



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.

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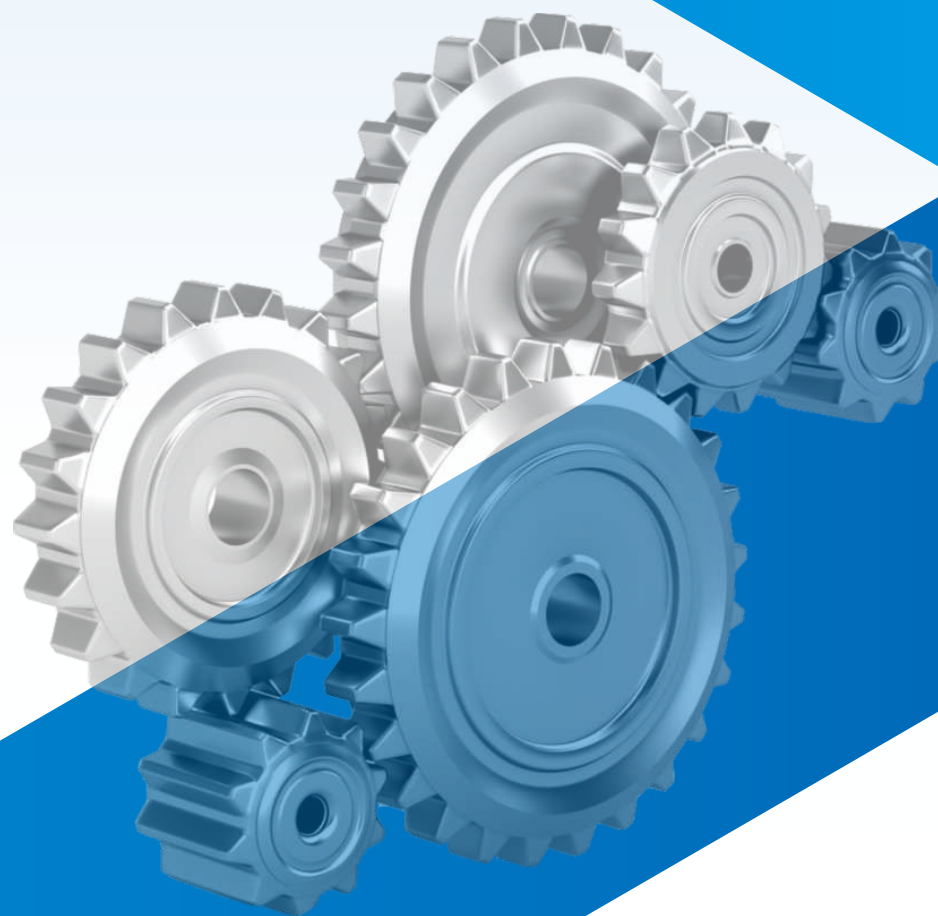
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公司简介

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 auxliary cooling conveyor, and has obtained the 1S09001:2015 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

OUR MAIN PRODUCTS INCLUDE:

- 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
- 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

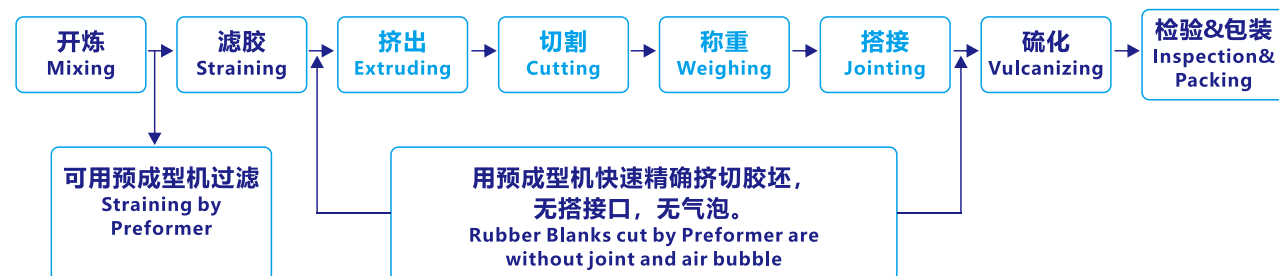
JYZ PRECISION PREFORMER

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

MAIN INDUSTRIES SERVED

1 汽车业，摩托业

- 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

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 鞋业

- 鞋底
- 鞋跟

Footwear Industry

- Soles
- Heels

3 运动休闲业

- 网球
- 高尔夫球
- 板球
- 海绵球

Sporting and Leisure Goods Industry

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

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

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



◀ **JYZ250**
精密预成型机
Precision Prefomer

JYZ250
精密预成型机 (后喂料)
Precision Prefomer (Rear Load)



◀ **JYZ200**
精密预成型机
Precision Prefomer

JYZ80
精密预成型机
Precision Prefomer



JYZ精密预成型机(自动型) JYZ PRECISIONPREFORMER (AUTO SERIES)

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;
- 电子秤闭环反馈, 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。

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



◀ **JYZ200H**
高压型精密预成型机
High Pressure Type
Precision Prefomer

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

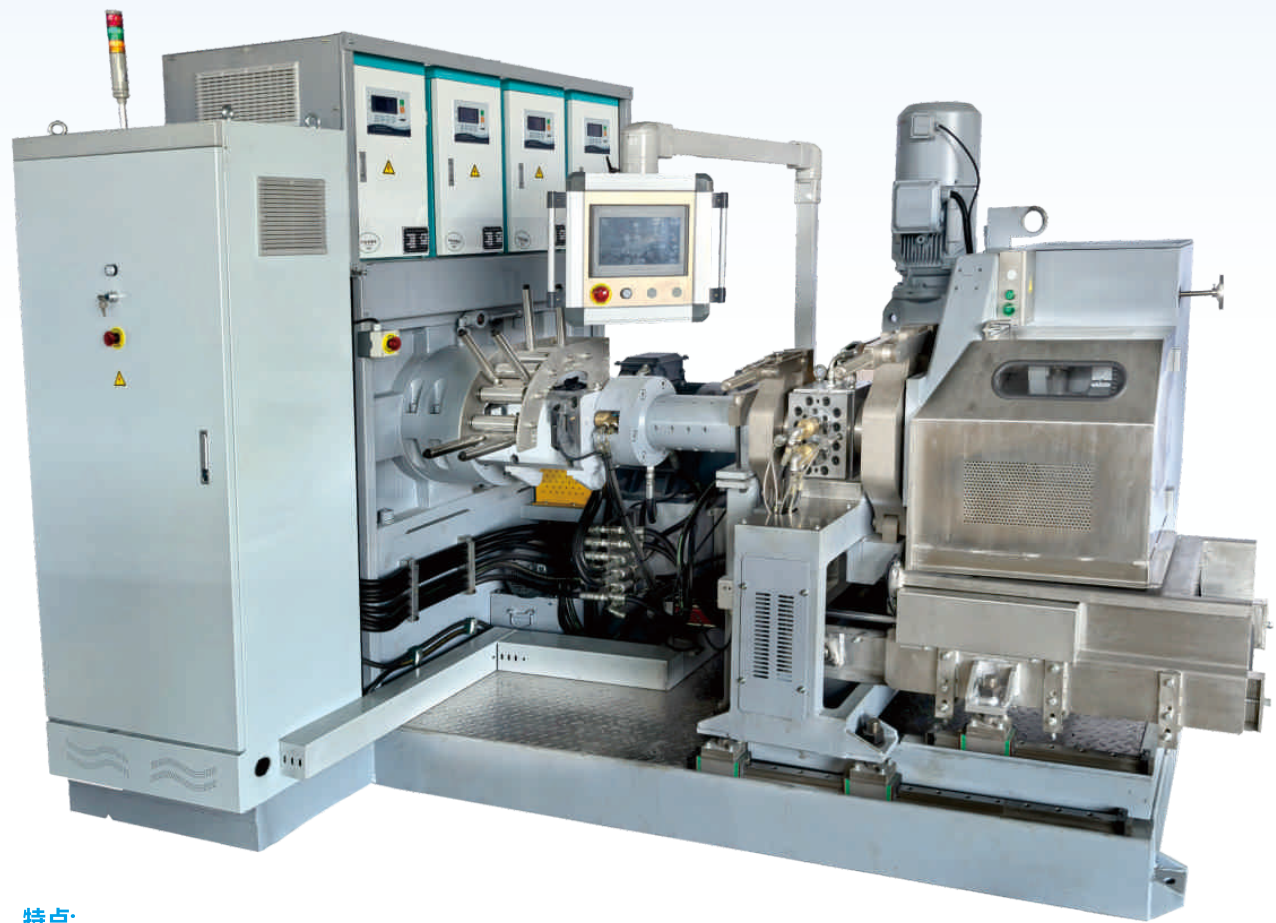


KLY冷喂料精密预成型机

KLY COLD FEED PRECISION PREFORMER

冷喂料精密预成型机
是一款高效率、高精度的胶坯生产设备，将条状冷料经过螺杆及齿轮泵塑炼、输送、并进行预成型，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。

Cold Feed Precision Preformer
is a type of rubber blank manufacturing equipment with high efficiency and high accuracy. It is applied to plasticize the cold rubber compound in strip shape, conveyed and pre-formed by screw and gear pump. It can process a wide range of all rubber material including Silicone, NR, NBR and FKM compound etc.



- 特点:**
- 连续冷喂料，胶料无需在开炼机上预热打卷，降低操作工劳动强度。
 - 实现持续生产，效率更高。

- FEATURES:**
- Continuous cold feeding rubber compound, compound not required pre-heated in mixing mill, which reduces the labor intensity of operator.
 - Continuous production, higher efficiency.

技术参数

Technical parameter

项目名称 Items	单位 Unit	KLY50	KLY75	KLY90	KLY120	KLY150
螺杆直径 Screw Diameter	mm	50	75	90	120	150
螺杆长径比 Screw L/D		12:1	12:1	8:1	8:1	8:1
螺杆转速 Screw Speed	r/min.	5-60	5-60	5-60	5-60	5-60
齿轮泵挤出压力 Extruding Pressure of Gear Pump	MPa	35	35	35	35	35
总功率 Total Power	kW	25	45	66.5	75	115
切刀速度 Cutting Speed	r/min.	0.5-600	0.5-600	0.5-600	0.5-600	0.5-600
最大口型直径 Max.Die Size	mm	60	125	190	190	190
胶坯重量精度 Blank Weight Accuracy	%	±1	±1	±1	±1	±1
最大产能 Max. Output	kg/h	80	150	300	550	750
外形尺寸(LxWxH) External dimension	mm	3000*1500*1800	4000*1700*2000	4000*1700*2000	4800*1900*1600	4800*1900*1600
机器重量 Machine Weight	kg	2000	3000	6000	8000	10000

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 fluorinecompound . Compared to screw strainer, it wil 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.

可选配件

- ① 触摸屏操作界面
- ② 柱塞位置百分比显示
- ③ 后喂料

Optional accessories

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



项目名称 Items	单位 Unit	JYLZ80	JYLZ100	JYLZ150	JYLZ200	JYLZ250	JYLZ200H	JYLZ250H
料筒内径 Barrel inner diameter	mm	80	100	150	200	250	200	250
总功率 Total power	kW	11.5	11.5	14.0	14.0	18.0	18.0	18.0
最大挤出压力 Max.extruding pressure	MPa	40.0	40.0	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	95	95
一次装胶量 Single load capacity	kg	2~3	5~6	10~15	20~30	60~70	20~30	60~70
外形尺寸(LxWxH) External dimension	mm	1800x940x1640	1800x940x1640	3100x1250x1640	3100x1250x1640	4200x1250x1640	3600x1250x1640	4200x1250x1640
机器重量 Weight	Kg	1200	1200	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.



定长切割输送机
Length-fixing cutting conveyor

收卷装置
Rolling device



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 preformer. it is space -saving,the part directly contact with rubber blanks is stainless steel to prevent contamination.Rubber blanks travel through vibratory way to preven 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.



可选配件

- 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 accessories

- ① Air chiller: chilled air cooling

② Surrounded by a cover.

③ Water cooling slope conveyor: Enhance cooling effect.

LSZ1050

振动式冷却输送机

Vibra Cooling Conveyor



LSZ1250

振动式冷却输送机

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	110
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x宽x高) External Dimension(LxWxH)	mm	2800x1400x2700	2800X1800X3100
重量 Weight	kg	1200	2000

LSS650水冷式冷却输送机

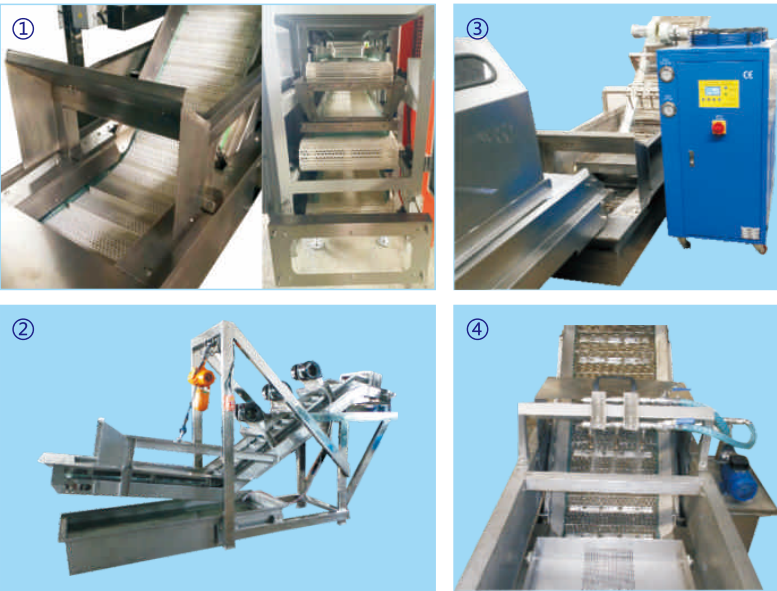
LSS650 WATER COOLING CONVEYOR

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 wil not become deformed and more stable. 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.



- 可选配件

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 accessories

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



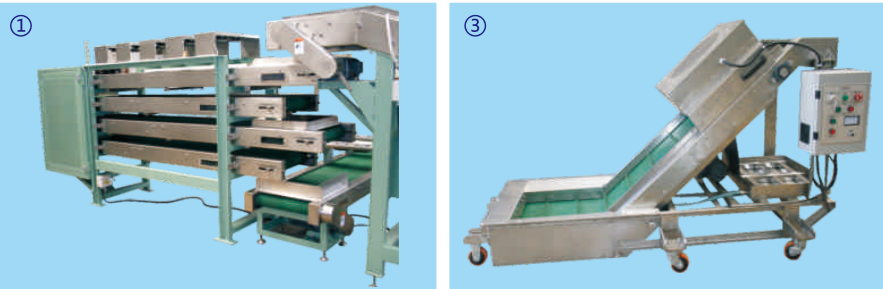
精密预成型机与水冷式冷却输送机(带提升装置)配套使用

Preision 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(LxWxH) Water tank dimension	mm	2000x760x300
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	m³/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	m³/h	29040
总功率 Total power	kW	2.6
外形尺寸(LxWxH) External dimension	mm	6100x750x1840
重量 Weight	kg	1200



- 其他冷却装置

Other Cooling Units
- ① 皮带输送机

Belt Conveyor
- ② 斜面冷却输送机

Slope Cooling Conveyor

LSS-0800清理&自动称量水冷式冷却输送机

LSS-0800 CLEAN-UP & AUTO-WEIGHING WATER COOLING CONVEYOR

LSS-Q800清理&自动称量水冷式冷却输送机

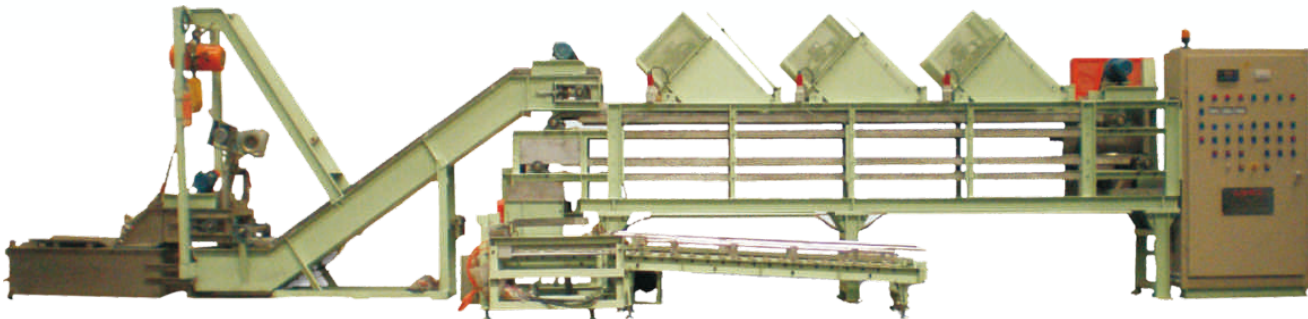
是与精密预成型机配套使用的胶料后段冷却，输送，吹干及称重分箱装置。精密预成型机切下的胶料经过LSS-Q800冷却输送机浸水，输送，吹干后由横向皮带输送机送入物料箱。当物料箱内胶料达到设定的重量后，横向皮带输送机停止运行，自动推箱器将满箱的物料自动换成空箱，横向皮带输送机再次运行，达到自动称重，自动分箱，自动换箱功能。

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 conyeyor. When the rubber compounds reach the set weight, the cross belt conveyor wil 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-weiching, 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 rubbechippings 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 conveyor, 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(LxWxH) 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

APPLICATION

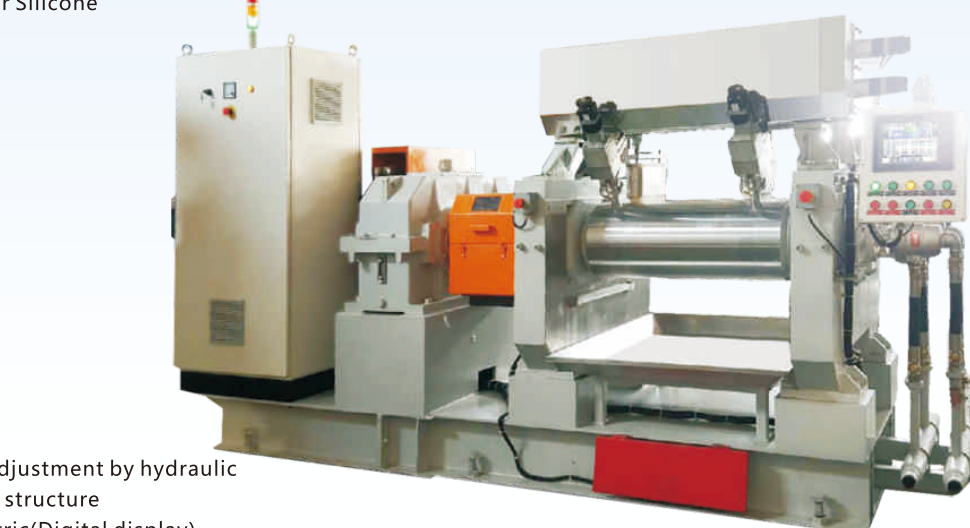
Automatic turning rubber compound with scheduled time, Not by labor. Particularly for rubber compound with high viscosity, More effective for Silicone

可选配件

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

Optional accessories

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



胶片冷却线

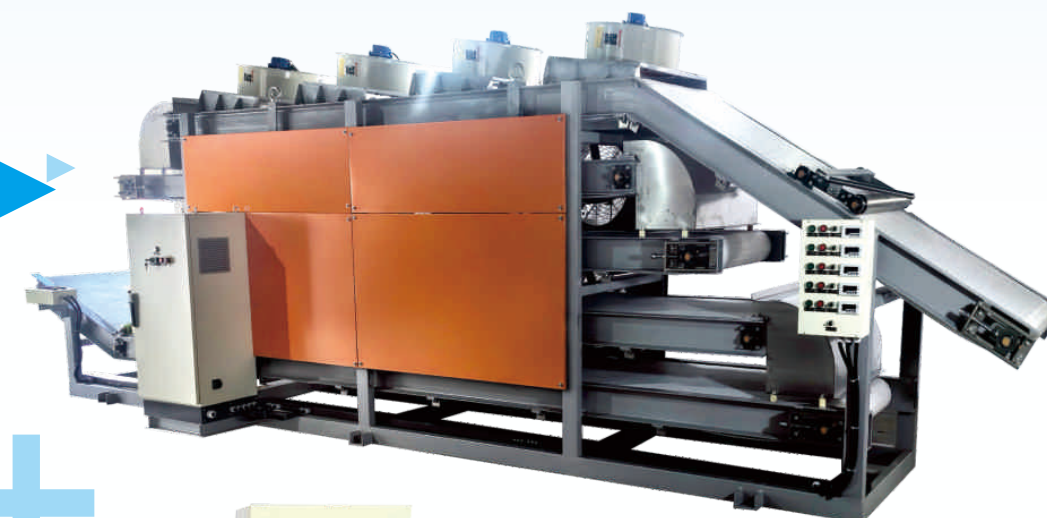
COOLING LINE FOR RUBBER SHEET



水槽
Water Tank



冷片机
Batch-off



裁断机
Cutter

滚轮冷却输送机 ROLLER COOLING CONVEYOR



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 mil(screw extruder).

结构特点

- ① 由接收输送、浸泡隔离、提升、挂条吹干、出料输送等装置组成。
- ② 接收输送与浸泡隔离输送速度可调;
- ③ 浸泡隔离输送由水泵将隔离液喷射至转动的胶片上冷却;
- ④ 放置隔离剂的水箱装有搅拌机,防止隔离剂结块;
- ⑤ 挂条输送装置由构架、挂杆、链条及导轨构成。

Structural features

- ① It has receiving and conveying unit, soaking and isolating unit, elevating unit, sheet hanging and drying unit discharging and conveying unit, etc.
- ② The conveying speed of receiving and conveying unit & soaking and isolation unit is adjustable.
- ③ To spray release agent fluid to the running rubber sheet from water pump fit in the soaking and isolating unit;
- ④ There is a mixer in water tank where placed release agent, to avoid the caked issue of release agent.
- ⑤ 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 Items	单位Unit	LPX450
适用胶片规格宽度 Applicable rubber sheet specification	mm	< =450
接取运输带速度 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	0.37x10
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
搅拌机电机功率 Mixing motor power	kW	0.4
挂条电机功率 Hanging motor power	kW	2.2
外形尺寸(长x宽x高) External dimension(LxWxH)	mm	7500x3300x2650
总重量 Total weight	kg	3500

