





舟山南海亚塑料机械有限公司
ZHOUZHAN NANHAIYA PLASTIC MACHINERY CO.,LTD

地址(Add): 浙江省舟山市定海区兴舟大道西段502号C区
Block C, No. 2 West Section, Xingzhou Avenue,
Dinghai District, Zhoushan City, Zhejiang Province
电话(Tel): 0580-8835106
传真(Fax): 0580-8835106
手机(M.T): +86-13866163221
邮箱: info@nhyscrews.com
网站(Web): www.nhyscrews.com



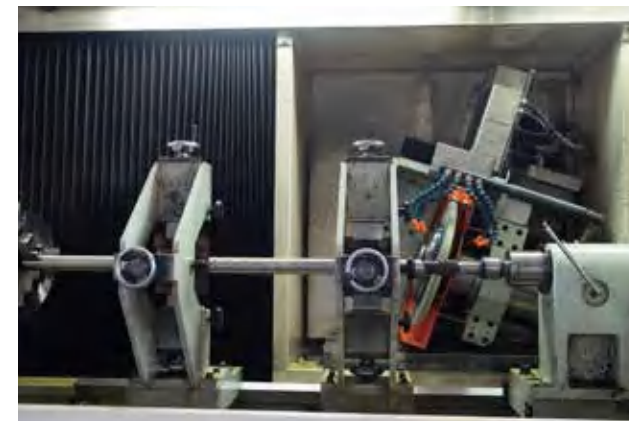
NANHAIYA PLASTIC MACHINERY
舟山南海亚塑料机械有限公司

SCREW BARREL



致力高精度超耐磨机筒螺杆生产
NANHAIYA devotes itself to
producing high-precision
and high wear-resisting screw barrel.

Equipment 设备



企业简介 Company Profile >>

舟山南海亚塑料机械有限公司是国内较早从事精密螺杆和熔胶筒生产的专业制造厂家，公司拥有雄厚的技术力量，先进的生产工艺和设备，集十几年螺杆、熔胶筒制造的经验，引进欧美先进技术和工艺，从事各种螺杆设计；合金喷焊；到各种规格单螺杆；锥形、平行双螺杆；PE木塑、PVC、EVA、TPR、TR、铝塑板、螺杆、机筒等的生产。均具有高水准，高精度，赢得了客户的信赖。

主要产品有：

单螺杆挤出机螺杆、机筒：Φ15-940mm，长径比1:8-1:60系列。注塑机螺杆、机筒：15G-25000G系列。双螺杆挤出螺杆、机筒：Φ25-Φ200系列。单螺杆种类：屏障型、分离型、排气型、销钉型、双头、造粒型、化纤螺杆等。双螺杆种类：普通型、锥型、超锥型、造粒型等。

公司生产的各种螺杆机筒均采用38CrMoAlA合金钢制造、经过调质定性、精加工、表面氮化处理、电镀、螺杆表面喷涂双合金。使产品具有高耐磨、耐腐蚀，提高寿命等特点，能替代进口产品。公司产品长期为各大中型企业塑机配套，产品质量指标及技术参数均达到或超过国家标准。

公司宗旨：质量为本，信誉至上，精益求精，热忱欢迎新老客户垂询惠顾。

Zhoushan Nanhaiya Plastic Machinery Co.,Ltd is a professional manufacturer that engages in producing precise screw and barrel for several decades. With abundant technical power and advanced production process and equipment, the company integrates with years of experience in manufacturing screw and barrel, introduces advanced European and American technologies and processes, and engages in various screw, alloy spraying welding, single screw of different specifications, coned and parallel twin screw, PE wooden plastics, PVC, EVA, TPR, TR, aluminum plastic panels, screws, and barrels. These products receive trust from clients for high level and high precision.

Main products include:

Single screw extruders' screw and barrel: φ 15-940mm; Length-diameter ratio 1:8-1:60 series.

Injection molding machines' screw and barrel: 15G-25000G series.

Twin-screw extruders' screw and barrel: φ 25-φ 200 series.

Single screw categories: screen type, separated type, exhausting type, dowel type, double-end type, pelleting type, and chemical fiber screw.

Twin screw categories: ordinary type, cone type, hypercone type, and pelleting type.

Various screw machine cylinders produced by the company apply 38CrMoAl A alloy steels. Through tempering qualitative processing, finish machining surface treatment in nitrogen, electroplating, and double alloys sprayed on the screw surface, the products are featured with high abrasion resistance, corrosion resistance and long lifetime and can replace import substitutes. The company's products are supporting for plastic machines of large and medium-sized enterprises. The product quality indexes and technical parameters reach or surpass the national standards.

The company aim: with quality orientation, credit first, and excellence, the company sincerely welcomes all clients to inquire and patronize relevant business.

Enterprise honor

企业荣誉



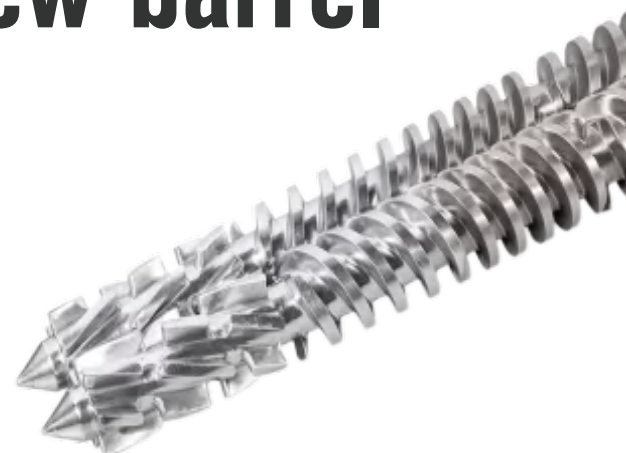
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Conical twin screw barrel

锥形双螺杆机筒



产品技术指标 Product technical index

- 1、国产38CrMoAlA材质，经调质氮化处理，表面硬度HV860-1000，氮化深度0.5-0.8mm，脆性≤2级。
- 2、进口高强度合金钢材质，螺杆易损部位等离子堆焊镍基、钼基合金1-1.5毫米厚，使用寿命提高1.5倍以上。

1. Nitrided screw and barrel:

Material: 38CrMoAlA

Surface hardness: HV860-1000

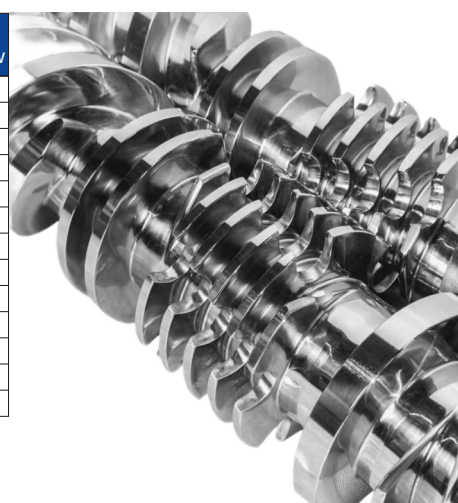
Nitriding depth: 0.5-0.8mm

2. Bimetallic screw and barrel

产品规格 Product specifications

螺杆规格(d/D) specification	工作长度(mm) Working length	挤出能力(Kg/h) Extrusion ability	螺杆转速(rpm) Rotation speed of screw
Φ35/Φ77	810	40-70	5~50
Φ45/Φ90	990	50-80	5~45
Φ50/Φ105	1070	100-150	4~45
Φ51/Φ105	1220	100-150	4~45
Φ55/Φ110	1220	120-180	4~40
Φ60/Φ125	1320	150-200	4~40
Φ65/Φ120	1440	200-250	4~40
Φ65/Φ132	1440	200-250	4~40
Φ70/Φ140	1460	220-300	4~40
Φ75/Φ150	1480	250-300	4~35
Φ80/Φ143	1800	300-360	4~35
Φ80/Φ156	1660	300-360	4~35
Φ92/Φ188	2000	400-500	4~35

合金层
Bimetallic alloy layer



Conical twin screw barrel

锥形双螺杆机筒



Parallel twin screw barrel

平行双螺杆机筒

通用材质 Common steel

材质 Steel: 38CrMoAIA
调质硬度 Heat treatment hardness: HB260° ~ 320°
氮化硬度 Nitriding hardness: HV950° ~ 1000°
氮化深度 Nitriding depth: 0.50~ 0.7mm
氮化脆性 Nitriding brittleness: ≤二级 grade 2
表面粗糙度 Roughness: Ra0.4
螺杆直线度 Screw straightness: 0.015mm
氮化后表面镀铬硬度 Chrome plating hardness: ≥950HV
镀铬层厚度 Chrome thickness: 0.05 ~ 0. 10mm
合金深度 Bimetal depth: 1.0 ~ 2.0mm
双合金硬度 Bimetal hardness: HRC56° ~ 65°



特殊材质 special steel

热作钢 hot processed steel: 1.2344、H13、 W360、 SKD61、
冷作钢 cold processed steel: 1.2379、 K340、 D2、 DC53、 SKD11、 W110
高速钢 HSS: 1.3343、 1.3243、 SKH51、 SKH55、
HIP粉末高速钢 HIP powder HSS : CPM9V、 SK739、 SK726、 SK742、 GH113
牙顶 PTA 合金 PTA alloy: 螺杆牙顶司太立等离子合金焊接, 合金种类: 钴基、镍基、铁基合金
Screw flight top use Stellite plasma alloy welding, alloy types: cobalt base,nickel base, iron base alloy.
料管镶套合金 Barrel alloy layer: 料管采用离心浇铸合金内孔, 过盈热套工艺, 合金种类: 钴基、镍基、铁基合金
Barrel use centrifugal casting alloy inner bore, shrinkage fit technology. Alloy types: cobalt base ,
nickel base, iron base alloy.

型号model	长径比L/D	PVC产量(kg/h)PVC output capacity	螺杆转速(rpm)screw rotation speed	传动功率(kw)driving motor	螺杆直径(mm)screw dia
NHY75	26-36	220-350	45	45	75
NHY90	26-36	280-460	45	55	90
NHY110	26-36	350-650	45	75	110
NHY120	26-36	500-800	45	110	120
NHY130	26-36	680-1000	45	132	130

Parallel twin screw barrel

平行双螺杆机筒



平行双螺杆常用型号 Common size of parallel twin screw
螺杆直径 screw dia: Φ60~Φ150mm
长径比 L/D ratio: 1: 20~30

Extruder screw barrel

挤出机螺杆机筒



产品技术指标 Product technical index

常规材料 Conventional materials: 38CrMoAlA SKD61 Cr12MoV SACM645 Ni

基合金 GH13氮化硬度 Nitriding hardness: HV900-1000

氮化深度 Nitriding depth: 0.5-0.8mm

淬火硬度 Quenching hardness: HRC55° - 62°

氮化脆度 Nitriding embrittlement: ≤二级

表面粗糙度 Nitriding embrittlement: Ra0.4

螺杆直线度 Straightness of screw: 0.015mm

氮化后表面镀铬硬度 Hardness of chromium plating: HV≥950HV

镀铬层厚度 Thickness of chromium plating layer: 0.05 ~ 0.10mm

合金深度 Alloy depth: 0.8 ~ 2.0mm

产品规格 Product specifications

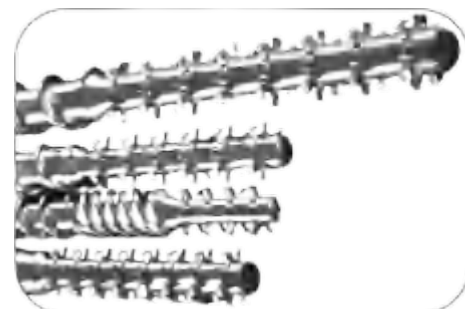
规格(specification): Φ15~Φ300

长径比(ratio of length to diameter): L/D=15-53

螺杆可选用普通型、渐变型、突变型、屏障型、销钉型、DIS开孔风流型、排气型、BM型、分离型螺杆。压缩比可按用户要求进行制造，螺杆头数可以单头或多头。机筒可选择开槽进料系统分式等，并可代为设计。

The screw can be ordinary type, gradual change type, mutation type, barrier type, pin type, dis air flow type, exhaust type, BM type and separate type screw.

The compression ratio can be manufactured according to the requirements of users, and the number of screw heads can be single or multiple. The machine can choose slotting and strong feeding system, and can be designed instead.



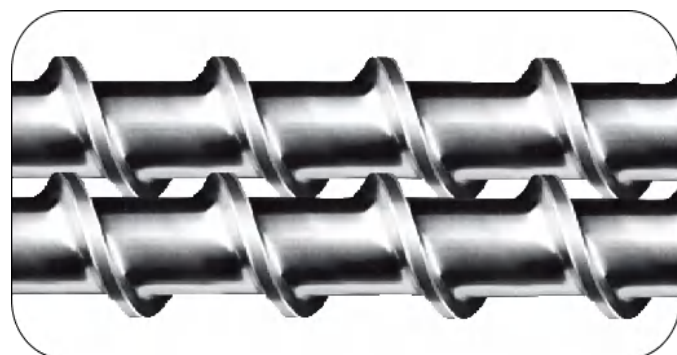
Extruder screw barrel

挤出机螺杆机筒



Bimetallic screw barrel

双合金螺杆机筒



用途区分:

各种立式、卧式射出机、挤出机、注塑机、电木机、橡胶筒、吹膜机等。

产品应用范围:

适用于LCP, PA+GF, PET+GF, PBT+GF, PC+GF等各类塑料添加玻璃纤维,防火剂, 碳粉及PPA, PPO, LCP,磁粉, PC等特殊工程塑胶。

加工范围:

双合金螺杆: 外径: $\Phi 15\text{mm}-\Phi 360\text{mm}$; 有效长度: 10000mm

双合金料管: 内径: $\Phi 14\text{mm}-\Phi 200\text{mm}$; 有效长度: 6000mm

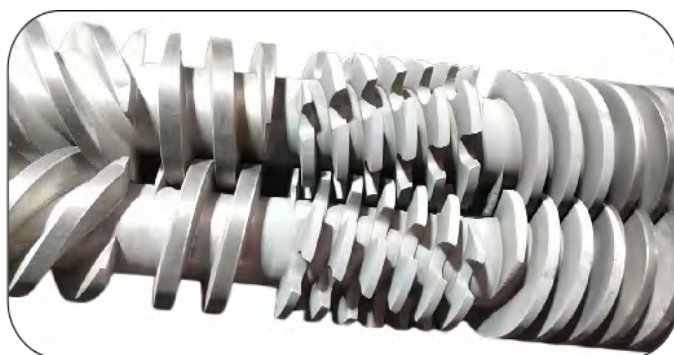
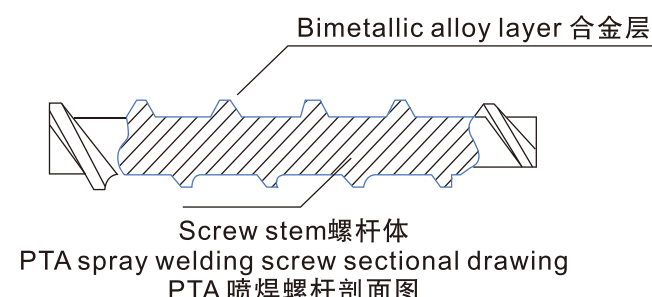
皮膜密度: 98-99.8%

硬度: Hv1100-1400C

密著强度: 10000Psi 以上

双金属机筒: 母材38CrMoAlA、40Cr、42CrMo

双金属螺杆: 母材38CrMoAlA、31CrMoV9(国外)



Distinction of uses:

All kinds of vertical, horizontal injection machine, extruder, injection molding machine, bakelite machine, rubber cylinder, film blowing machine, etc.

Field of application:

It is suitable for LCP, PA + GF, pet + GF, PBT + GF, PC + GF and other plastics to add glass fiber, Fire retardant, carbon powder and PPA, PPO, LCP, magnetic powder, PC and other special engineering plastics.



Processing area:

Double alloy screw: outer diameter: $\Phi 15\text{mm} - \Phi 360\text{mm}$; effective length: 10000mm

Double alloy material pipe: inner diameter: $\Phi 14\text{mm} - \Phi 200\text{mm}$; effective length: 6000mm

Membrane density: 98-99.8%

Hardness: HV1100-1400c

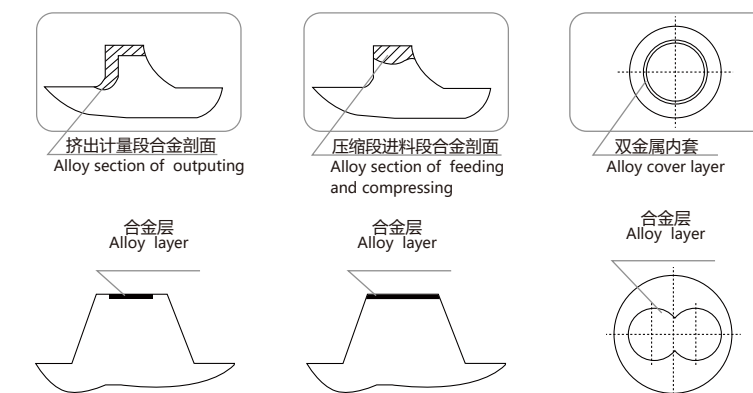
Adhesion strength: above 10000psi

Bimetal barrel: base metal 38CrMoAlA, 40Cr, 42CrMo

Bimetal screw: base metal 38CrMoAlA, 31CrMoV9 (foreign)

Bimetallic screw barrel

双合金螺杆机筒



双金级别:

A级: 含钨40%

B级: 含钨25%

C级: 含钨95%

合金硬度:

HRC 56~65°C

Double gold level:

Grade A: 40% tungsten

Grade B: 25% w

Grade C: 95% w

Alloy hardness:

HRC 56~65°C

技术指标 TECHNICAL TARGETS:

氮化层深度 Depth of nitration case: 0.5~0.8mm

氮化硬度 Hardness of nitration: 950~1020HV

氮化脆度 Fragility of nitration: Less than grade 1

表面粗糙度 Roughness of the surface: Ra 0.4um

螺杆直线度 Linearity on the screw: 0.015mm

双合金硬度 Hardness of double alloys: HRC55-62

双合金深度 Depth of double alloys: >2mm

Technical parameter:

The bimetallic barrel for single screw is a kind of barrel moulding 2-5mm-thick alloy coat on the barrel inner wall which has excellent corrosion resistance, abrasion resistance and high working temperature. And its useful service life is greatly improved contrast to the common nitrided barrel. Bimetal has more obvious advantages when processing special plastics to enhance the abrasion life, such as engineering plastics, fluorine plastics, PPO and etc.

The company uses special alloy powders being sprayed and welded on the screw's ridge, and used different alloys and welding methods for the screw of different functions.

For our bimetallic screw, we have adopted a new technology of surface hardening process by the whole screw surface instead of only hard facing the screw flights by PTA treatment.

For bimetallic barrel, we have raised its tungsten carbide content to 30% and 50% from the previous 10% of tungsten carbide and increased the processing length to 4000mm from the previous length of 3000mm

技术参数:

双金属机筒就是在机筒内壁浇铸一层2—5mm的耐磨耐腐蚀的、耐高温的合金,其有效使用寿命比普通氮化机筒大大提高,对于加工工程塑料、氟塑料、聚砜、PPO特殊类型的塑料等,双金属的优越性尤为明显。

本公司生产的单螺杆双金属螺杆,采用特殊合金粉末在螺杆螺棱部分喷焊合金,可以针对不同功能的螺杆采用不同的合金和焊接方式。

双合金螺杆也从以往的PTA牙顶喷焊,更新设备采用高压速 (HP/HVOF) 全面合金披覆的熔射技术。WPT1耐腐蚀型合金适用于尼龙、PVE、PC、PMMA等, WPT2耐磨耐高温型合金适用于尼龙玻纤、磁粉、铝镁粉、电木注塑等, WPT3兼有WPT1、WPT2两种特性,耐磨耐腐蚀耐高温。

双合金熔胶机筒方面。从以往的合金含钨10%提升至含碳化钨30%及50%,可加工长度亦从3000mm提升至4000mm。

Segment screw

积木螺杆



产品规格 Product specifications

Φ60/2, Φ65/2, Φ70/2, Φ72/2, Φ75/2, Φ80/2, Φ85/2, Φ90/2, Φ93/2, Φ100/2, Φ105/2, Φ110/2, Φ115/2, Φ120/2, Φ125/2, Φ130/2, Φ140/2, Φ150/2, Φ160/2, Φ170/2, Φ180/2, Φ190/2, Φ200/2, Φ250/2

适用范围：常用于镜片、透明外壳、化妆品容器类、透明亚克力、尼龙、PVC、PC、PPA、PPO、PPS、PA6T、LCP、ABS防火、电木、PC+玻璃纤维、尼龙+玻璃纤维、磁粉、陶瓷粉、铝镁粉、铁粉、电动注塑机、PVC木塑、PE木塑、超高分子板材、免烧砖托板、1：2以上高钙扣板、50-400份以上高钙管材、50-300高钙型材、软PVC片材、PVC发泡板等普通塑料、PP、PE、ABS、PVC、原料造粒、生产管材、异型材、片材等工程塑料改性造粒。

Scope of application: commonly used in lenses, lenses, etc Transparent shell, cosmetic container, transparent acrylic, nylon, PVC, PC, PPA, PPO, PPS, PA6T, LCP, ABS fire prevention, bakelite, PC + glass fiber, Nylon + glass fiber, magnetic powder, ceramic powder, aluminum magnesium powder, iron powder, electric injection molding machine, PVC wood plastic, PE wood plastic, ultra-high molecular plate, unburned brick supporting plate, 1:2 high calcium gusset plate, 50-400 parts of high calcium pipe, 50-30 parts of high calcium pipe 0 high calcium profile, soft PVC sheet, PVC foam board and other ordinary plastics, PP, PE, ABS, PVC, raw material granulation, production pipe, profile, sheet and other engineering plastics modified granulation.



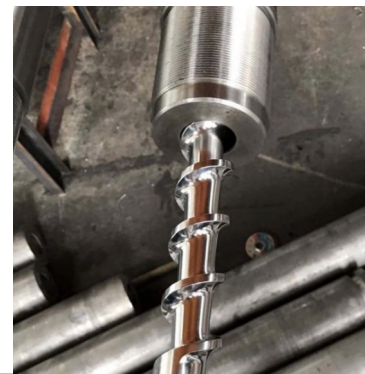
Segment screw

积木螺杆



Screw barrel of injection molding machine

注塑机螺杆机筒



通用材质 common steel

常规材料 Conventional materials: 38CrMoAlA SKD61 Cr12MoV

SACM645 Ni 基合金 GH113

氮化硬度 Nitriding hardness: HV900-1000

氮化深度 Nitriding depth: 0.5-0.8mm

淬火硬度 Quenching hardness: HRC55° - 62°

氮化脆度 Nitriding embrittlement: ≤二级

表面粗糙度 Nitriding embrittlement: Ra0.4

螺杆直线度 Straightness of screw: 0.015mm

氮化后表面镀铬硬度 Hardness of chromium plating: HV≥950HV

镀铬层厚度 Thickness of chromium plating layer: 0.05 ~ 0.10mm

合金深度 Alloy depth: 0.8 ~ 2.0mm

产品规格 Product specifications

理论注塑量(g) Amount of Injection	螺杆直径 X长度(mm) Screw Diameter X Length	料筒外径X长度(mm) Barrel Diameter X Length	理论注塑量(g) Amount of Injection	螺杆直径 X长度(mm) Screw Diameter X Length	料筒外径X长度(mm) Barrel Diameter X Length
30-90	Φ30x900	Φ85x860	80-125	Φ75x1825	Φ170x1725
60-125	Φ35x910	Φ85x860	100-150	Φ80x2000	Φ180x1805
100-150	Φ38x935	Φ95x900	125-200	Φ85x2300	Φ190x1900
125-160	Φ40x980	Φ95x910	200-300	Φ90x2700	Φ210x2000
125-300	Φ42x1030	Φ105x1110	250-500	Φ100x2600	Φ230x2405
250-400	Φ45x1210	Φ115x1165	300-600	Φ110x2600	Φ256x2590
300-500	Φ50x1300	Φ125x1260	400-1000	Φ120x2800	Φ256x2800
450-600	Φ55x1335	Φ130x1320	600-800	Φ130x3010	Φ256x2970
500-700	Φ56x1350	Φ130x1350	800-1000	Φ145x3010	Φ256x3200
500-700	Φ60x1380	Φ140x1350	1000-	Φ160x3500	Φ270x3200
650-800	Φ65x1415	Φ150x1420	15001300-	Φ170x3415	Φ317X3380
700-1000	Φ70x1790	Φ160x1685	2500		

Screw barrel of injection molding machine

注塑机螺杆机筒



Screw and barrel for rubber machine

橡胶机械螺杆机筒

通用材质 common steel

常规材料 Conventional materials: 38CrMoAlA (JIS SACM645)
氮化硬度 Nitriding hardness: HV900-1050
氮化深度 Nitriding depth: 0.5-0.8mm
淬火硬度 Quenching hardness: HRC55° - 65°
氮化脆度 Nitriding embrittlement: ≤二级
表面粗糙度 Nitriding embrittlement: Ra0.4
螺杆直线度 Straightness of screw: 0.015mm
氮化后表面镀铬硬度 Hardness of chromium plating: HV≥900HV
镀铬层厚度 Thickness of chromium plating layer: 0.025 ~ 0.10mm
合金深度 Alloy depth: 2.0 ~ 3.0mm



产品规格 Product specifications

橡胶销钉螺杆、机筒规格: Φ75mm~Φ200mm
Rubber pinned screw and barrel, specification: Φ75~Φ200mm
橡胶冷、热喂料螺杆、机筒, 规格: Φ30mm~250mm
Rubber cold, hot feeding screw and barrel, specification: Φ30mm~250mm

Screw and barrel for rubber machine

橡胶机械螺杆机筒



Gearbox

齿轮箱



产品规格 Product specifications

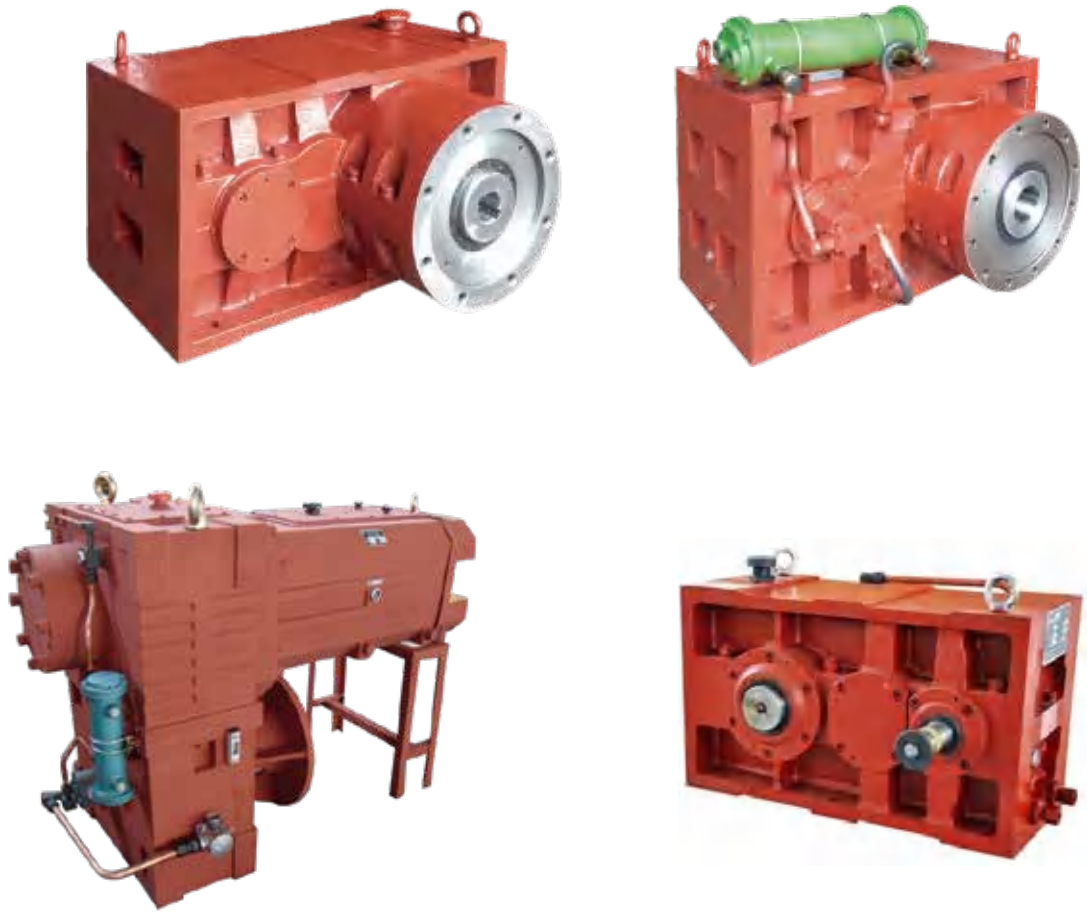
本系列产品采用JB/T9095.1-1999标准生产的硬齿面传动装置，由减速箱和分配箱两部分组成，是锥形双螺杆挤出机配套的专用产品。

- 1、减速器的齿轮为高强度合金钢渗碳钢，经渗碳淬火磨齿，6级精度。齿部硬度HRC58-62，传动噪声低。
- 2、分配箱小锥角斜齿轮，采用高轻度合金钢，经数控滚齿机切齿后渗碳、淬火处理，精度高，硬度高。
- 3、采用球墨铸铁箱体和高强度推力调心滚子轴承的设计，性能可靠，能承受大轴向推力。
- 4、减速器和分配箱皆配备有冷却装置，运行安全。
- 5、全部切削加工的外形平整美观。除现有的规格外，还可按用户的要求设计制造其它规格的产品。

型 号 Model	规 格 SPEC.	输入功率 (KW)	n入	n出	输出扭矩 (N.m)	输出轴轴向推力 (KN)	螺杆直径 Screw Diameter	长径比 Length- Diameter Ra
ZLYJ	112-8	5.5	800	100	525	35	Φ35	25:1
	133-8	8	800	100	764	39	Φ50	25:1
	146-10	11	1000	100	1050	54	Φ55	25:1
	173-10	18.5	900	90	1962	110	Φ65	25:1
	180-10	18.5	900	90	1962	110	Φ65	25:1
	200-12.5	30	1000	80	3581	155	Φ75	25:1
	225-12.5	45	1000	80	5371	180	Φ90	25:1
	205-16	55	1120	70	7503	192	Φ105	25:1
	280-16	75	960	60	7643	258	Φ110	25:1
	315-16	85	960	60	13528	287	Φ120	25:1
	330-16	110	960	60	17507	360	Φ135	25:1
	375-16	132	960	60	21008	390	Φ150	25:1
	395-16	185	960	60	29442	400	Φ160	25:1
	420-16	160/220	960	60	31831	430	Φ170	25:1
ZSYJ	450-20	213	1000	60	40640	500	Φ180	25:1
	560-20	440	1000	50	84034	700	Φ200	25:1
	630-20	540	1000	50	103132	770	Φ250	25:1
	450-32	200	1500	47	40635	500	Φ165	25:1
ZSYJ	560-57	220	1500	26	80802	700	Φ190	25:1
	630-44	315	1500	34	88471	770	Φ200	25:1

Gearbox

齿轮箱



规格参数 Specification parameters

参数 Parameter	SZ45	SZ50	SZ55	SZ65	SZ80	SZ92
输入转速(max r/min) Input rotation speed	1500	1500	1500	1500	1500	1500
输出转速(max r/min) Output totation speed	44.8	37.8	37.5	39.1	37.7	40
输入功率(KW) Input power	18.5	22	30	37	55	110
单轴输出扭矩(N · m) Single shaft output torque	1972	2779	3820	4518	6786	13130
分配轴夹角Distribution shaft including angle	2°40'	2°58'12"	2°36'14"	2°11'16"	2°0'18"	1°52'3.64"
连接花键尺寸connection spline size	8-48x42x8	8-54x46x9	6-60x53x14	8-65x56x10	8-72x62x12	10-98x92x14

Heater

加热器

远红外节能加热圈 Infrared energy-saving heating coil



工作原理图 Working principle diagram



风冷加热器 Air-cooled electric heater

结构：加热/冷却系统由冷却单元和加热单元组成。
一、冷却单元：由冷却风罩、鼓风机及多种散热器组成。冷却风罩和鼓风机可以分别取下，安装简便。1.冷却风罩采用不锈钢板或镀锌钢板制作，配有冷却风机接口、优化气流导风片、排气口以及接线盒，外观精美。2.冷却风机。3.散热器：根据散热要求可选用紫铜板散热片、铝板散热片、陶瓷散热片、外风道铸铝、内风道铸铝及液体冷却式铸铝。
二、加热单元：采用电加热方式，电热元件可选用矿物绝缘加热器、云母加热器、陶瓷加热器、铸铝加热器或铸铜加热器。

我们可以根据客户所需要的加热和散热功率来设计加热与散热面积的比率。我们既可提供单相供电的，也可以提供三相供电的电热圈和鼓风机。

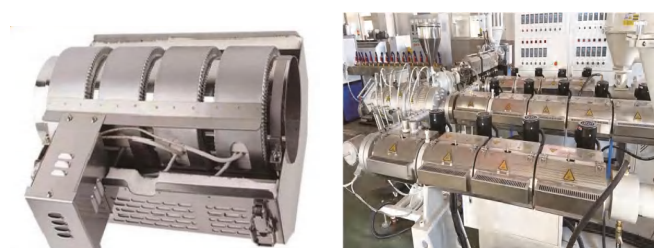
Structure:The heating/cooling system by the cooling unit and the heating unit.

Cooling unit:by cooling air cover,blower and a variety of radiator.Cooling hood and blowers can be removed,and easy to install.

1.the cooling fan cover is made of stainless steel or aluminized steel production,with a cooling fan connector to optimize the airflow wind guide piece,the exhaust port and the junction box,attractive appearance.2.the cooling fan.3.Radiator:According to the cooling requirements can choose copper plate heat sink,aluminum heat sink,ceramic heat sink,the outer ductcast aluminum,inner ductcast aluminum and liquid-cooled aluminum.

Second,the heating unit:electric heating,the heating element can be used micaheater, ceramic heater,cast aluminum heater or copper heater.

We can design the products according to the customer needs heating and cooling power ratio of the area of heating and cooling.We have been able to provide single-phase power supply,can also provide three-phase power supply heaters and fans.



Heater

加热器

陶瓷加热器 Ceramics Electric heaters



云母加热器 Mica Electric heaters



铸铝加热器 Cast aluminum heater

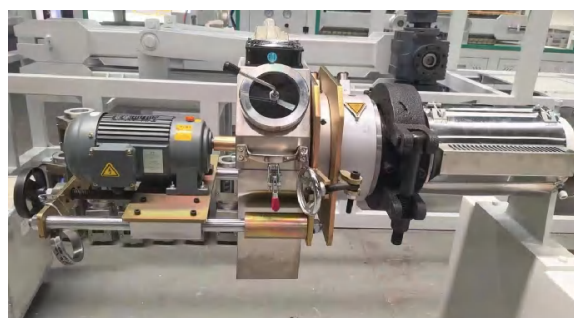
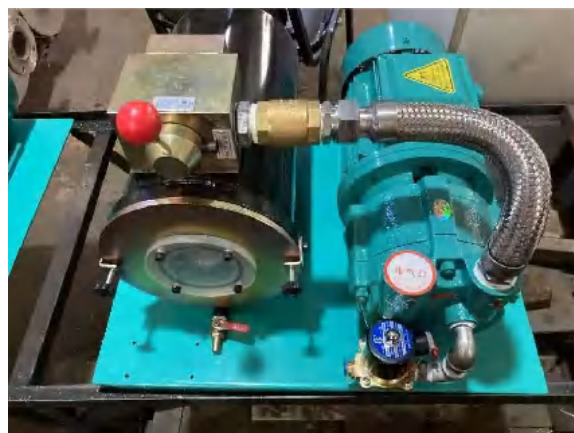


铸铜加热 Copper Electric heaters



Spare parts

备件



Application area

应用领域

