

## ① 造粒 Pelletizing Process

中空建筑模板的品质控制对原料要求较高，需要在挤出塑化过程中确保配方体系中的助剂和填充物料在挤出过程中分散均匀，我们自主研发了超高扭矩的双螺杆高产量填充改性造粒装备及一步法完成配混挤出成型，通过设备螺杆元件及组合的优化设计，秉承经济、节能、环保的同时，又保证高分子材料在塑化过程中，充分保留了高分子材料的物理化学特性，从而得到品质稳定的模板原料。

The quality control of the hollow building template board has high requirements on raw materials, and it is necessary to ensure that the additives and filling materials in the formulation system are evenly dispersed during the extrusion process. We independently developed a high-torque twin-screw high-output filling and modifying granulation equipment and one-step method to complete compounding and extrusion forming, through the optimized design of the screw elements and combinations of the equipment, while adhering to economy, energy saving and environmental protection, it also ensures that the physical and chemical characteristics of high polymer materials are fully retained during the plasticization process, so as to obtain board raw materials with stable quality.



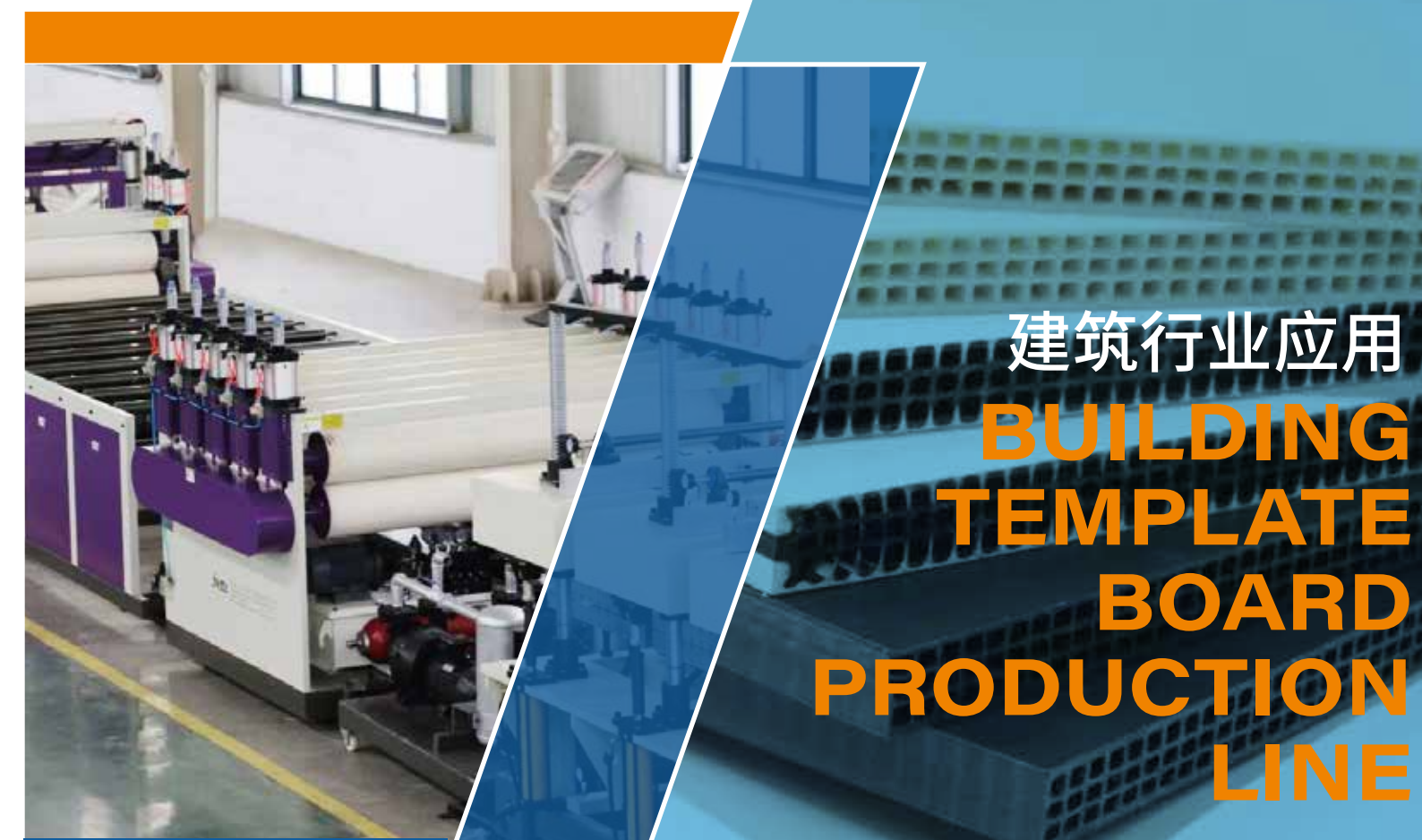
### 主要技术参数 Main technical parameters

机型Model	长径比L/D	转速Speed	参考参量Capacity for reference
CJWV77	36-56	400-900rpm	2000-3000kg/h
CJWH95	36-56	400-900rpm	3000-3500kg/h

设备生产稳定，可以根据客户的需求开发多种多样尺寸的制品  
Stably extrusion line, and products of various sizes can be developed according to customer's requirements

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8+ 个制造基地 Manufacture bases  
500+ 项发明专利 Patents  
1,000,000m<sup>2</sup> 工厂面积 Plant Area



80年代初 金海螺第一代螺杆研制成功  
In the early 1980s, the first generation screw of JINHAILUO was successfully developed

1997 上海金纬机械  
Shanghai JWELL Machinery

2008 苏州金纬机械  
Suzhou JWELL Machinery

2012 常州金纬机械  
Changzhou JWELL Machinery

2018 贝克威尔(泰国)  
Bkwell (Thailand)

2019 浙江金纬智能装备  
Zhejiang JWELL Machinery

2020 金纬公司业绩突破50亿人民币  
Jwell's annual sales exceeded CNY 5 billion

2021 滁州金纬机械  
Chuzhou JWELL Machinery

2022 连续11年荣获中国塑料机械挤出行业排名首位  
Ranked first in China's plastic machinery extrusion industry for 11 consecutive years



## ② 建筑模板挤出 Construction Board Extrusion Process



PP建筑模板生产线  
PP BUILDING TEMPLATE BOARD  
PRODUCTION LINE

### 建筑模板生产线的特点 The characteristics of the building plate production line

在传统915mm单出生产线的基础上，经过不断创新，不断验证后，推出的全新产品，在满足大产量，低能耗的同时，把产品质量的稳定性做到最佳，生产线挤出产量：900~ 1000张/天。  
 ◎双机共挤生产线产品表面的阻燃层均达到欧盟认证EVO, V1,V2等各种不同等级要求。  
 ◎模具、定型板以及冷却系统和真空系统的独特设计保证高速度的挤出定型；耐磨性、定型性好，更易操作。  
 ◎通过两段式组合牵引机设计，可有效控制产品的平整度，可以降低每次开机产生的不合格产品。  
 ◎特殊的切割设计，可以最大限度的减少产品端面的毛边；针对PP原料改进型的锯齿，切割时锯屑不会粘结；产品的自动定长功能，方便人员操作，切割精度高。

On the basis of the traditional 915mm single production line, after continuous innovation and verification, the new product is launched to meet the needs of large capacity and low consumption. At the same time, the stability of product quality is the best. The output of the production line is 900-1000 pcs sheets per day.  
 ◎The fire-proof layers on the surface of the products produced by the two-machine co-extrusion production line all meet the requirements of different grades such as VO, V1, V2 and so on.  
 ◎The unique design of die, calibration plate, cooling system and vacuum system ensures high-speed extruding, good wear resistance, shaping and easy operation.  
 ◎Through the design of two-stage combined haul off unit, the smoothness of products can be effectively controlled, and the unqualified products produced by each start-up can be reduced.  
 ◎Special cutting design can minimize the rough edge of the product; for the improved sawtooth for PP raw material, sawdust will not stick when cutting; automatic length counting function of the product.

### 主要技术参数 Main technical parameters

机型 Model	JWS130 (80) -1500	JWS150 (80) -2000
适用原料 Material	PP改性料 modified material	PP改性料 modified material
制品宽度 Products width	915/1220mm	915mm*2 (一模双出)
制品厚度 Products thickness	15-17mm	15-17mm
挤出机规格 Extruder specification	JWS130/35 JWS80/35	JWS150/35 JWS80/35
最大挤出量 Capacity (Max)	450~500KG/H	600~650KG/H

## ③ 建筑塑料模方挤出 PP Profile Extrusion Process

塑方是替代传统木方的新型高分子材料，通过特殊的挤出成型工艺，塑方可以满足在现场使用过程中对握钉力的要求，塑方可以反复循环使用，产品具有防水，防霉变，不变形等特点。与传统的木模方不同，PP建筑模板可以搭配塑方进行安装。塑方型材的生产是用单螺杆型材挤出生产线，也可以做共挤。

PP profile is a newly designed polymer material which replace traditional wooden profile. By adopting special extrusion process, PP profile can meet the requirement of nail-holding ability. PP profile can be recycled used, and has the characteristic of water proofing, Mould proof, no deformation, etc. Different from the traditional wooden profile, PP construction board can be installed on PP profiles. The production for this profile is very simple by using single screw extruder or sometimes with co-extrusion.



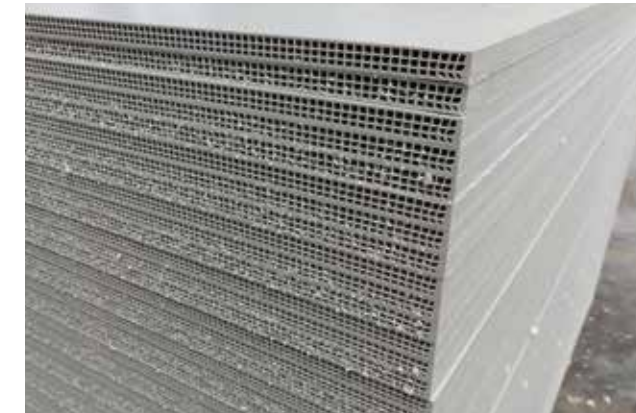
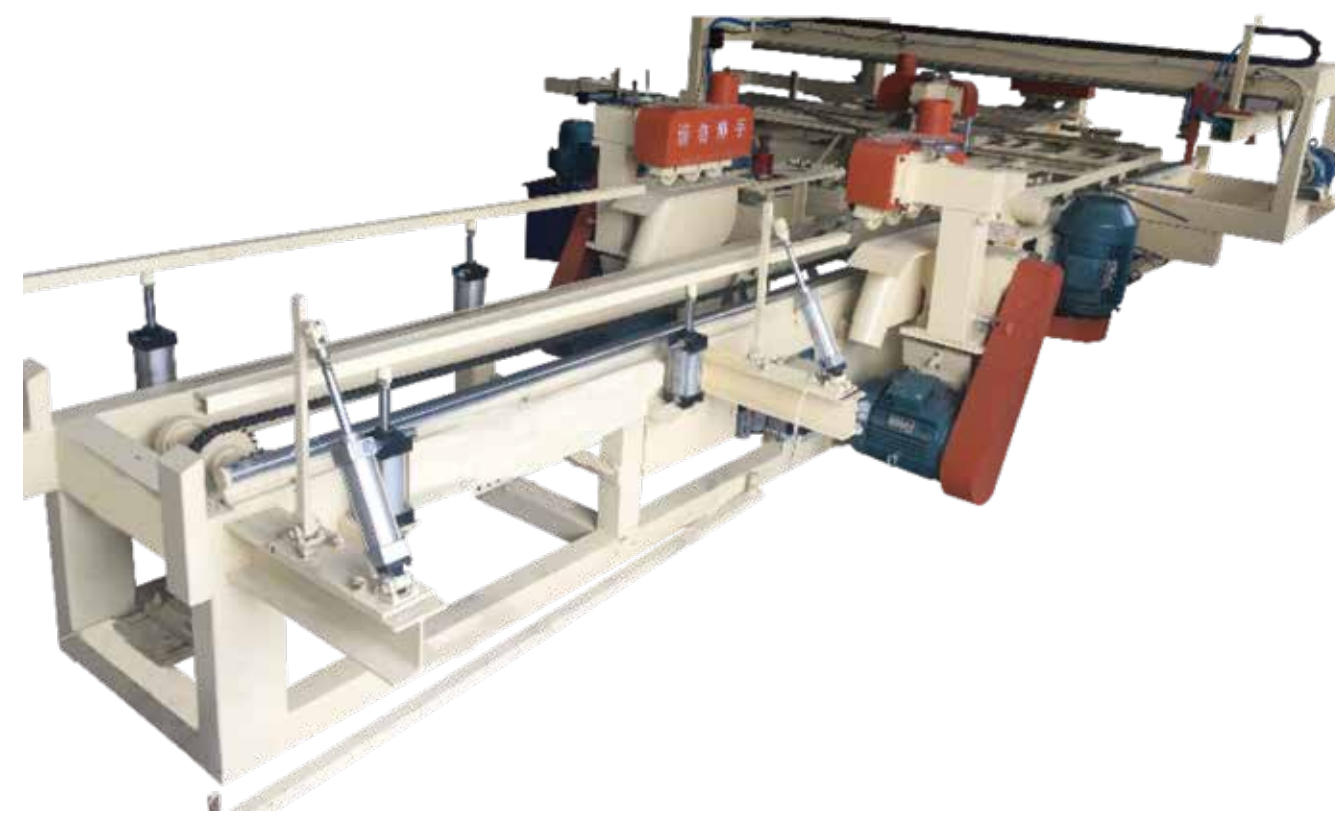
### 主要技术参数 Main technical parameters

机型 Model	YF50	YF108	YF180	YF240	YF300
制品最大宽度(mm)	50	108	180	240	300
主机型号 Extruder model	JWS 45	JWS 50	JWS 65	JWS 90	JWS 120
驱动功率(kw)	15/11	22/18.5	30/22	55/45	90/75
冷却水用量(m³/h)	4	4	5	7	7
压缩空气用量(m³/min)	0.5	0.6	0.6	0.6	0.6

## ④ 四边锯修边 Edge Cutting Process

模板在放置一段时间后，会有一定的收缩，需要进行精确修边，以达到对角线，平行度，直线度符合施工要：915x1830mm(3/6尺)；1220x2440mm(4/8尺)。修边锯可以实行全自动操作，自动上板，自动码垛，只需要人工使用叉车将板材叉至指定位置即可。

After a certain period, PP construction boards may have some shrinking. Therefore need to do the precise edge cutting, so that the diagonal catercorner, balance can meet the construction requirement: 915x1830mm(3/6inch); 1220x2440mm(4/8inch). Edge cutting machine can be automatic: automatic board loading, and automatic stacking. After stacking, only use the forklift to move the boards away.



## ⑤ 破碎清洗回收 Waste Recycling Shredding And Washing Process

建筑模板专用破碎机，清洗机，主要针对该产品研发设计的专用机型。采用专用的主轴，独特的投料斗形式，方便托盘以及宽幅板材制品的送入。宽幅制品无需分切，减少回收工序，节约能源，减少劳动强度，降低成本，提高粉碎回收效率。

PP construction board crusher and washing line, is mainly used for crushing wide but thin plastic board products. It has a designed with main shaft and unique feeding hopper, which is easy to feed trays and wide plate products in. Wide products do not need to be cut, which spares the recycling process, saves energy, reduces labor intensity and cost and improves the efficiency of pulverization and recycling.



## ⑥ 安装应用 Application

PP中空建筑模板被广泛应用在建筑工地施工中，安装时，除了和传统的木方组合使用，还可以与铝合金框架和塑方组合使用。

PP construction board is widely used in building site. When doing the installation, except for combination usage with traditional wooden profile, it can also do the combination usage with plastic profile.

