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SHANGHAI ZHONGJI



FOAMPLASTICS MACHINERY
JILIN TSINGHUA



中吉EPS机械制造
SHANGHAI ZHONGJI FOAMPLASTICS MACHINERY

清华EPS泡塑机械
JILIN TSINGHUA SCIENCE & TECHNOLOGY

www.zhongji.com



生产设备 EPS PRODUCTION LINE

- EPS真空全自动包装成型机
AUTOMATIC VACUUM SHAPE MOLDING MACHINES
- EPS间歇式预发泡机
BATCH PRE-EXPANDERS
- EPS真空自动板材成型机
AUTOMATIC VACUUM BLOCK MOLDING MACHINES
- EPS自动板材成型机
AUTOMATIC BLOCK MOLDING MACHINES
- EPS板材切割机
AUTOMATIC BLOCK CUTTING MACHINES
- EPS数控仿形切割机
CNC SHAPE CUTTING MACHINES
- EPS流化干燥床
FLUIDIZED BEDS
- EPS连续式预发泡机
CONTINUOUS PRE-EXPANDERS
- EPS破碎机
CRUSHERS & RECYCLING SYSTEM
- EPS电子控制系统
ELECTRONIC CONTROL SYSTEM
- EPS泡塑机械零配件
PARTS AND HYDRAULIC PRESSURE PARTS





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Company profile

●清华EPS产业 中吉EPS机械

“自强不息，厚德载物”八字源于《周易》，“乾”“坤”二卦的卦辞：“天行健，君子以自强不息；地势坤，君子以厚德载物”。

公元一九九四年春，侯树旗创建了吉林省清华科技有限公司，担任法人代表，并立此八字为训，与“坚忍图成，追求卓越”共为公司理念，志以科技兴邦，产业报国。

清华公司于一九九七年经国家商标局核准，使用清华® 注册商标。主要从事EPS（可发性聚苯乙烯）科学研究、技术开发、EPS泡塑机械制造、EPS制品车间设计建造、EPS专业人才培养、网络信息服务等，是集科、工、贸、产、学、研为一体的民营高科技集团型企业。凭借精诚团结、锐意开拓的创新精神，成就了初期的辉煌。

上海中吉机械制造有限公司在不断改进和完善原有的清华公司EPS泡塑机械的基础上，开发、研制出挤塑聚苯乙烯泡沫板（XPS）生产线，彩钢夹芯板生产线和钢结构整厂设备等。新厂区距虹桥机场15公里，交通十分便捷。

风雨十余载，公司不断创新，取得了巨大的成功，摆脱了产品单一、产业脆弱的局面。分别在全国各地创建了EPS泡塑机械制造公司、EPS制品和钢结构生产厂等企业，设备销往世界各地，并开辟了国际合作的广阔渠道。作为清华EPS教育基金发起人，投资创办了吉林省科技外语学校EPS泡塑专业。

喝彩十余载，创新不断的中吉公司一直是中国EPS泡塑行业的技术先锋。

Jilin Tsinghua foamplastics machinery Co., Ltd. was started in 1994 by Gunther Hou, mainly engaged in EPS (Expandable PolyStyrene) industry, such as machinery manufacturing, designing and construction for EPS production plants, talents training, website service, etc. It has been the **Tsinghua**® holder since 1997.

Shanghai Zhongji Machinery Manufacturing Co., Ltd. Utilizes the latest technology and equipment to manufacture a variety of standardized and customized machinery from board of EPS based on Tsinghua Company, and engages in the production lines of XPS, sandwich panel and steel structure, the new factory is 15km away from Shanghai Hongqiao Airport, with convenient traffic around.

With the history of more than ten years, a dozen enterprises have already been established such as EPS machinery manufacturing, EPS R&D, EPS and sandwich panel products manufacturing etc. EPS machinery have been exported to more than 30 countries and regions all over the world. As the initiator of Tsinghua educational funds, the company have also invested to originate the major of EPS foamplastics in Jilin Science & Technology Foreign Language Institute.



中吉EPS机械制造
SHANGHAI ZHONGJI FOAMPLASTICS MACHINERY

清华EPS泡塑机械
JILIN TSINGHUA SCIENCE & TECHNOLOGY

自强不息
厚德载物
望子成龙
追求卓越

滕树祥



清华公司教育培训中心对国内EPS企业负责人进行专业培训
Principals of domestic EPS enterprises accepted professional training
held by Tsinghua Company.





EPS网络管理中心
Zhongji.com Website Management
Information Centre.



BASF公司的Mr.Ruckstuhl正在给学员们
讲授EPS包装设计
Mr.Ruckstuhl from BASF is lecturing on EPS
packing and design.

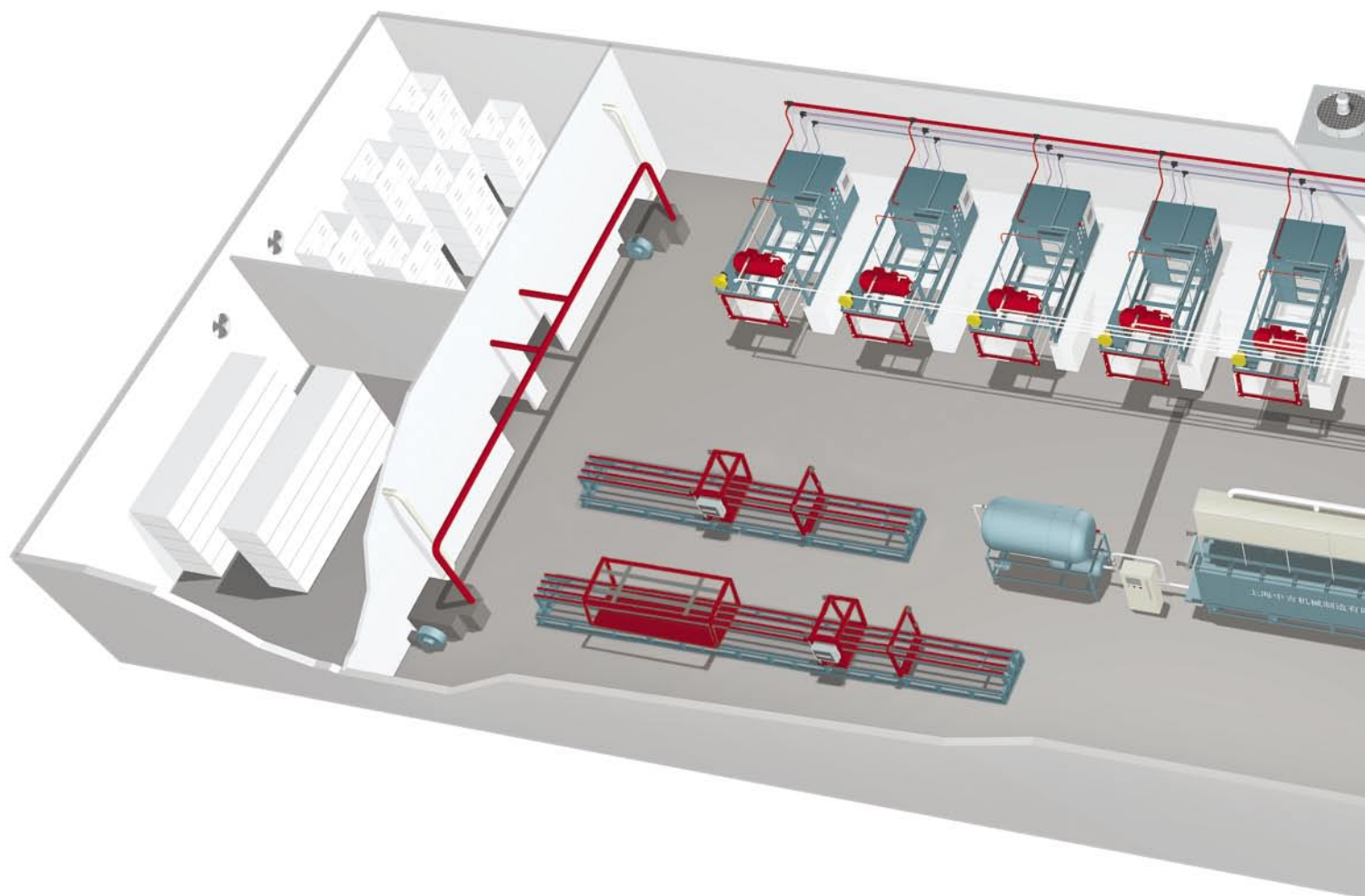
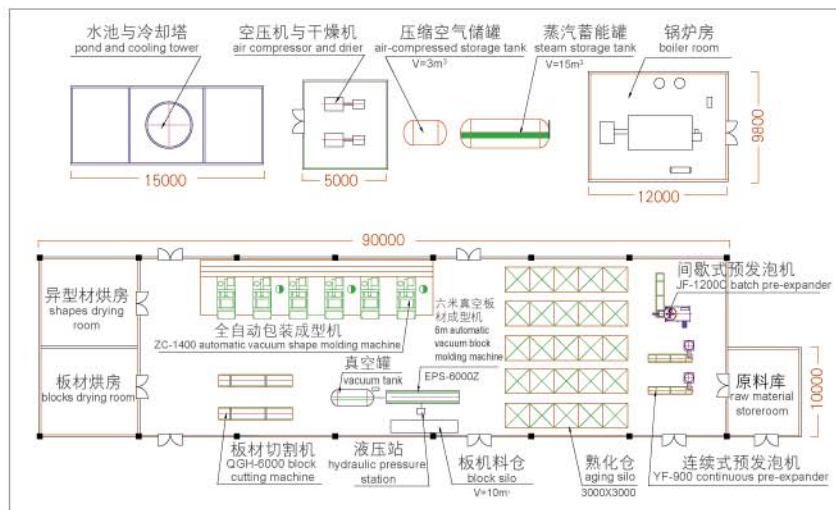


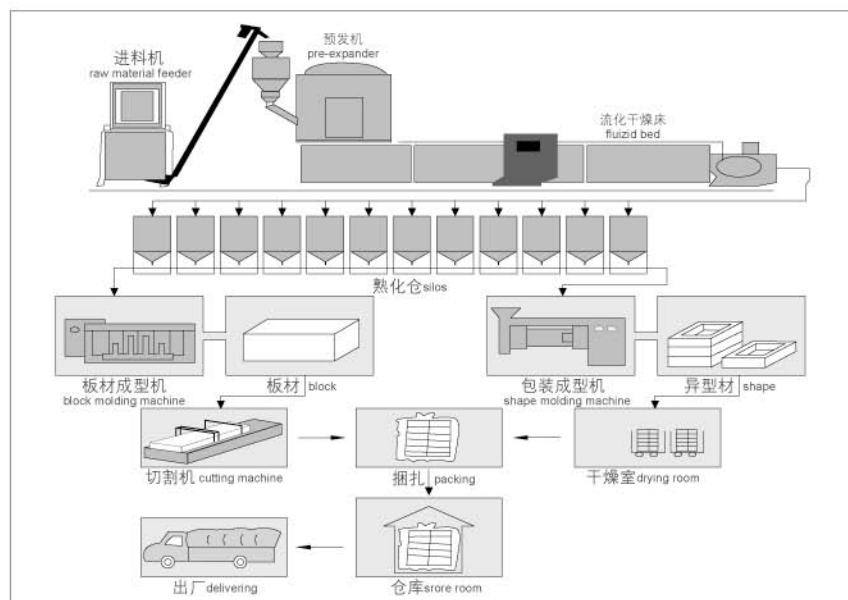
EPS泡塑专业人才在这里成长
EPS foamplastics talents are growing from here.

Sometric Layout

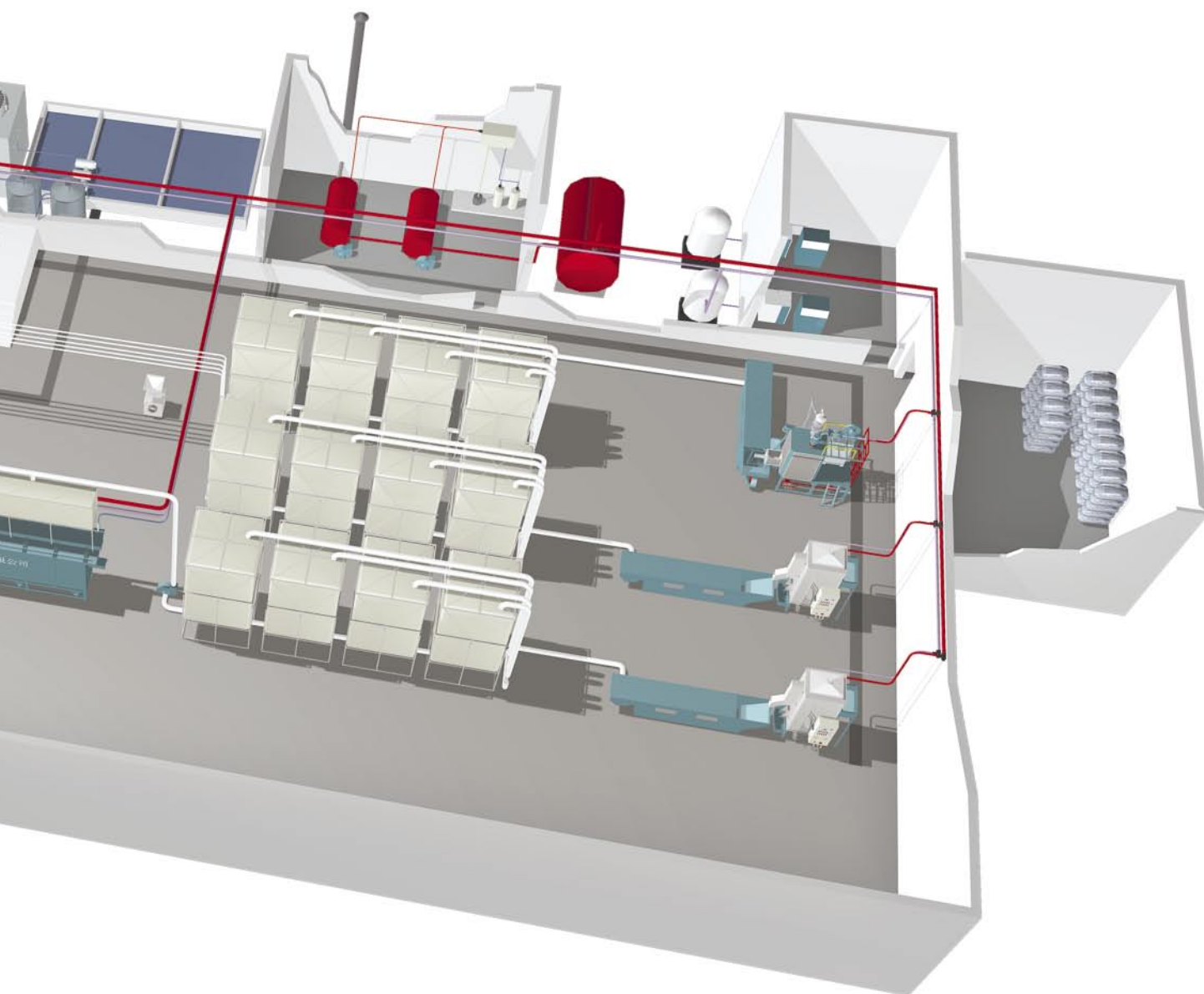
of a EPS Molding Plant

EPS制品成型车间布置图





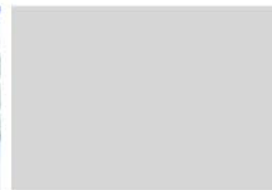
EPS制品生产的工艺路线
The process of EPS products manufacturing



EPS 真空全自动包装成型机



EPS Automatic
Vacuum
Shape Molding Machines



主要特点

- 1、机器采用PLC与触摸屏，完成机器的开合模、进料、加热、保温、冷却、脱模、制品顶出等全自动循环过程；
- 2、机器可根据不同的制品，选择普通、加压、真空等不同方式进料，保证模内进料快速、均匀；
- 3、机器采用先进的液压系统，运行和锁模分别采用主、付油缸工作，可节能30%；
- 4、机器采用数控编码器，控制开合模的行程距离，保证加料时每次留缝一致，加料密度均匀；
- 5、机器加热时采用平衡阀控制，保证每次模腔内蒸汽压力一致、温度相同；
- 6、机器真空系统主要由真空储能罐、真空冷凝罐和高效水环真空泵等组成，制品成型速度快，粘接均匀，含水率低。
- 7、电脑设有生产工艺记忆功能和生产数量统计功能，操作者可点触摸屏，查找或自行设计制品的成型工艺参数。

Main features

1. Use PLC programmable controller and touch screen to finish the autocycle process of opening-closing mold, feeding, heating, heat preservation, cooling, demolding and releasing.
2. According to different products wanted, choose different feeding methods such as common, pressure and vacuum to ensure feeding speed and uniformity.
3. Hydraulic system used in the machine can save 30% energy. Its operation and locking mold are used by the main and auxiliary cylinder respectively.
4. Use digital encoder to control the travel distance of operation and locking mold, ensure the uniformity of each feeding.
5. Balance valve of the machine, used in heating, ensure the same steam pressure and temperature during each cycle.
6. Vacuum system, mainly including vacuum storage tank, vacuum cooling tank, and water-cycle vacuum pump, ensure fast molding, uniform cementing and low moisture content.
7. For production technical memory and quantity statistic, operator can find and set the different foam parameter by themselves.

主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	ZC-1200	ZC-1400	ZC-1600	ZC-1700	ZC-2000
1	标准模具尺寸 Standard Dimensions of Mold	mm		1200X1000	1400X1200	1600X1400	1700X1500	2000X1800
2	制品尺寸 Dimensions of Product	mm		1000X850	1200X1050	1400X1250	1500X1350	1800X1600
3	制品高度 Height of Product	mm		350	350	350	350	350
4	最大开模间距 Max.Interval	mm		1200	1400	1400	1400	1400
5	最小开模间距 Min.Interval	mm		150	200	200	200	200
6	行程速度 Procession Speed	mm/sec		160	160	120	120	100
7	蒸汽 Steam	压力 Pressure	Mpa	0.5-0.7	0.5-0.7	0.5-0.7	0.5-0.7	0.5-0.7
		进口口径 Inlet DN	mm	50	70	80	80	80
		消耗 Consume	公斤/模 kg/cycle	5.5	6.5	7	8	10
8	压缩空气 Air-Compressed	压力 Pressure	Mpa	0.5-0.7	0.5-0.7	0.5-0.7	0.5-0.7	0.5-0.7
		进口口径 Inlet DN	mm	65	65	65	65	65
		消耗 Consume	公斤/模 kg/cycle	1.5	1.8	2.2	2.2	2.8
9	冷却水 Water	压力 Pressure	Mpa	0.3-0.6	0.3-0.6	0.3-0.6	0.3-0.6	0.3-0.6
		进口口径 Inlet DN	mm	65	65	65	65	65
		消耗 Consume	公斤/模 kg/cycle	50-120	50-130	50-150	50-160	50-180
10	电源 Supply Power	功率 Power	kw	10.2	10.2	13.7	16.1	20.1
		电压 Voltage	v	380	380	380	380	380
11	成型周期 Molding Period	秒/模 Second/cycle		60-100	60-120	80-130	100-150	120-180
12	最大外形尺寸 Max. Contour Size	mm		4300X2000 X3130	4500X2200 X3500	4600X2400 X3850	4600X2520 X4000	5100X2620 X4000
13	整机重量 Machine Weight	kg		4000	4500	5000	6500	12000

JF-1600C 型全自动间歇式预发泡机

主要特点

在JF-1200C间歇式预发泡机的基础上，引进国外先进的发泡机械工艺和装备，开发出国内唯一超大型、多功能的多次复合间歇式预发泡机，获得中国实用新型专利。

1. 机器在进行EPS原料一次预发后，还可进行二次、三次发泡（客户可选配）。年生产量在2000吨EPS原料以下的EPS生产工厂，只需一台JF-1600C型间歇式预发泡机，即可同时预发重料和预发轻料，满足生产要求，提高了生产效率，节约了生产场地和能源。
2. 电气系统采用日本光洋公司的PLC可编程工控机和10"大型真彩触摸屏，操作简单，运行平稳。
3. 加料采用全自动螺旋上料机构和负压加料装置，并采用光电控制系统和称重模拟块，确保称重精确。
4. 蒸汽系统采用日本“YS”公司的蒸汽减压阀，严格控制发泡筒体内的蒸汽压力。
5. 预发珠粒比重在20kg/m³以上时，采用德国的比例阀（客户可选配）来精确控制发泡筒体内的温度差在±2℃以内。确保发泡均匀。

Main features

Fetch in advanced technologies abroad, we have developed the unique supersized multifunctional compound batch pre-expander based on the JF-1200C batch pre-expander, which obtains the domestic patent for utility model.

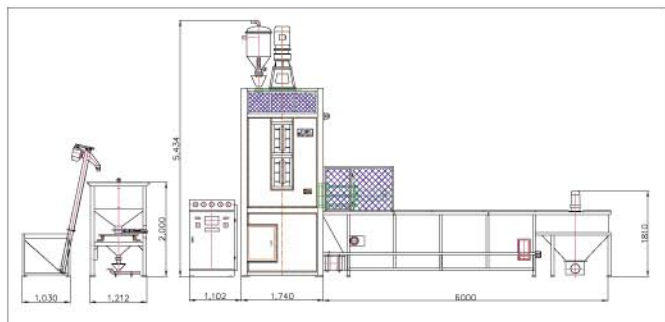
1. Foam twice or thrice (optionally) after EPS raw material's once pre-expanding. For those factories whose annual output of EPS raw material below 2000t, only one JF-1600C batch pre-expander is necessary to pre-expand heavy & light raw material simultaneously, which meets the production requirement, improves the production efficiency and saves space & energy.
2. Adopt KOYO Japan's PLC programmable controller and 10" real color touch screen in the electric system, easy to operate, running stably.
3. Use automatic spiral feeder & negative pressure feeder to feed, photoelectric controlling system & weighing module to ensure exact weighing.
4. Adopt YS Japan's steam reducing valve in the steam system, strictly controlling the steam pressure in the chamber.
5. Use German proportional valve (optionally) to control the temperature difference in the chamber exactly within ±2℃ when the density of beads pre-expanded is above 20 kg/m³, ensuring the uniformity of foaming.

主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	JF-1600C
1	预发筒体尺寸 Chamber Size	筒直径 Diameter	mm	1600
		筒体高 Height	mm	2500
2	预发料桶容积 Chamber Vol.	m ³		5
3	蒸汽入口通径 Steam Inlet DN	mm		80
4	压缩空气入口通径 Air-Compressed Inlet DN	mm		40
5	蒸汽压力 Steam Pressure	Mpa		0.3-0.8
6	压缩空气压力 Air-Compressed Pressure	Mpa		0.5-0.8
7	总电机功率 Power	kw		23
8	加料控制方式 Control Mode			电子计量 Electronic computation
9	烘干方式 Drying Way	kg/m ³		流化干燥床 Fluidized Bed
10	发泡密度 Foaming Density			11-50
11	生产效率 Capacity	kg/h		900-1800
12	最大外形尺寸 Max. Contour Size	mm		12000x2650x5500
13	整机重量 Machine Weight	kg		6500





JF-1100B型间歇式预发泡机

EPS Batch Pre-expander



Batch Pre-expanders



主要特点

1. 机器采用PLC可编程工控机和触摸屏，实现人机对话，通过负压自动上料装置、精确电子称重和料位开关，实现了自动上料与精确计量；通过对桶体内的温度、压力的自动控制装置和自动光电料位控制装置，实现了发泡珠粒密度轻质均匀；通过振动筛、块料粉碎、风机输送装置，完成了EPS珠粒发泡的一次自动循环过程；
2. 更加精确控制桶体内的蒸汽压力和温度，采用进口蒸汽减压阀和先进的德国的比例阀（客户可选配），保证减压阀出口的压力始终恒定，保证桶体内的温度差控制在 $\pm 1^{\circ}\text{C}$ 之内，确保发泡后的珠粒密度误差在 $\pm 2\%$ 之内。若生产密度 $20\text{kg}/\text{m}^3$ 以上的泡沫制品，则需要增设比例阀；
3. 流化干燥床内设热空气干燥系统（获得国家专利），温度可达 75°C ，使发出的EPS原料更加干燥，并且快速定型，后发性好，加快了熟化过程，缩短了生产周期；
4. 由于将自动上料装置和电子称重装置与机器分离，避免了机器工作过程中产生的振动影响电子称重装置计量的准确性和可靠性；
5. 机器设有四种安全保护装置，可安全地保证机器正常运转；
6. 电脑设有生产工艺记忆功能和生产数量统计功能，操作者可点触摸屏，查找经常使用的EPS原料生产厂家的发泡工艺参数，同时可自行设计不同的发泡工艺参数。电子称重数显系统可方便地添加数字打印机（可根据客户添加），统计出一天、一周、一月或一年的EPS原料的产量，便于厂内统计与核算；
7. 根据客户的要求，可以增加远程通讯系统，用来远程检控机器是否正常运转，解除机器故障；并可升级机器软件系统，改善机器工艺性能；
8. JF-1200C型间歇式发泡机桶体内设封闭式热空气干燥系统（获国家专利），温度可达 75°C ，使发出的EPS原料更加干燥，一次发泡密度可达 $11\text{kg}/\text{m}^3$ ，并且快速定型，后发性好，减掉了流化干燥床，方便了珠粒的输送，加快了熟化过程，缩短了生产周期。
9. 新颖的方型桶体，加上桶体外采用冰花不锈钢板包装，外观更加美观大方。先进的EPS发泡加工工艺，提高了生产效率，改善了发泡的质量，使EPS珠粒发的更准，更轻，更快，并且设备运行安全可靠，故障率低。

Main features

1. Use PLC programmable controller and touch screen to realize man-machine dialog. Use charging device of automatic negative pressure, electric weighing, level switch to realize automatic feeding and gauge. Use auto-controller of temperature and pressure in the chamber and photoelectric level material to realize the uniform and light density of the beads. EPS beads is formed in the auto-cycle by shock sieve, crushing and transportation fan.
2. Use imported steam reducing valve and proportional valve (optional) to ensure the stable pressure of the reducing valve outlet, and the temperature tolerances within $\pm 1^{\circ}\text{C}$ in the chamber. If the block density is above $20\text{kg}/\text{m}^3$, the proportional valve should be installed.
3. Hot air drying system (Patent) in the fluidized beds, temperature up to 75°C , ensure the EPS raw material drier, fast mold, speed up the aging process and shorten the production cycle.
4. Separation of auto-charging device and electric weighing with the machine avoids the inaccuracy and unreliability of electric weighing caused by operation.
5. Four security devices on the machine ensure it operates normally and safely.
6. For production technic memory and quantity statistic, operator can find the foam parameter of manufacturer's used EPS raw material and simultaneously set the different foam parameter by themselves. For statistics and account of EPS production per day, week, month or year, the electric weighing can be installed with digital printer optionally.
7. Remote communication system can be optionally used to monitor the machine and remedy its faults. Software system can be upgraded to improve its processing properties.
8. Hot air drying system (Patent) in the foam chamber, temperature up to 75°C , making EPS beads more dry, resulting in the density of foam up to $11\text{kg}/\text{m}^3$, making forming quickly, especially cut down the fluidized bed to advance the beads' transportation, speed up the aging and shorten the production cycle.
9. Use new EPS foam processing technology to improve its production efficiency, ensure EPS beads more accurately, lightly, fast and have low fault rate during its secure operation.

JF-1200C 型全自动间歇式预发泡机

EPS Batch Pre-expander



JF-1200C BATCH PRE-EXPANDER



主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items		单位 Unit	型号 Type	JF-1100B	JF-1200C
1	预发筒体尺寸 Chamber Size	筒直径 Diameter	mm		1100	1200
		筒体高 Hight	mm		1800	1800
2	预发料筒容积 Chamber Vol.		m³		1.7	1.9
3	蒸汽入口通径 Steam Inlet DN		mm		50	50
4	压缩空气入口通径 Air-Compressed Inlet DN		mm		25	25
5	蒸汽压力 Steam Pressure		Mpa		0.2-1.0	0.3-0.8
6	压缩空气压力 Air-Compressed Pressure		Mpa		0.5-0.8	0.5-0.8
7	总电机功率 Power		kw		12	16.3
8	加料控制方式 Control Mode			电子计量 Electronic computation		电子计量 Electronic computation
9	烘干方式 Drying Way			流化干燥床 Fluidized Bed		筒体烘干 Chamber drying
10	发泡密度 Foaming Density		kg/m³		12-30	11-50
11	生产效率 Capacity		kg/h		280-500	400-600
12	最大外形尺寸 Max. Contour Size		mm		7500x3000x3500	7500x3150x3800
13	整机重量 Machine Weight		kg		3300	3800

真空自动板材成型机



主要特点

1. 机器采用PLC可编程工业控制器和电脑触摸屏，完成机器的开合模、进料、加热、保温、冷却、脱模、制品顶出等自动循环过程；
2. 机器在加料、加热、保温和冷却的全过程均采用真空自动控制系统；
3. 真空系统主要有真空储能罐、真空冷凝罐和高效水环真空泵等组成；
4. 机器生产板材的密度可达 $6-40\text{kg}/\text{m}^3$ ，并且板材成型速度快、粘接均匀、含水率低、变形小；
5. 机器模腔表面采用特氟龙涂层（客户可选配），板材易脱模；
6. 加厚真空板材成型机配备自动输送装置和自动电子称重、打印装置；
7. 机器可和彩钢夹芯板配套，生产850mm、950mm和1150mm的板材，也可生产1000mm的建筑板材。

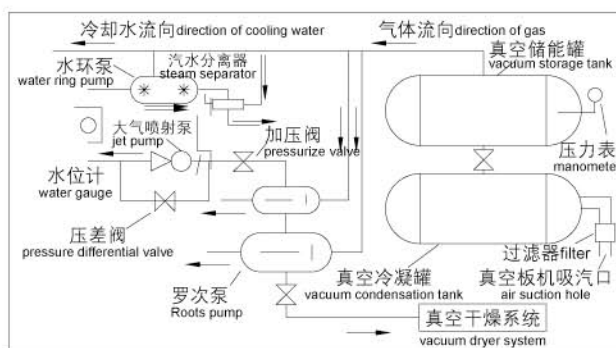
Main features

1. Use PLC programmable controller and touch screen to finish the autocycle process of opening-closing mold, feeding, heating, heat preservation, cooling, demolding and releasing.
2. Use auto vacuum control system in the process of feeding, heating, heat preservation and cooling.
3. Vacuum system includes vacuum storage tank, vacuum cooling tank and high efficiency water-cycle vacuum pump.
4. Blocks density being to $6-40\text{kg}/\text{m}^3$, has fast molding, uniform cementing, low moisture content and undeformation.
5. Teflon coating (optional) on the surface of mold is easy to demould.
6. Thickened vacuum block molding machine is attached with auto-transportation, auto-electric weighing and printer.
7. Can be a part of sandwich panel of 850mm, 950mm and 1150mm, also can produce 1000mm building block.

Automatic Vacuum Block Molding Machines



电子称重、打印装置
Electronic Weighing and Printing



EPS板材成型机真空系统原理图
The Vacuum System Principle Drawing of EPS Block Molding Machine

主要规格和参数

Main Specifications & Parameters

序号 Number	项目 Items	单位 Unit	型号 Type	EPS6000Z	EPS6000Z/C	EPS8000Z	EPS8000Z/C
1	模腔内净尺寸 Mold Size	mm		6120x1230x1050	6080x1230x630	8110x1240x1040	8100x1230x630
2	模腔体积 Mold Vol.	m ³		7.96	4.71	10.46	6.28
3	制品密度/比重 Products Density/Proportion	kg/m ³		6 ~ 35	6 ~ 45	6 ~ 25	6 ~ 40
4	生产效率 (标准条件) Capacity	piece/h		2 ~ 12	2 ~ 12	2 ~ 12	2 ~ 12
5	蒸汽压力 Steam Pressure	Mpa		0.6	0.6	0.6	0.6
6	蒸汽进口口径 Steam Inlet DN	mm		150	100	150	150
7	压缩空气进口口径 Air-Compressed Inlet DN	mm		50	50	65	65
8	电源 Supply Power						
	功率 Power	kw		30	30	30	30
	电压 Voltage	V		380	380	380	380
9	控制方式 Control Mode			自动 Automatic	自动 Automatic	自动 Automatic	自动 Automatic
10	结构特点 Structural Features			液压单门真空冷却 Hydraulic Single-door Vacuum Air Cooling	液压单门真空冷却 Hydraulic Single-door Vacuum Air Cooling	液压单门真空冷却 Hydraulic Single-door Vacuum Air Cooling	液压单门真空冷却 Hydraulic Single-door Vacuum Air Cooling
11	控制系统 Control System			PLC 及人机界面 Man Machine Interface & PLC	PLC 及人机界面 Man Machine Interface & PLC	PLC 及人机界面 Man Machine Interface & PLC	PLC 及人机界面 Man Machine Interface & PLC
12	最大外形尺寸 Max. Contour Size	mm		14000 × 4000 × 3000	14000 × 3000 × 3000	16000 × 4000 × 3000	16000 × 3000 × 3000
13	整机重量 Machine Weight	t		15	12	17	13
14	自动输送装置 Automatic Feeding Device			配 With	可选 Optional	配 With	可选 Optional
15	电子称重 Electronic Weight			配 With	可选 Optional	配 With	可选 Optional
16	打印 Printing			可选 Optional	可选 Optional	可选 Optional	可选 Optional

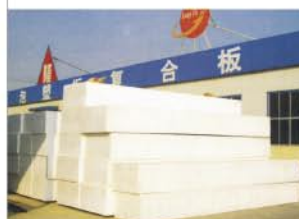
※上表中模腔内净尺寸为定型产品的尺寸，也可按用户要求做适当调整。
Mold Size mentioned above is standard product size, But also can be properly adjusted according to the customer's request.

EPS自动板材成型机



Automatic

Block Molding Machines





主要特点

1. 机器采用PLC完成机器的开合模、负压进料、穿透加热、保温、风冷却、脱模、制品顶出等自动循环过程；
2. D型板材成型机独有的双气室设计（已获国家专利），在原单气室板材成型机的基础上，节能30%，板材成型速度快，粘接性好，密度均匀，避免了单气室板材成型机模腔内上下加料密度不均，板材边角加料不满、板材含水的弊端，生产板材的密度可达6-45kg/m³；
3. 机器可选配触摸屏、自动输送装置和自动电子称重、打印装置；
4. 机器可和彩钢夹芯板配套，生产850mm、950mm和1150mm的板材，也可生产1000mm的建筑板材。

Main features

1. Use PLC programmable controller and touch screen to finish the autocycle process of opening-closing mold, feeding, heating, heat preservation, cooling, demolding and releasing.
2. D type has unique double gas rooms (Patent), which can save 30% energy, well distribute, reducing water, undeformed, blok density being to 6-45 kg/m³.
3. Touch screen, auto transportation, auto electric weighing and printer can be attached optionally.
4. Can be a part of sandwich panel of 850mm, 950mm and 1150mm, also can produce 1000mm building block.

主要规格和参数

Main Specifications & Parameters

序号 Number	项目 Items	单位 Unit	型号 Type	EPS6000C	EPS6000D	EPS6000E	EPS8000C	EPS8000D	EPS4000C	EPS3000C
1	模腔内净尺寸 Mold Size	mm		6080x1230x630	6080x1230x630 6080x1030x630	6090x1240x630(最大) 6090x830x630(最小)	8100x1230x630	8100x1230x630 8100x1030x630	4040x1230x510	3040x1230x530
2	模腔体积 Mold Vol.	m ³		4.71	4.71/3.94	4.71	6.28	6.28	2.53	1.98
3	制品密度/比重 Products Density/Proportion	kg/m ³		6~40	6~45	6~45	6~35	6~45	6~45	6~45
4	生产效率（标准条件） Capacity	piece/h		2~8	2~9	2~9	2~8	2~8	2~9	2~9
5	蒸汽压力 Steam Pressure	Mpa		0.6	0.6	0.6	0.6	0.6	0.6	0.6
6	蒸汽进口口径 Steam Inlet DN	mm		100	100	100	150	150	100	100
7	压缩空气进口口径 Air-Compressed Inlet DN	mm		50	50	50	65	65	40	40
8	电源 Supply Power	功率 Power	kw	11	11	12	11	11	7.5	7.5
		电压 Voltage	v	380	380	380	380	380	380	380
9	控制方式 Control Mode			自动 Automatic	自动 Automatic	自动 Automatic	自动 Automatic	自动 Automatic	自动 Automatic	自动 Automatic
10	结构特点 Structural Features			液压单开门 Hydraulic Single-door Open	液压单开门 Hydraulic Single-door Open	液压单开门 Hydraulic Single-door Open	液压单开门 Hydraulic Single-door Open	液压单开门 Hydraulic Single-door Open	液压单开门 Hydraulic Single-door Open	液压单开门 Hydraulic Single-door Open
11	控制系统 Control System			PLC	PLC	PLC	PLC	PLC	PLC	PLC
12	最大外形尺寸 Max. Contour Size	mm		8000×3000 ×3000	8000×3000 ×3000	8000×3000 ×3000	10000×3000 ×3000	10000×3000 ×3000	6000×2800 ×3000	5000×2800 ×3000
13	整机重量 Machine Weight	t		9	9.5	10.5	11	12	7	6
14	备注 Remark				双气室节能型 Double Air Chamber	模腔高度可调整 Mold's Height Can be Adjusted		双气室节能型 Double Air Chamber		

※上表中模腔内净尺寸为定型产品的尺寸，也可按用户要求做适当调整。

Mold Size mentioned above is standard product size, But also can be properly adjusted according to the customer's request.

EPS 立式自动板材成型机

EPS Automatic Vertical Block Molding Machines

主要特点

1. 机器采用PLC和触摸屏完成机器的开合模、负压进料、穿透加热、保温、风冷却、脱模、制品顶出、自动输送等自动循环过程；
2. 机器生产板材的密度可达6-40kg/m³，并且板材成型速度快，粘接性好，含水率低，变形小；
3. 预发珠粒从机器上部进料，节约能源、进料速度快、密度均匀，尤其适用于轻板生产；
4. 机器结构紧凑，占地面积小。

Main features

1. Use PLC programmable controller and touch screen to finish the autocycle process of opening-closing mold, negative-pressure feeding, heating, heat preservation, air cooling, demolding, releasing and auto transportation.
2. Blocks density being to 6-40kg/m³, has fast molding, uniform cementing, low moisture content and undeformation.
3. Feeding of EPS beads from the upper of machine can save energy, speed up feeding, have uniform density and especially fit to produce light block.
4. Smaller body can save the space.



主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	EPS2000L	EPS2500L
1	模腔内净尺寸 Mold Size	mm		2030x1030x630	2530x1020x760
2	模腔体积 Mold Vol.	m ³		1.32	1.96
3	制品密度/比重 Products Density/Proportion	kg/m ³		6 ~ 40	6 ~ 40
4	生产效率 (标准条件) Capacity	piece/h		2 ~ 8	2 ~ 8
5	蒸汽压力 Steam Pressure	Mpa		0.6	0.6
6	蒸汽进口口径 Steam Inlet DN	mm		100	100
7	压缩空气进口口径 Air-Compressed Inlet DN	mm		25	40
8	电 源 Supply Power	功率 Power	kw	6	7.5
		电压 Voltage	v	380	380
9	控制方式 Control Mode			自动 Automatic	自动 Automatic
10	结构特点 Structural Features			液压立式单开门 Hydraulic Vertical Single-door	液压立式单开门 Hydraulic Vertical Single-door
11	控制系统 Control System			PLC	PLC
12	最大外形尺寸 Max. Contour Size	mm		3100 × 3000 × 3250	3100 × 3200 × 3800
13	整机重量 Machine Weight	t		4	5

※上表中模腔内净尺寸为定型产品的尺寸，也可按用户要求做适当调整。

Mold Size mentioned above is standard product size, But also can be properly adjusted according to the customer's request.



主要特点

1. 机器的开合模、负压进料、穿透加热、保温、风冷却、脱模、制品顶出均为气动控制;
2. 机器生产板材的密度可达 $6\sim 25\text{kg}/\text{m}^3$;
3. 机器模腔采用特制铝合金板, 强度高、耐久性好、热传导效率高。

Main features

1. Pneumatic system controls the opening-closing mold, negative pressure feeding, heating, heat preservation, air cooling, demoulding, and releasing.
2. Blocks density being to $6\sim 25\text{ kg}/\text{m}^3$.
3. Special aluminium alloy plate used in the mold has good intensity, durability and thermal conductivity.

主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	EPS2000A	EPS2000B	EPS3000A	EPS3000B
1	模腔内净尺寸 Mold Size	mm		2030x1015x520	2030x1015x520	3040x1230x520	3040x1230x520 3040x1030x520
2	模腔体积 Mold Vol.	m^3		1.07	1.07	1.98	1.98
3	制品密度/比重 Products Density/Proportion	kg/m^3		6~25	6~30	6~25	6~30
4	生产效率(标准条件) Capacity	piece/h		2~6	2~7	2~6	2~7
5	蒸汽压力 Steam Pressure	Mpa		0.6	0.6	0.6	0.6
6	蒸汽进口口径 Steam Inlet DN	mm		65	65	80	0
7	压缩空气进口口径 Air-Compressed Inlet DN	mm			20		25
8	电 源 Supply Power	功率 Power	kw	3	3	3	3
		电压 Voltage	v	380	380	380	380
9	控制方式 Control Mode			手动 Manual	半自动 Semiautomatic	手动 Manual	半自动 Semiautomatic
10	结构特点 Structural Features			卧式三开门 Horizontal Three-door Opening	卧式三开门自动加热 Horizontal Three-door Automatic Heating	卧式三开门自动加热 Horizontal Three-door Automatic Heating	卧式三开门自动加热 Horizontal Three-door Automatic Heating
11	控制系统 Control System				接触器继电器 Contactor-Relay		接触器继电器 Contactor-Relay
12	最大外形尺寸 Max. Contour Size	mm		2300 × 1800 × 2000	2300 × 1800 × 2000	3400 × 1900 × 2300	3400 × 2400 × 2300
13	整机重量 Machine Weight	t		3	3.5	5	5.5

EPS板材自动切割机

EPS Automatic Block Cutting Machines

主要特点

1. 机器主体采用厚壁异型方管焊接和组合而成，可自由拆卸、组装；
2. 机器采用水平、竖向和端面切割丝，实现板材三维切割，端面切割丝单独配切割车，可与横、竖切割丝同时工作。采用离合器实现切割车架快速回车；
3. 机器采用10KVA多抽头特制变压器，可同时使用50根电热丝，变压器容量大、电压调节范围广；
4. 机器采用变频调速器，在0-4m/min之间任意调速，并且运行平稳，切割板材平整、尺寸稳定。
5. 端面切割可选配自动控制。
6. QGL-6000加长型垂直板材切割机可在垂直方向同时切割各种尺寸小型块材。



Main features

1. Its main body, welded and installed with thicken heterotype tube, can be dismantled and assembled easily.
2. Horizontal, vertical and end cutting wires in the machine are used to perform the 3D cutting of the block. End cutting wires, solely attached with cutter, can work with horizontal and vertical cutting wires together. Clutch on the machine ensure the quick cutter return on the cutting frame.
3. 10KV special transformer, work together with 50 wires, has large capacity and voltage regulating range .
4. Frequency governor regulates the speed between 0-4m/min, enables stable operation, smooth block of the stable size.
5. End cutting can optionally attached with auto controlling.
6. QGL-6000 lengthened vertical block cutting machine can cut all sizes of segments simultaneously in vertical direction.



主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	QG-3000, 6000, 8000	QGH-3000, 6000, 8000	QGL-3000, 6000, 8000
1	加工制品最大尺寸 Max. Products Size	mm		(3040, 6080, 8100) × 1230 × 630	(3080, 6080, 8100) × 1230 × 1240	(3080, 6080, 8100) × 1230 × 1240
2	最小切割厚度 Min. Cutting Thickness	mm		15	15	10
3	切割速度 Cutting Speed	m/min		0-4.5 (变频调速) Frequency Conversion to Timming	0-4.5 (变频调速) Frequency Conversion to Timming	0-4.5 (变频调速) Frequency Conversion to Timming
4	同时参加切割电热丝数量 Number of Operating Hot Wire Simultaneously	Piece		50	50	50
5	电热丝规格 Hot Wire Specification	mm		0.4-0.8	0.4-0.8	0.4-0.8
6	电机功率 Power	kw		0.55	0.55	5
7	变压器容量 Transformer Capacity	kw		10	10	10
8	最大外形尺寸 Max. Contour Size	mm		(5500, 8500, 10500) × 1600 × 1800	(5500, 8500, 10500) × 1600 × 2500	(7500, 10500, 12500) × 1600 × 3000
9	整机重量 Machine Weight	kg		1050, 1400, 1550	1200, 1500, 1700	2500, 3000, 3500

主要特点

1. 机器是通过控制X轴（运载EPS块料的传递带）和Y轴（承载电阻丝的热丝架）的同步运行组合成图形，同时利用电阻丝来切割各种形状的EPS制品。其运动路线是利用输入电脑的图形，自动发出脉冲信号来控制X、Y轴的运转；
2. 输入电脑的产品图形有两种方法：直接利用电脑专用AutoCAD 软件绘制或利用扫描绘图板把图形输入电脑；
3. 单线数控仿形切割机适用于切割的制品体积大或数量少；
4. 多线数控仿形切割机适用于切割的制品体积小或数量大。电阻丝切割系统可以同时使用多至二十条电阻丝，图形输入电脑后，所有电阻丝可平行运行，一次切割多达二十个复杂的二维形体；
5. 机器配置转动装置可实现三维切割。

Main features

1. By controlling the synchro running of X- axis (the transfer strap which carries EPS block) and Y- axis (the hot wire rack which carries resistor wires) to compound the graph, meanwhile use the wires to cut EPS block panels into various shapes.
2. Provide two methods to input product graphs into the computer: draw directly through the AutoCAD software or scan through the scanner.
3. Single-line CNC Shape Cutting Machine is used to cut products with large capacity or small amount.
4. Multi-line CNC Shape Cutting Machine is used to cut products with small capacity or large amount. Resistor wire cutting system can use up to 20 wires simultaneously, all wires run parallelly after inputting the graphs into the computer, which cuts up to 20 complex two-dimension shapes at one time.
5. When the machine is equipped with rotation device, it can realize three-dimension cutting.



主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	QGF-2000	QGF-3000	QGF-3000A
1	加工制品最大尺寸 Max.Products Size	mm		2000 × 1240 × 630	3000 × 1240 × 630	3000 × 1240 × 630
2	切割厚度 Cutting Thickness	mm		0-630	0-630	0-630
3	切割速度 Cutting Speed	m/min		0-3.5 (变频调速) Frequency Conversion to Timming	0-3.5 (变频调速) Frequency Conversion to Timming	0-3.5 (变频调速) Frequency Conversion to Timming
4	同时参加切割电热丝数量 Number of Operating Hot Wire Temporari	Piece		1-10	1-20	1-20
5	电热丝规格 Hot Wire Specifications	mm		0.3-1.5	0.3-1.5	0.3-1.5
6	电机功率 Power	kw		2.25	2.25	3.0
7	变压器容量 Transformer Capacity			6	6	6
8	CNC控制方式 Control Mode			全自动 automatic	全自动 automatic	全自动 automatic
9	控制软件 Control System			专用AutoCAD AutoCAD	专用AutoCAD AutoCAD	专用AutoCAD AutoCAD
10	切割模式 Ctting Mode	KVA		二维 Two Direction	二维 Two Direction	三维 (配转动装置) Three Direction (with the writhe set)
11	最大外形尺寸 Max.Contour Size	mm		4200 × 2000 × 2500	5500 × 2000 × 2500	5500 × 2000 × 2500
12	整机重量 Machine Weight	kg		1000	1200	1300

※上表中切割尺寸为定型产品的尺寸，也可按用户要求做适当调整。

Cutting Size mentioned above is standard product size, But also can be properly adjusted according to the customer's request.

EPS 流化干燥床

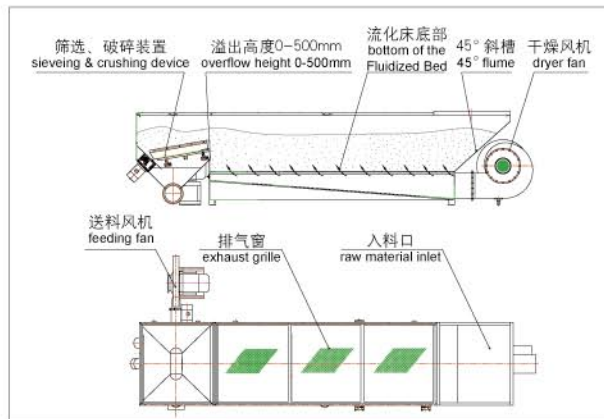
EPS Fluidized Beds

主要特点

1. 机器是预发泡机的配套设备，采用高压风机和热交换器形成的热风幕，对预发出来的EPS珠粒进行透析；
2. 改善了预发珠粒在成型过程中的进一步膨胀性、珠粒间的熔结性及珠粒的弹性，有利于提高EPS制品的质量；
3. 与间歇式预发机配套的流化干燥床内的温度达到75℃，并采用振动筛分、块料粉碎和风机输送等装置。

Main features

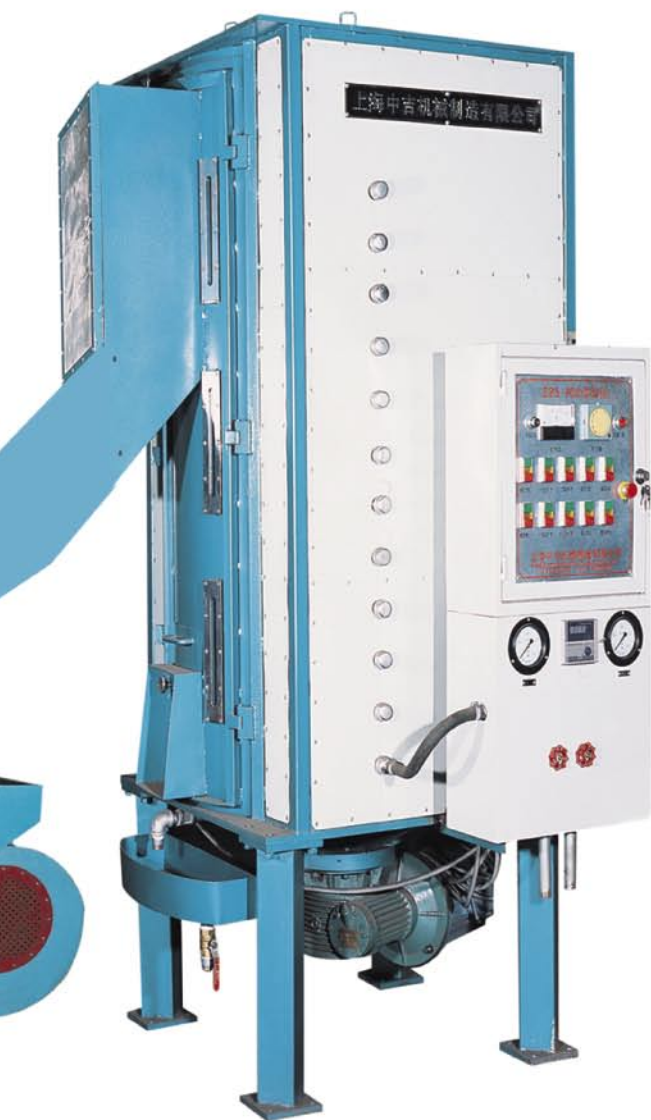
1. Fluidized bed is the attached part of pre-expander. Warm air curtain, produced by high pressure fan and heat exchanger in the fluidized bed, dialyse the expanded EPS beads.
2. Improve the further expansibility, welding and elasticity of the beads in the molding process.
3. Fix in with batch pre-expanders, LH-1200 or LH-1600 have 75℃ inside, installed vibratory sieve, shattering blocks and transporting fan.



主要规格和参数

Main Specifications & Parameters

序号 Number	项目 Items	单位 Unit	LH-900	LH-1200	LH-1600
1	蒸汽入口口径 Steam Inlet DN	mm	25	25	40
2	总电机功率 power	mm	5	6.6	12
3	最大外形尺寸 Max. Contour Size	mm	5800X1000X1200	6500X1000X1200	6500X1500X1820
4	整机重量 Machine Weight	kg	650	700	1800

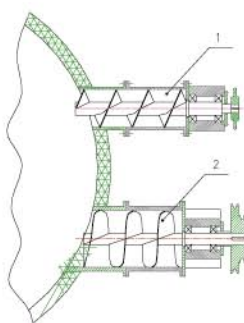


主要特点

1. EPS珠粒通过上料、发泡，进入流化干燥床（客户可选配），再通过风机输送装置，进入熟化料仓，完成了珠粒发泡的自动循环过程；
2. 机器进料系统包括一次进料装置和二次进料装置，一次进料装置通过变速器调节进料速度，二次进料装置通过移动导轨和风管式吹料降温方式保证进料稳定；
3. 自动负压上料装置由光电开关控制料位，实现了自动上料（客户可选配）。

Main features

1. EPS beads enter the fluidized beds (optional) through charging material and expansion, then go into the aging silo through transporting fan to finish their auto-cycle expansion.
2. Feeding system includes the first and second feeders.
3. Photoelectric switch controls the level of material in the auto-feeder of negative pressure to realize auto feeding (optional).



- 连续式预发泡机一次、二次进料装置
The first and second feeders of Continuous Pre-expander.
- 1. 一次进料装置: the first feeder
- 2. 二次进料装置: the second feeder

主要规格和参数

Main Specifications & Parameters

序号 Number	项 目 Items	单位 Unit	型号 Type	YF-900	YF-1200
1	预发筒体尺寸 Chamber Size	筒直径 Diameter	mm	900	1200
		筒体高 Height	mm	2000	2200
2	生产效率 Capacity	kg/h		250-400	300-500
3	蒸汽入口口径 Steam Inlet DN	mm		25	25
4	压缩空气入口口径 Air-Compressed Inlet DN	mm		20	20
5	蒸汽压力 Steam Pressure	Mpa		0.6	0.6
6	压缩空气压力 Air-Compressed Pressure	Mpa		0.6	0.6
7	搅拌电机 Agitation Motor	功率 Power	kw	5.5	6.8
		转数 Rotation	r/min	96	96
8	最大外形尺寸 Max. Contour Size	mm		2050 × 2900 × 2750	2800 × 1350 × 2850
9	整机重量 Machine Weight	kg		1500	1800

EPS Crusher & Recycling System

Main features

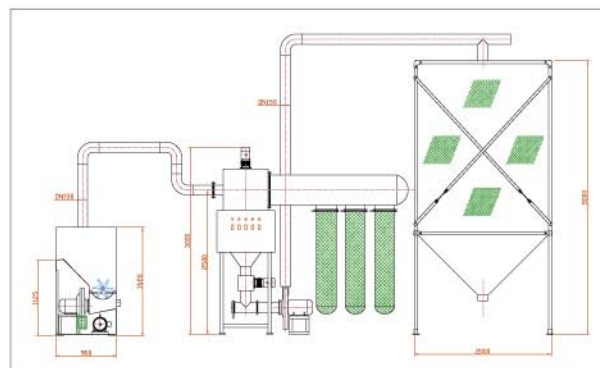
1. 机器适用于制品生产厂的边角料、报废料或回收料;
2. 机器将EPS块料在连接部位分开, 经过破碎、筛分的颗粒粒径均匀、饱满, 粉尘少。与新鲜的预发颗粒混合后再次成型, 制成各种规格的EPS制品。
3. EPS粉碎机与EPS粉尘筛选设备和新旧料比例混合设备(客户可选配)配套, 形成完整的EPS回收装置。

1. Using in EPS recycling.
2. Separate the EPS block at the joint, making the beads uniform, filled, dustless through crushing and sieving. Mix with new beads to remold and reproduce EPS products of any size.
3. EPS crushers can be optionally attached with EPS sieving devices, composing the integral EPS recycling system.

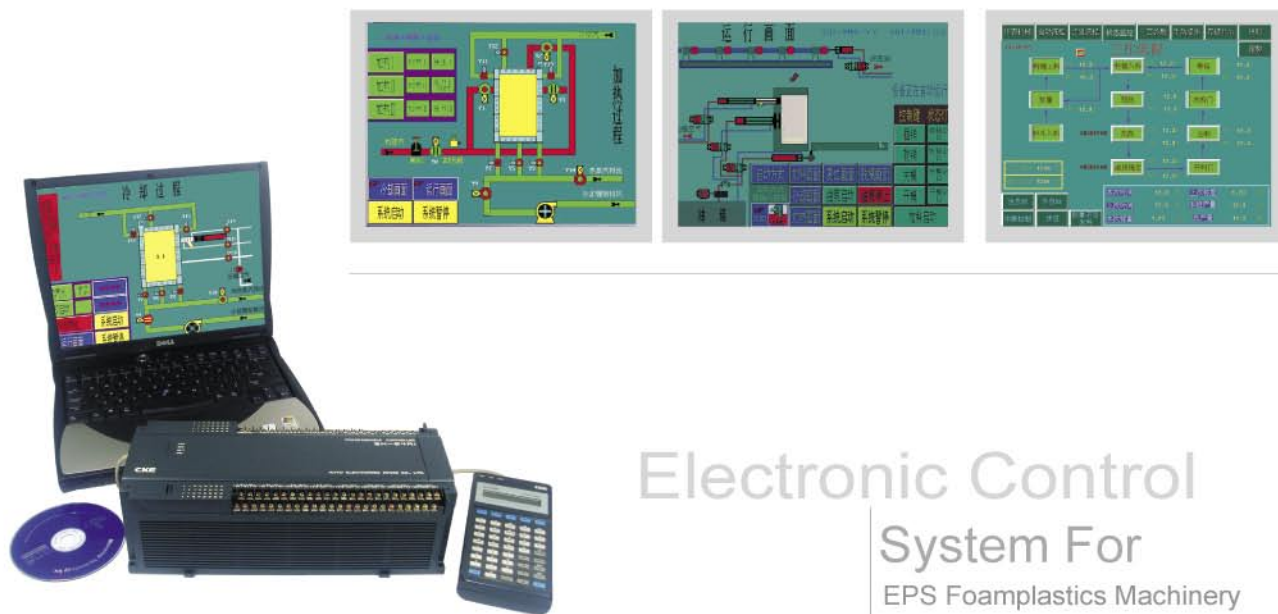


Main Specifications & Parameters

序 号 Number	项 目 Items	单位 Unit	crusher PS-B
1	破碎效率 Capacity	m ³ /h	25-30
2	碎粒直径 Diameter of beads smashed	mm	4-10
3	总电机功率 Power	Kw	4,5
4	最大外形尺寸 Max, Contour Size	mm	600X900X1600
5	整机重量 Machine Weight	kg	600



EPS回收系统
EPS Recycling System



Electronic Control System For EPS Foamplastics Machinery



人机界面能取代传统控制面板功能,可节省PLC的I/O模组、按钮开关、数字设定、指示灯等且能随时显示重要讯息,以利于操作人员正确掌握机器状况和避免错误,利于维修。

人机界面能储存255幅画面,每一画面可由文字、图形及指定的PLC资料组成,设计者可依需要编辑出各种画面,用以显示设备状态、操作指示、参数设定、动作流程、统计资料、警报讯息、简易报表等。

The functions of the touchable screen are both to show all information and to adjust all data, the old controller board to be replaced. By touchable switch, through signal light, following data changing, worker can operate accurately; avoid wrong operating as using old PLC, I/O board.

255 pictures, going with data, diagram, explanation in words, and specific inference date of PLC, have been stored in the computer, by the pictures, the user can renew data, check the machine in what state, project the working procedures, statistics data, warn, report and print, etc.

EPS 泡塑机械零部件

公司及驻外办事处常年为EPS用户提供EPS泡塑机械零部件、专用液压件、电子电器配件及各种易损易耗件。
Our company provides EPS foamlastics machinery parts, hydraulic pressure parts, and easy going old parts, etc.

P

arts and Hydraulic Pressure Parts for EPS Machinery



EPS成型机专用排水阀
draining value for the
shape molding machine



EPS成型机专用全自动加料枪
automatic feeding guns for
the shape molding machine



EPS成型机专用连接件
connecting parts for the
shape molding machine



EPS成型机专用连接件
connecting parts for the
shape molding machine



电接点电压表
electric contact manometer



角座阀
angle value



电磁换向阀组
reversing solenoid valve group



液压电磁阀
hydraulic solenoid valve



先导式电磁阀
solenoid valve



电接点压力表
electric contact manometer



气塞
air lock



数显时间继电器
number-shown time relay



气动蝶阀
pneumatic butterfly valve



气动三联件
pneumatic trinity



气动电磁阀
pneumatic solenoid valve



比例阀
aeljusting value



EPS板机专用全自动加料枪
automatic feeding gun for
the block molding machine



预发机螺旋送料装置
spiral feeding attachments
for pre-expanders



预发机用蜗轮蜗杆减速机
turbine worm speed reducer
for pre-expanders



调压器
aeljusting transformer



EPS板材切割专用电阻丝
wires for EPS block cutting



行星轮减速机
planet wheel speed reducer



切割机用蜗杆减速机
worm speed reducer for
the cutting machines



蒸汽减压阀
steam reducing valve

本公司在此郑重承诺：凡本公司售出的设备，都实行“三包”服务，免费为用户指导安装、调试设备及维修、操作人员的培训；并提供设备安装使用技术要求、工艺布置图等相关资料，终身提供维修及配件的供应。具体措施如下：

一、设备指导安装及调试：协助和指导用户根据实际情况协调设备的布局，合理安排总体安装位置的规划，指派技术人员指导设备安装、附属设施制作，并向用户提供相关方面的问题解答。

二、操作、维修人员的培训：本公司可根据用户要求免费提供操作、维修人员的培训。

1、设备生产地点培训：用户可派操作、维修人员到本公司学习、接受培训。本公司工程技术人员将从设备结构、工作原理，安装调试技术要求，操作、维修、保养规程等理论着手。通过生产现场对设备进行组装调试，基本掌握维修保养、操作规程。使其有一个初步的认识并了解设备的结构、性能；

2、安装调试现场培训：本公司在为用户安装调试设备时，用户可派员参与。通过安装调试人员的现场指导、培训，使操作、维修人员掌握要领，能够满足生产的要求。

三、本公司产品实行“三包”服务，整机“三包”期为一年。在“三包”期内，免费为用户提供的设备易损零部件及按“三包”要求提供免费维修服务。“三包”期外将按成本价长期提供维修保养及配件供应，并按用户要求以最快的速度送到用户手中。设备一旦发生故障用户无力排除，本公司将按用户要求派员以最快的速度赶到现场，及时为用户排除故障恢复生产。

四、本公司将与时俱进、开拓创新，不断研发新技术、新产品，积极改进、提高现有产品的结构、性能及质量，以满足用户的需求。当产品更新换代、有重大改进时，本公司将及时为用户提供信息。根据用户要求，本公司可按成本价为用户提供设备改造以满足要求。本公司以企业的信誉担保，将以认真负责的态度，为用户提供优质的售后服务，为用户正常生产提供强有力的保障。

We know only the best quality and top service offered can give you more confidence to be our customers. For it the offering we have is aiming the further best, even we have done well.

1. You will get all projects of how to establish EPS factory after your ask, including the preparing, designing, and training of stuffs, we do all in one package after you make up your mind to manufacture EPS.

2. Free service for fix any machine brought for 1 year, some easy getting old parts going with machine for renewing, which are good enough for 1 year use.

3. The questions and problems can be resolved and returned to you immediately.



www.zhongji.com



上海中吉机械制造有限公司

Shanghai Zhongji Machinery Manufacturing Co.,Ltd.

地址：上海市青浦区重固工业区新丹路368号

Add: No.368 Xindan Road, Qingpu Industry District,
Shanghai, China.

电话/Tel: 86-21-68453855 13916868669

传真/Fax: 86-21-50453855

服务热线: 86-21-28105137

E-mail: epsmachinery@hotmail.com

www.zhongji.com

吉林省清华科技有限公司

Jilin Tsinghua Science & Technology Co.,Ltd.

地址：长春市团山街5号

Add: No.5 Tuanshan Street, Changchun.

电话/Tel: 86-431-5912795

传真/Fax: 86-431-5912799

E-mail: info@foameps.com

www.foameps.com

