.8	17.2	20.5	21.5	25.5	26.7	33.1	40.9	50.3	61.5	—	—
500	9.8	12.3	15.3	19.1	22.8	23.9	28.4	29.7	36.8	45.4	55.8	68.3	—	—
560	11.0	13.7	17.2	21.4	25.5	26.7	31.7	33.2	41.2	50.8	62.5	—	—	—
630	12.3	15.4	19.3	24.1	28.7	30.0	35.7	37.4	46.3	57.2	—	—	—	—
710	13.9	17.4	21.8	27.2	32.3	33.9	40.2	42.1	52.2	—	—	—	—	—
800	15.7	19.6	24.5	30.6	36.4	38.1	45.3	47.4	58.8	—	—	—	—	—
900	17.6	22.0	27.3	34.6	40.9	42.9	51.1	52.9	—	—	—	—	—	—
1000	19.6	24.4	30.3	38.5	45.5	47.6	56.8	58.8	—	—	—	—	—	—
1200	23.5	29.3	36.4	46.2	54.5	57.1	68.2	70.6	—	—	—	—	—	—
1400	27.5	34.1	42.4	53.8	63.6	66.7	—	—	—	—	—	—	—	—
1600	31.4	39.0	48.5	61.5	72.7	76.2	—	—	—	—	—	—	—	—

螺杆直径 Screw dia.	ϕ60	ϕ70	ϕ80	ϕ100	ϕ120	ϕ120	ϕ120	ϕ120	ϕ120
	300 kg/h (max.)	400 kg/h (max.)	500 kg/h (max.)	管径(Pipe dia.) 160-450 mm	管径(Pipe dia.) 200-630 mm	管径(Pipe dia.) 280-800 mm	管径(Pipe dia.) 500-1200mm	管径(Pipe dia.) 710-1600mm	

管径(Pipe dia.) 10-63 mm
管径(Pipe dia.) 20-125 mm
管径(Pipe dia.) 50-250 mm
800kg/h (max.)
1100 kg/h (max.)
1100kg/h (max.)
1250 kg/h (max.)
1400 kg/h (max.)

*如有参数变更，恕不另行通知。 We reserve the right to change any design and specification without notice.

企业理念 & 愿景 Philosophy & Prospect