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玮祥坤硕机械 (南通)有限公司
WELLSHYANG KUNSHUO MACHINERY(NANTONG) CO., LTD.



苏州坤硕机械有限公司
SUZHOU KUNSHUO MACHINERY CO.,LTD.

公司简介 ABOUT US

玮祥坤硕机械(南通)有限公司(苏州坤硕机械有限公司)是一家专业从事橡胶精密预成型机及辅助冷却输送机设备的设计、研发、生产企业，并通过ISO9001:2015 质量体系认证和CE认证。我们拥有专业橡胶机械制造及维护的技术团队，多年累积丰富的橡胶机械行业经验，学习日本等国外在橡胶机械设计和制造方面的先进理念及经验，力求为客户提供品质精良符合生产需求的机器。

我们坚持认真用心做好每一台设备，认定品质改进是企业发展的动力源泉，提供最优质的产品让用户认识其价值，为用户提供最专业的橡胶预成型技术解决方案和及时、专业、高效的技术服务支持，以此获得用户的认可。

WellShyang Kunshuo Machinery(Nantong) Co.,Ltd. (Suzhou Kunshuo Machinery Co.,Ltd.) specializes in design, research and development, production for rubber precision preformer and auxiliary cooling conveyor, and has obtained the ISO9001:2015 quality system certificate and CE certificate. We have qualified, dedicated and outstanding technical team with plenty of experiences in professional rubber machinery manufacturing and maintenance, accumulating extensive experience in rubber machinery industry, studying advanced concepts and experience in rubber machinery design and manufacturing from foreign countries such as Japan, strives to provide customers with good quality machine which can meet the production requirement.

We insist in manufacturing each equipment earnestly, and recognize that quality improvement is the power source of enterprise development, to provide the best quality products to make the users know its value, to provide users with the most professional rubber preforming technology solutions and timely, professional and efficient technical service support, to gain users' acceptance.

我们的主要产品包括:

- 精密预成型机
- 冷却输送机
- 滤胶机
- 开炼机自动翻胶装置
- 其他客户定制机型

OUR MAIN PRODUCTS INCLUDE:

- Precision Preformer
- Cooling Conveyor
- Rubber Strainer
- Auto Blender for Mixing Mill
- Other Customized Machines

资质认证 QUALIFICATION



专利证书 PATENT

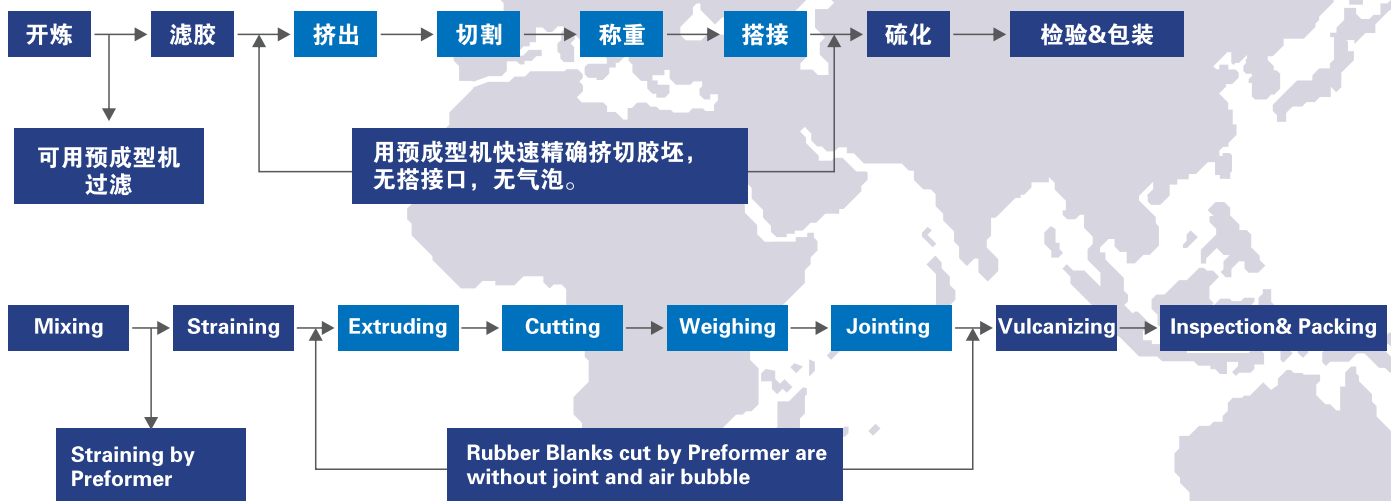


JYZ 精密预成型机 JYZ PRECISION PREFORMER

精密预成型机是一款高效率、高精度的胶坯生产设备。胶料适应性强，如硅胶、天然胶，丁腈胶及氟胶等所有橡胶原料，能挤出各种环形、矩形、条形以及异形的胶坯。特别适合生产密封件、油封、气门嘴、瓶塞、网球、鞋底、摩擦片等产品。它集抽真空、过滤、挤出、切割、称重、计数等多种功能于一体。

Precision Preformer is a type of rubber blank manufacturing equipment with high efficiency and high accuracy.

It can process a wide range of all rubber material including silicone, Natural rubber, NBR and FKM compound etc. It is able to extrude rubber blanks of circular, rectangle, strip and odd shapes. It is especially suitable to produce sealing, oil seal, tire valves, bottle stoppers, tennis balls, shoe soles and friction lining, etc. It integrates a variety of different functions such as vacuuming, filtrating, extruding, cutting, weighing, counting, etc.



主要应用领域

1、汽车业，摩托车业

- ◆ 高精度密封件、油封及垫片等
- ◆ 减震件
- ◆ 雨刮器
- ◆ 小型橡胶轮
- ◆ 橡胶膜片，垫圈
- ◆ 摩擦片

2、鞋业

- ◆ 鞋底
- ◆ 鞋跟

3、运动休闲业

- ◆ 网球
- ◆ 高尔夫球
- ◆ 板球
- ◆ 海绵球

4、其他一般橡胶制品

- ◆ 造粒
- ◆ 原材料过滤
- ◆ 注射机喂料胶条
- ◆ 电绝缘体硅胶导电管、导电条的挤出
- ◆ 橡胶手柄
- ◆ 热水袋
- ◆ 橡胶连接器
- ◆ 橡胶电插头
- ◆ 医用瓶塞
- ◆ 婴儿奶嘴
- ◆ 胶质类密封条&胶团（橡胶泥）
- ◆ 家用电器的橡胶部件

MAIN INDUSTRIES SERVED

1、Automotive, Motorcycle Industry

- ◆ Precision seals, oil seals and gaskets
- ◆ Anti-vibration parts
- ◆ Windscreen wiper blades
- ◆ Small solid rubber casters
- ◆ Rubber diaphragms & grommets
- ◆ Friction lining for clutches

2、Footwear Industry

- ◆ Soles
- ◆ Heels

3、Sporting and Leisure Goods Industry

- ◆ Tennis balls
- ◆ Golf balls
- ◆ Cricket balls
- ◆ Sponge balls

4、Other General Rubber Goods

- ◆ Pelletizing granules
- ◆ Material screening of all compounds
- ◆ Preparing strip to feed injection molding machines
- ◆ Extruding the silicone conductive tube or gasket for electrical insulators
- ◆ Rubber handle grips
- ◆ Hot water bottles
- ◆ Rubber couplers
- ◆ Rubber electrical plugs
- ◆ Medical bottle stoppers
- ◆ Baby nipples
- ◆ Rubber kind mastics & doughs(rubber mud)
- ◆ Rubber components for domestic appliances

JYZ精密预成型机 (自动型)

特点:

- PLC控制和触摸屏操作界面, 彩色触摸屏方便数据输入, 密码保护.
- 触摸屏上设有实体按钮开关的应急备用按键.
- 电子秤闭路反馈, 自动调整切刀速度控制胶坯重量.
- Rs232接口连接电子秤.
- 可储存1000种产品的工艺数据, 随时调用.
- 故障点图标及文字显示.
- 可靠的安全性: 机头关闭、切刀旋转、柱塞前进和后退均有互锁装置.
- 料筒中心延长, 便于清料.
- 油箱侧有可拆卸清洗盖, 方便清理.
- 正反转不锈钢输送机, 分离初始阶段不合格坯料.



JYZ250 精密预成型机
JYZ250 Precision Prefomer



JYZ200 精密预成型机
JYZ200 Precision Prefomer

JYZ PRECISION PREFORMER (AUTO SERIES)

FEATURES:

- PLC control and touch screen operator interface, convenient to input data, password protection.
- Emergency standby keys on touchscreen for real button switches.
- Weigh scale close loop feedback system for adjusting cutter speed automatically to control blank weight.
- RS232 connection to weigh scale.
- 1000 products technics database available to connect.
- Graphic and text display for failure point and cause.
- Reliable safety performance.
- Interlocks designed for head closing, cutter rotating, and ram moving forward & retract.
- Extended center for easier cleaning.
- Dismountable cleaning cover in side of oil reservoir for easy clean.
- Reversing stainless steel conveyer to separate the incorrect weight blanks at initial phase.



JYZ250H 高压型精密预成型机
JYZ250H High Pressure Type Precision Preformer



JYZ200H 高压型精密预成型机
JYZ200H High Pressure Type Precision Preformer

可选:

- ① 切刀由同步带驱动，噪音低，最高刀速可达400RPM.
- ② 脉冲切刀，伺服电机控制，实现连续及断续切割，刀速为0.5-400RPM.
- ③ 客户可自行提供含有RS232接口电子秤，与预成型机配套使用.
- ④ 柱塞位置由百分比显示.
- ⑤ 条形码扫描.
- ⑥ 伸缩式输送机.
- ⑦ 防粘输送带.
- ⑧ 液压开门，易开关.
- ⑨ 后喂料.

OPTIONAL:

- ① Cutter driven by synchronous belt, lower noise, cutter speed up to 400 RMP.
- ② Pulse cut, serve motor control, Continuous and non-continuous cutting, cutter speed at 0.5- 400 RPM.
- ③ Customers can provide RS232 connection to weigh scale for use with Preformer.
- ④ Ram position displayed by %.
- ⑤ Barcode scan.
- ⑥ Telescope conveyor
- ⑦ Anti-sticking conveying belt
- ⑧ Hydraulic controlled plate, easy to open/close.
- ⑨ Rear load.



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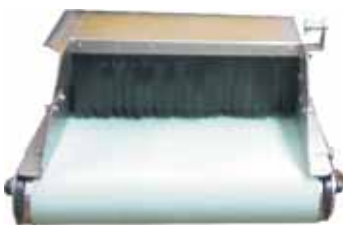
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技术参数
TECHNICAL PARAMETER

项目名称 Items	单位 Unit	JYZ150	JYZ200	JYZ250	JYZ200H	JYZ250H
料筒内径 Barrel inner diameter	mm	150	200	250	200	250
总功率 Total power	kW	16.0	16.0	25.0	22.0	25.0
最大挤出压力 Max. extruding pressure	MPa	36.8	20.7	20.7	40.0	40.0
料筒最高温度 Max. barrel temperature	°C	95	95	95	95	95
口型最大直径 Max. die diameter	mm	125	125	190	125	190
胶坯重量范围 Blank weight range	g	0.3~100	0.3~200	0.3~2000	0.3~200	0.3~2000
胶坯重量精度 Blank weight accuracy	%	±1.0	±1.0	±1.0	±1.0	±1.0
一次装胶量 Single load capacity	kg	13~15	20~30	60~70	20~30	60~70
切刀转速 Cutter speed	r/min	35~300	35~300	23~300	35~300	23~300
外形尺寸(L×W×H) External dimension	mm	4080×1220×1640	4080×1250×1640	5100×1250×1640	4700×1350×1850	5100×1250×1640
机器重量 Weight	kg	2500	2500	3600	4600	5000



操控面版
Control Panel



标配RS232接口电子称
Standard Rs232 Weigh Scale



通用机头
GP Head



鞋模机头
SH Head

JYLZ柱塞式滤胶机 JYLZ RAM RUBBER STRAINER

柱塞式滤胶机可过滤硅胶、丁腈胶、天然胶、丁基胶、氟胶等各种胶料原料。相比螺杆式滤胶机，胶料在过滤的全过程无升温、不焦烧、胶料可添加促进剂之后进行过滤,操作简单，安全性能佳,效率更高。

Ram Rubber Strainer can screen various rubber compounds include silicon, NBR,NR, butyl, and fluorine compound . Compared to screw strainer, it will not have heat up & scorching in the whole screening process, it can screen the rubber compound with accelerants. easy to operate, good safety performance, higher efficiency.



可选:

- ① 触摸屏操作界面.
- ② 柱塞位置百分比显示.
- ③ 后喂料.

OPTIONAL:

- ① Touchscreen operational interface.
- ② Ram position displayed by %.
- ③ Rear load.

技术参数

TECHNICAL PARAMETER

项目名称 Items	单位 Unit	JYLZ150	JYLZ200	JYLZ250	JYLZ200H	JYLZ250H
料筒内径 Barrel inner diameter	mm	150	200	250	200	250
总功率 Total power	kW	14.0	14.0	18.0	18.0	18.0
最大挤出压力 Max. extruding pressure	MPa	36.8	20.7	20.7	40.0	25.0
料筒最高温度 Max. barrel temperature	°C	95	95	95	95	95
一次装胶量 Single load capacity	kg	10~15	20~30	60~70	20~30	60~70
外形尺寸(L×W×H) External dimension	mm	3100×1250×1640	3100×1250×1640	4200×1250×1640	3600×1250×1640	4200×1250×1640
重量 Weight	kg	2200	2200	3300	3300	4300

定长切割输送机 & 收卷装置 LENGTH-FIXING CUTTING CONVEYOR & ROLLING DEVICE

用途:

主要与柱塞式滤胶机配套使用, 将经过滤胶机过滤后的硅胶及其他低硬度橡胶胶条进行定长切割或收卷。

APPLICATION:

Ancillary for ram rubber strainer, to cut or roll silicone or lower hardness rubber strips with fixed length after screening through ram rubber strainer.



LSZ 振动式冷却输送机 LSZ VIBRA COOLING CONVEYOR

振动式冷却输送机是专为解决胶坯粘连、变形、冷却而设计的预成型机配套辅机，该机占地面积小，与胶料接触部位均采用不锈钢材料，防止胶料污染。胶坯通过振动方式行进，有效防止胶料粘连、变形。标准冷却距离长为35米，最长达50米。可通过风冷或喷淋强化冷却效果，重量小的坯料可采用封闭式风冷，重量较大或热量较大的坯料，还可以通过外接水箱进行循环水喷淋冷却，对FKM、NBR、CR、EPDM、造粒、轴承密封件、油封、O型圈等坯料的冷却效果尤为突出。

Vibra Cooling Conveyor is a specifically designed auxiliary machine to avoid the sticking of hot rubber blanks that produced on a precision performer. It is space -saving, the part directly contact with rubber blanks is stainless steel to prevent contamination. Rubber blanks travel through vibratory way to prevent the stickiness and deformation effectively. It is with long cooling distance at 35 meter, the max. cooling distance up to 50 meter. The cooling process can be strengthened by air or spraying water. For small rubber blanks, can use the air cooling with cover; for the heavy weight and much hot rubber blanks, can use circulation water connected with external reservoir to spray water. Especially with prominent cooling effect for FKM, NBR, CR, EPDM, pelleting, bearing seals, oil seals and O-rings etc.

可选:

- ① 冷风机：冷空气冷却。
- ② 封闭式。
- ③ 水冷式斜面输送机:增强冷却效果

OPTIONAL:

- ① Air chiller: chilled air cooling.
- ② Surrounded by a cover.
- ③ Water cooling slope conveyor: Enhance cooling effect.



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LSZ1050振动式冷却输送机与LSZ1250振动式冷却输送机
LSZ1050 Vibra Cooling Conveyor & LSZ1250 Vibra Cooling Conveyor

技术参数 TECHNICAL PARAMETER

项目名称 Items	单位 Unit	LSZ1050	LSZ1250
振动槽直径 Vibration groove diameter	mm	1050	1250
振动槽宽度 Vibration Groove width	mm	245	320
振动槽高度 Vibration groove height	mm	1600	1600
物料输送距离 Material running distance	mm	35000	39000
螺旋节距 Helical pitch	mm	110	1100
进料口宽度 Width of inlet	mm	650	650
进料口高度 (离地面高度) Height of inlet (Off the ground)	mm	300	300
出料口宽度 Width of outlet	mm	220	280
出料口高度 (离地面高度) Height of outlet (Off the ground)	mm	1650	1680
输送速度 (可调) Conveying Speed (adjustable)	m/min	6~8	6~8
振动电机功率 Power for vibration motors	kW	0.75*2	1.1*2
冷却风机功率 Power for cooling fan	kW	3.7	3.7
水泵功率 Power for water pump	kW	0.37	0.37
总功率 Total power	kW	5.6	6.3
外形尺寸(长×宽×高) External Dimension (LxWxH)	mm	2800×1400×2700	2800X1800X3100
重量 Weight	kg	1200	2000

LSS650水冷式冷却输送机 LSS650 WATER COOLING CONVEYOR

水冷式冷却输送机是专为解决胶坯粘连、变形而设计的预成型机配套辅机。

通过冷却水或冷却溶液使胶坯降温，再经过强制风冷，使胶坯不变形、更加稳定。该机特点是全程调节水平不锈钢网带调控运行速度，配合预成型机的所有切割速度。

Water cooling conveyor is a specifically designed auxiliary machine to avoid the sticking of hot rubber blanks that produced on a precision performer. After cooling down with cooling water or cooling solution and forcible cooling wind, the rubber blanks will not become deformed and more table. The feature of the machine is the running speed can be adjusted by the horizontal stainless steel net belt during the whole process, to go with all the cutting speeds of precision preformer.



可选:

- ① 塑料网带，无金属碎屑。
- ② 斜面提升装置，便于清理水箱内橡胶碎屑。
- ③ 喷淋装置。
- ④ 水箱外接冷水机。

OPTIONAL:

- ① Plastic net belt, No metal chips
- ② Elevated device for slope conveyor, easy to clean rubber chippings in reservoir.
- ③ Spraying device.
- ④ Chiller connected with external reservoir.



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精密预成型机与水冷式冷却输送机（带提升装置）配套使用
 Precision Preformer Connected with Water Cooling Conveyor (with lifting device)

技术参数
TECHNICAL PARAMETER

项目名称 Items	单位 Unit	LSS650
斜面输送 (全部采用不锈钢材料) Sloping conveyor (stainless steel material)		
水箱尺寸(L×W×H) Water tank dimension	mm	2000×760×300
料坯浸水距离 Distance of blank conveying (in water)	mm	1300
斜面输送宽度 Slope conveying width	mm	450
斜面输送速度 Slope conveying speed	m/min	7.6
斜面冷却风量 Slope cooling air volume	m ³ /h	3720
水平输送 Horizontal conveyor		
水平输送宽度 Horizontal conveying width	mm	450
水平输送速度 (可调) Horizontal conveying speed (adjustable)	m/min	3.1~6.2
层次 Layers		3
水平冷却风量 Horizontal cooling air volume	m ³ /h	29040
总功率 Total power	kW	2.6
外形尺寸(L×W×H) External dimension	mm	6100×750×1840
重量 Weight	kg	1200

其他冷却装置
Other Cooling Units



皮带输送机
 Belt Conveyor



斜面冷却输送机
 Slope Cooling Conveyor



水箱
 Water Tank

LSS-Q800清理&自动称量水冷式冷却输送机

LSS-Q800 CLEAN-UP & AUTO-WEIGHING WATER COOLING CONVEYOR

LSS-Q800清理&自动称量水冷式冷却输送机是与精密预成型机配套使用的胶料后段冷却，输送，吹干及称重分箱装置。

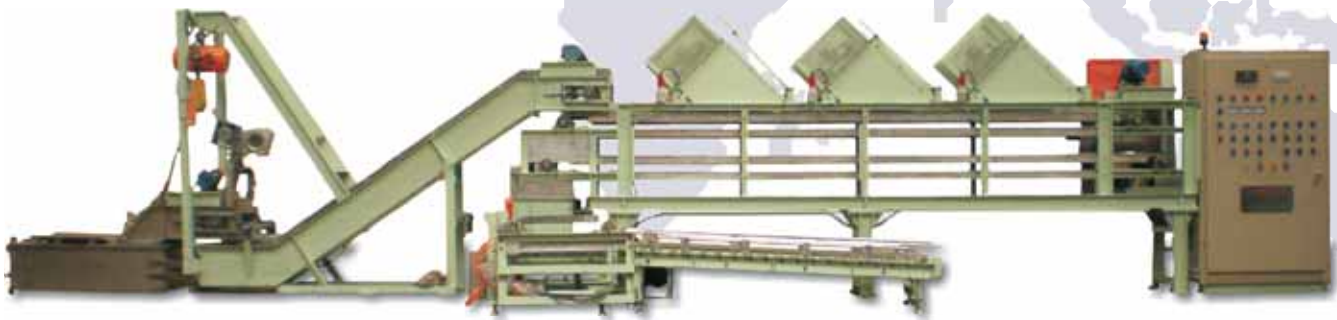
精密预成型机切下的胶料经过LSS-Q800冷却输送机浸水，输送，吹干后由横向皮带输送机送入物料箱。当物料箱内胶料达到设定的重量后，横向皮带输送机停止运行，自动推箱器将满箱的物料自动换成空箱，横向皮带输送机再次运行，达到自动称重，自动分箱，自动换箱功能。

同时，满箱的物料箱被自动输送到辊筒输送线上，由操作人员处理。浸水输送装置可使胶料冷却并防止胶料碎屑相互污染。水箱内有余料箱，方便取出清理。当冷却输送机上无胶料时，空运行5分钟后，即自动停机。

LSS-Q800 clean-up & auto-weighing water cooling conveyor is a specifically designed auxiliary machine to avoid the sticking of hot rubber blanks that produced on a precision performer, which used for cooling, conveying, drying, weighing and sorting rubber compounds into charging-basket.

Rubber blanks cut by precision preformer can be sorted into charging-baskets after dipping into water, conveying, drying then delivered by cross belt conveyor. When the rubber compounds reach the set weight, the cross belt conveyor will stop running, the basket-pushed device will change this full charging-basket with an empty one automatically, and cross belt conveyor will run again to fulfill the functions of auto-weighing, automatic basket-sorting and automatic basket-changing.

Meanwhile, full charging basket will be delivered to roller conveying line, and then operating personnel can deal with it. Water-dipping device facilitates to cool down the rubber blanks and to avoid polluted by kinds of rubber chippings mutually. There is a charging-basket for remaining compounds which is easy to take out and clean up. When there is no rubber compound on the cooling conveyer, it will stop after 5 minutes' automatic dry run.





提升装置
Lifting device



自动称量装置
Auto weighing device

技术参数 TECHNICAL PARAMETER

项目名称 Items	单位 Unit	LSS-Q800
浸水输送速度 Conveying speed in water	m/min	4-8
浸水输送长度 Conveying length in water	mm	1500
斜面输送速度 Slope conveying speed	m/min	3-6
斜面输送长度 Slope conveying length	mm	1500
水平输送宽度 Horizontal conveying width	mm	300
水平输送速度 Horizontal conveying speed	m/min	1.5-3
水平输送长度 Horizontal conveying length	mm	4000
料箱内胶料称重范围/箱(可设定), 超出范围可定制 Blanks weight in per charging-basket(can be set), customized if beyond it.	kg	10~20
配套料箱尺寸 Matching charging-basket dimension	mm	(500-600)*(400-460)*(150-170)
外形尺寸(L × W × H) External dimension	mm	9000x2400x2100
重量 Weight	kg	2000

自动翻炼开炼机

AUTOMATIC MIXING MILL WITH AUTO BLENDER

用途：

自动翻炼到规定时间，不需要人工翻炼胶料，特别是粘度较高的胶种，例如硅胶，效果尤为明显

APPLICATLON:

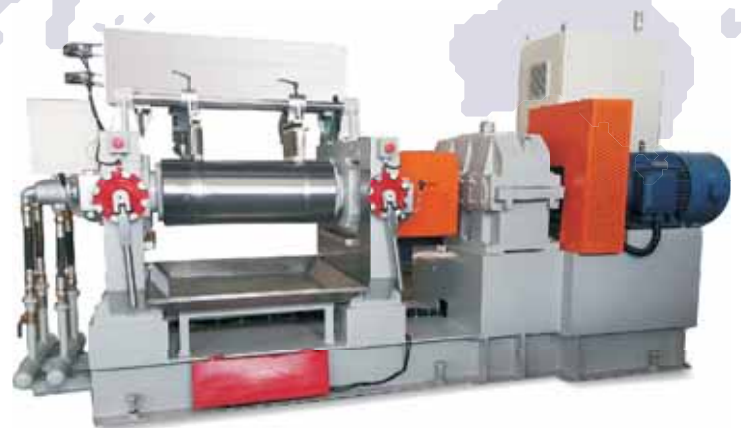
Automatic turning rubber compound with scheduled time , Not by labor. Particularly for rubber compound with high viscosity, More effective for Silicone.

可选：

- ① 挡胶板液压调整间距
- ② 挡胶板快折式结构
- ③ 辊距电动调节（数字显示）
- ④ 主机变频调速
- ⑤ 钻孔式辊筒

OPTIONALS:

- ① Stock guide clearance adjustment by hydraulic.
- ② Stock guide fast folding structure.
- ③ Roll adjustment by electric (Digital display).
- ④ Frequency control speed for main unit.
- ⑤ Drilling type roll.



悬挂式胶片冷却线 HANGING COOLING LINE FOR RUBBER SHEET

用途: 用于将开炼机（螺杆机）压出的温度较高胶片浸泡隔离、冷却干燥。

APPLICATION:

Applied for soaking and isolation, drying and cooling the higher temperature rubber sheet extruded from mixing mill (screw extruder).

结构特点:

由接收输送、浸泡隔离、提升、挂条吹干、出料输送等装置组成。

接收输送与浸泡隔离输送速度可调；

浸泡隔离输送由水泵将隔离液喷射至转动的胶片上冷却；

放置隔离剂的水箱装有搅拌机,防止隔离剂结块；

挂条输送装置由构架、挂杆、链条及导轨构成。

STRUCTURAL FEATURES:

It has receiving and conveying unit, soaking and isolating unit, elevating unit, sheet hanging and drying unit, discharging and conveying unit, etc.

The conveying speed of receiving and conveying unit & soaking and isolation unit is adjustable.

To spray release agent fluid to the running rubber sheet from water pump fit in the soaking and isolating unit;

There is a mixer in water tank where placed release agent, to avoid the caked issue of release agent.

The hanging and conveying unit is constituted of cooling and conveying framework, hanging rod, link chain and guide rail.



技术参数

TECHNICAL PARAMETER

项目名称 Item	单位 Unit	LPX450
适用胶片规格宽度 Applicable rubber sheet specification	mm	<=450
接收运输带速度 Receiving conveyor belt speed	m/min	15~46
挂胶杆数量 Number of hanging rods	根pc	28
胶片最大悬挂高度 Max. hanging height for rubber sheet	mm	1500
冷却风机功率 Cooling wind fan power	kW	0.37×10
最大功率(三相) Max. power (3 phase)	kW	10
浸水输送电机功率 Soaking conveyor motor power	kW	2.2
浸水水泵功率 Soaking water pump power	kW	0.75
搅拌电机功率 Mixing motor power	kW	0.4
挂条电机功率 Hanging motor power	kW	2.2
外形尺寸(长×宽×高) External dimension (L×W×H)	mm	7500×3300×2650
总重量 Total weight	kg	3500

联系我们

玮祥坤硕机械(南通)有限公司 苏州坤硕机械有限公司

地址: 中国江苏省南通市如东县大豫镇大同村45组, 邮编: 226000

电话: 13916602248

邮箱: info@ksmach.com 网址: www.ksmach.com

CONTACT US

WELSHYANG KUNSHUO MACHINERY(NANTONG) CO., LTD.

SUZHOU KUNSHUO MACHINERY CO., LTD.

Add.: 45#Group Datong Dayu, Rudong, Nantong, Jiangsu, China, 226000

Tel.: 0086-13916602248

E-mail: info@ksmach.com www.ksmach.com

