



Sevenstars Group

张家港市北斗星机械有限公司
Zhangjiagang Sevenstars Machinery Co.,Ltd.

张家港市骑士机械有限公司 (分公司)
Zhangjiagang HorseRider Machinery Co.,Ltd. (Branch company)

张家港市北斗星塑料制品有限公司(分公司)
Zhangjiagang sevenstars plastic manufacturing Co.,Ltd(Branch company)

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Http://www.horserider-plastech.com
Http://www.sevenstars-plastic.com



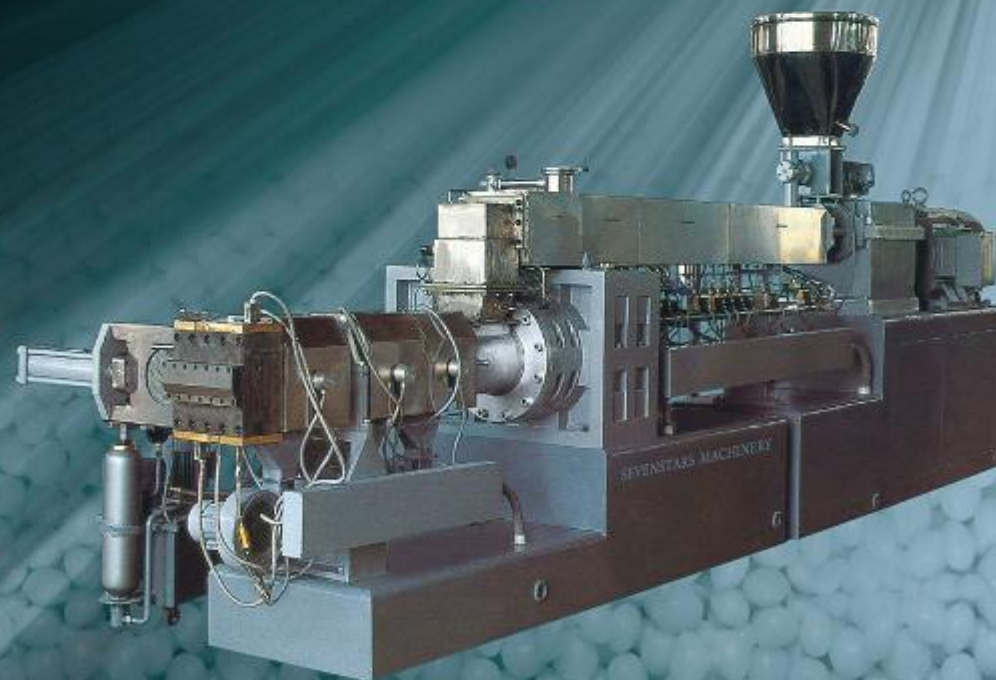
SEVENSTARS MACHINERY

北斗星机械

张家港市北斗星机械有限公司
Zhangjiagang Sevenstars Machinery Co.,Ltd.
张家港市骑士机械有限公司
Zhangjiagang HorseRider Machinery Co.,Ltd.
张家港市北斗星塑料制品有限公司
Zhangjiagang Sevenstars Plastic Manufacturing Co.,Ltd.



Plastic Recycling Line



www.sevenstarsgroup.cn



COMPANY INTRODUCTION 公司简介

张家港市北斗星机械有限公司是一家专业生产塑料机械的企业，公司旗下有两个子公司，分别是张家港市骑士机械有限公司、张家港市北斗星塑料制品有限公司。位于中国黄金水道长江中下游南岸，全国知名的文明卫生城市——张家港，周临苏、锡、常、宁、沪等经济腹地，水陆交通极为便利。

公司主要产品有：PE/PP薄膜清洗线、PET瓶片清洗线、各种单螺杆造粒生产线以及各种双螺杆造粒生产线、单轴破碎机、双轴破碎机，各种塑料粉碎机以及其它塑料回收辅机，产品远销欧洲、中东、非洲和东南亚等国家地区，深受国内外客户的信赖和好评。

公司产品畅销国内外，并可根据客户要求对产品进行设计，培训并免费安装、调试，提供工艺配方一条龙服务，竭诚欢迎广大新老客户前来选购。公司拥有型材、塑木生产线供客户现场参观。

公司秉承“以质量创品牌，以低价占市场，以信誉赢客户”的经营理念，不断求新、求变、诚挚地恭请社会各界朋友来公司指导、接洽，共谋伟业。

Zhangjiagang Sevenstars Machinery Co.,Ltd. is a group company including Zhangjiagang HorseRider Machinery Co.,Ltd and Zhangjiagang sevenstars plastic manufacturing Co.,Ltd, specialized in producing plastic machinery. It lies to the south of the middle and lower reaches of Yangtze River. It is located in the National civilization and hygienic city—Zhangjiagang, Surrounded by the economic belt of Suzhou, Wuxi, Changzhou, Nanjing and Shanghai. Both land and river transports are rather convenient. Our company mainly produce: PP/PE Film/Bottle Washing line ,PET bottle recycling line and Different plastic pelletizing line including single screw pelletizing line and twin screw pelletizing line and under-water pelletizing line and Different Plastic crusher and single shaft shredder and double shaft shredder and others.

We may also design products according to customer's requirements. We can train operators. We conducts installation and debugging. We can also provide users with formula. Sincerely welcome to select our products, we also welcome you to visit our other production fields of profile, plastic pipe extrusion line ,plastic wood compound production line etc.

By keeping the operation idea of "Creating brand by quality,occupying the market by favorable price and obtaining customers by credit",our company continuously pursues innovation and development. We sincerely invite friends of different circles to visit our company for direction and business negotiation so that we can develop together.



COMPANY HONORS 公司荣誉



HDPE /PP BOTTLE,DRUM RECYCLING LINE

HDPE/PP瓶、桶清洗线

整套清洗回收系统可根据客户要求定制

The complete recycling solution can be customized



技术参数 Technical parameter

型号 Model	参数 Parameter	生产产量 Production Capacity (kg/hour)	生产线长度 Length of Line (meter)	生产功率 power Consumption (kw/hour)	生产方式 Work ways	设备要求 Special Requirement
BDX-PE/PP300		300	Around 25	To be Determine	自动/Automatic	To be Determine
BDX-PE/PP500		500	Around 50	To be Determine	自动/Automatic	To be Determine
BDX-PE/PP1000		1000	Around 65	To be Determine	自动/Automatic	To be Determine



PP/PE FILM RECYCLING LINE

PP/PE薄膜清洗线



技术参数 Technical parameter

型号 Model	参数 Parameter	生产产量 Production Capacity (kg/hour)	生产线长度 Length of Line (meter)	生产功率 power Consumption (kw/hour)	生产方式 Work ways	设备要求 Special Requirement
BDX-PE/PP300		300	Around 25	To be Determine	自动/Automatic	To be Determine
BDX-PE/PP500		500	Around 50	To be Determine	自动/Automatic	To be Determine
BDX-PE/PP1000		1000	Around 65	To be Determine	自动/Automatic	To be Determine



PP/PE FILM RECYCLING LINE

PP/PE薄膜清洗线

We design various of washing plants according to customers requirement.
In order to allow us to make a detailed proposal for you , please kindly inform us:

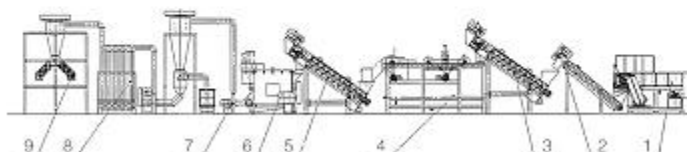
- a) The material type (PP,PE,PET,PVC and etc.)
- b) The shape or thickness of the material (bottles ,film,drums and etc)
- c) The capacity (kg/hr)

We will also make particular proposal according to customers particular requirement.

The environmental pollution is becoming more and more serious because of the waste from modern industry,especially the big quantity of cumulate waste plastics that occupy a lot of land. The washing plants we make are for recycling of waste plastics and make the raw material that ready for reuse.

PP/PE FILMS WASHING PLANT FLOW CHART

MAIN FLOW CHAT

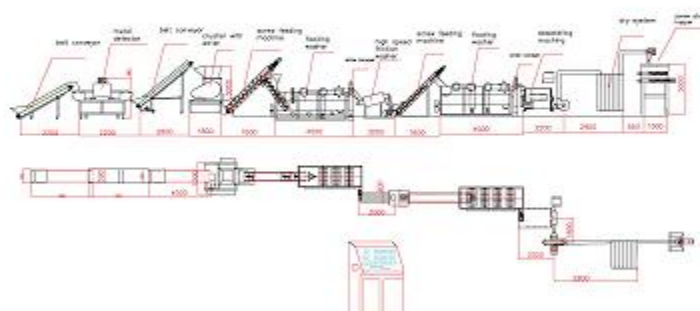


1,2 SHREDDING,CRUSHING AND SCREW LOADING

3,4,5 WASHING

6,7,8 DRYING

9 PACKING



PRE-WASHER FOR PLASTIC



PE WASHING TANK



PE/PP WASHING TANK



HOT AIR DRYER AND PACKING

Dewatering of the thin material is the most difficult step in the recycling of waste material, the material with high humidity makes low quality pellets in the extruding step. To solve the problem we make the horizontal centrifugal dryer for the dewatering of the thin material like film.



The rotor of dryer is designed especially for thin materials.



CYLINDER SCREEN WASHER :

The cylinder screen brush washer cleans the dust on the surface of screen automatically to keep the screen holes clear without jam.

DOUBLE SECTION DRYING SYSTEM :

The material from the mechanical drying step (centrifugal dryer) still contains some percentage of water and the water left is difficult to dry even with another step of mechanical drying. Therefore, the hot air drying system is necessary.



PET FLAKE WASHING AND RECYCLING LINE

PET瓶片清洗线



Rolling Barrel Separator



Manual Separation Platform



Metal Detector



Wet Crusher



Hot Washer



High-speed Friction Washer



Floating Washer

技术参数 Technical parameter

型号 Model	参数 Parameter	生产产量 Production Capacity (kg/hour)	生产线长度 Length of Line (meter)	生产功率 power Consumption (kw/hour)	生产方式 Work ways	设备要求 Special Requirement
BDX-PET300		300	Around 25	To be Determine	自动/Automatic	To be Determine
BDX-PET500		500	Around 50	To be Determine	自动/Automatic	To be Determine
BDX-PET1000		1000	Around 65	To be Determine	自动/Automatic	To be Determine
BDX-PET1500		1500-2000	Around 80	To be Determine	自动/Automatic	To be Determine



Floating Washer



Spray Washer



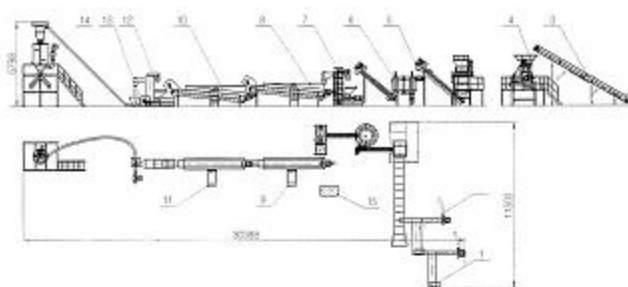
Pipeline Dryer



CUSTOMER EXAMPLE OF PET FLAKE WASHING AND RECYCLING LINE

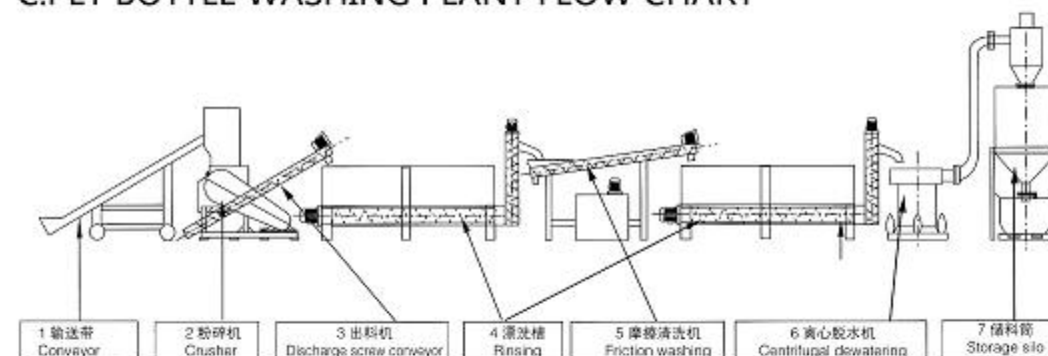
PET瓶片清洗线客户案例(A、B、C...)

A.PET BOTTLE WASHING PLANT FLOW CHART

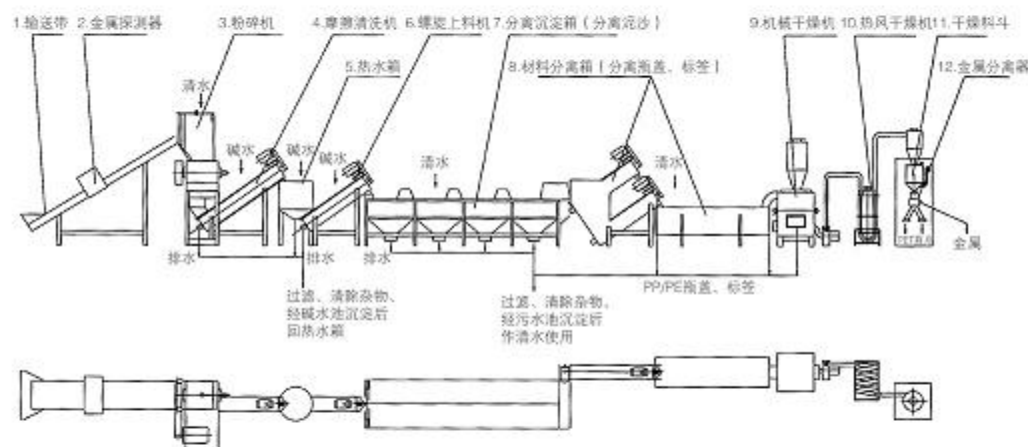


- 1-7 Shredding, Crushing & Hot washing
- 8-10 Floating Washing
- 12-13 Drying
- 14-15 Packing

C.PET BOTTLE WASHING PLANT FLOW CHART



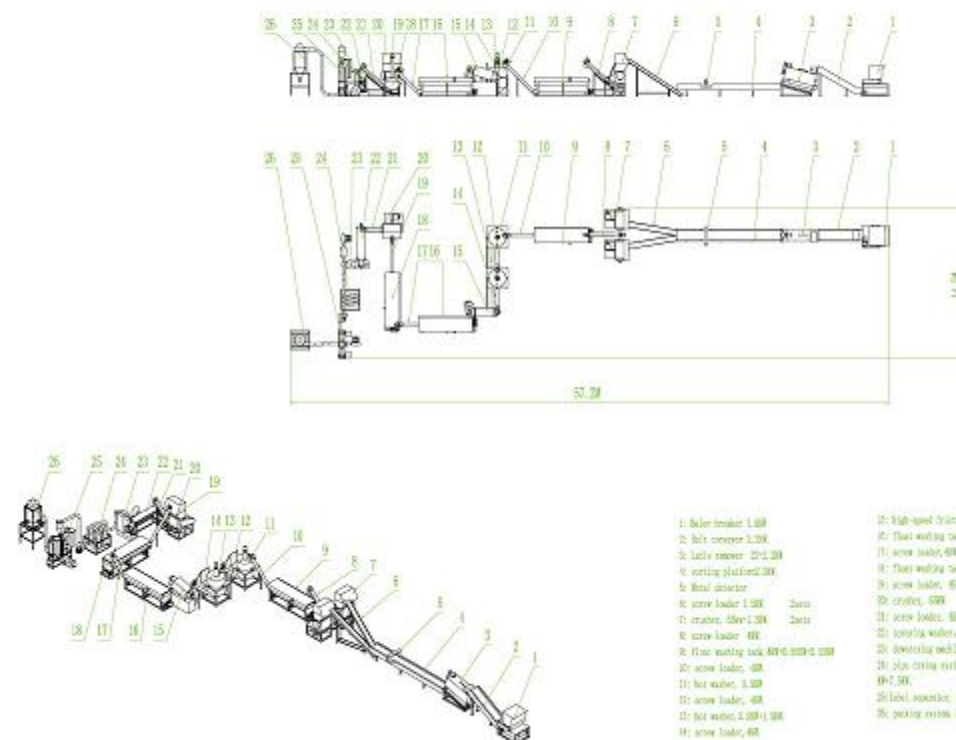
B.PET BOTTLE WASHING PLANT FLOW CHART



1.输送带/Conveyor belt	7.分离沉淀箱/ Separation tank 1
2.金属探测器/Metal detector	8.材料分离箱/ Separation tank 2
3.粉碎机/Plastic Crusher	9.机械干燥机/Mechanical dryer
4.摩擦清洗机/Friction Washer	10.热风干燥剂/Thermal dryer
5.热水箱/hot water tank	11.干燥料斗/Hopper dryer
6.螺旋上料机/Screw Loader	12.金属分离器/Metal separator

保留技术更改权/subject to technical modifications

D.PET BOTTLE WASHING PLANT FLOW CHART



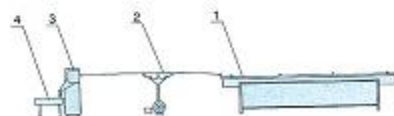
- 1: Baller breaker 1.500
- 2: Ball conveyor 1.200
- 3: Baller conveyor 20-2.000
- 4: Sorting platform 2.000
- 5: Baller conveyor 400
- 6: Baller conveyor 1.500
- 7: Baller conveyor 1.500
- 8: Baller conveyor 1.500
- 9: Baller conveyor 1.500
- 10: Baller conveyor 1.500
- 11: Baller conveyor 1.500
- 12: Baller conveyor 1.500
- 13: Baller conveyor 1.500
- 14: Baller conveyor 1.500
- 15: Baller conveyor 1.500
- 16: Baller conveyor 1.500
- 17: Baller conveyor 1.500
- 18: Baller conveyor 1.500
- 19: Baller conveyor 1.500
- 20: Baller conveyor 1.500
- 21: Baller conveyor 1.500
- 22: Baller conveyor 1.500
- 23: Baller conveyor 1.500
- 24: Baller conveyor 1.500
- 25: Baller conveyor 1.500
- 26: Baller conveyor 1.500

All Type Of Pelletizing Ways For Plastic

物料挤出造粒流程图

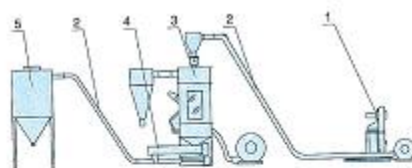
Strands pelletizing group

1. Water trough
2. Air knife
3. Pellerizer
4. Sieve



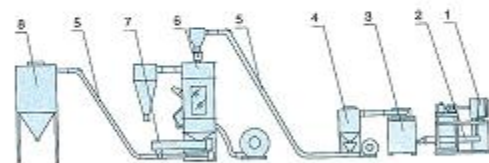
Air-cooling pelletizer group

1. Air-cooling pelletizer
2. Wind transmission system
3. Fluidized-bed dryer
4. Sieve
5. Product container



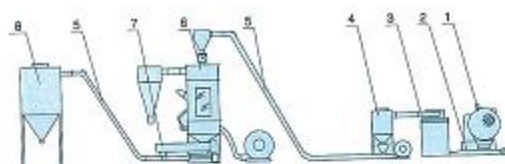
Water ring pelletizer group

1. Horizontal water ring pelletizer
2. Trough
3. Centrifugal dryer
4. Splitter
5. Wind transmission
6. Fluidized-bed dryer
7. Sieve
8. Product container



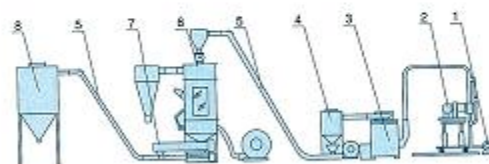
Eccentric water fog pelletizer group

1. Eccentric water fog pelletizer
2. Water power transmission
3. Centrifugal dryer
4. Splitter
5. Wind transmission
6. Fluidized-bed dryer
7. Sieve
8. Product container



Under water pelletizer group

1. Pelletizer in water group
2. Water power transmission
3. Centrifugal dryer
4. Splitter
5. Wind transmission
6. Fluidized-bed dryer
7. Sieve
8. Product container



SJ Series Single-Screw Extruder

SJ系列单螺杆挤出机

特性

高精度齿轮箱，承载能力高，传动平稳，噪音低；
 新型机筒和螺杆设计，确保更好的融化均匀性，低融温和高产量；
 标准螺杆，机筒气体氮化处理，抗磨损耐腐蚀性强，特殊物料可选用双金属材料制作；
 超静音风机冷却机筒，免维护操作；
 进口温控表，PID温度控制，控温更加稳定、精确；
 模头设计有手旋式或液压式两种，换网轻松省时。

Major Characteristics

Gearbox
 high precision, high loading capacity, steady driving and low noise
 Barrel and screw
 high melt homogeneity, low melt temperature and high production
 barrel made of nitrided steel, high wear & corrosion resistance
 barrel made of bi-metal for processing special material
 super-mute blower cooling barrel, maintenance-free
 Steady and accurate temperature & humidity control system
 Two types of die head: manual-operated and hydraulic, easy to change screen



技术参数 Technical parameter

Type	Screw Dia. (mm)	L/D	Screw speed Motor Power		Capacity	
SJ20	20	28	32	90rpm, 3kw / 150rpm, 5.5kw	1-5kg/hr	3-10kg/hr
SJ30	30	28	32	90rpm, 7.5kw / 120rpm, 11kw	8-15kg/hr	10-30kg/hr
SJ45	45	28	32	90rpm, 15kw / 120rpm, 22kw	15-40kg/hr	20-60kg/hr
SJ65	65	28	32	80rpm, 45kw / 90rpm, 55kw	40-80kg/hr	60-120kg/hr
SJ90	90	28	32	80rpm, 75kw / 90rpm, 90kw	90-150kg/hr	120-200kg/hr
SJ120	120	28	32	80rpm, 90kw / 90rpm, 132kw	200-300kg/hr	250-400kg/hr
SJ150	150	28	32	70rpm, 160kw / 80rpm, 220kw	350-500kg/hr	400-600kg/hr
SJ180	180	28	32	60rpm, 220kw / 80rpm, 280kw	500-700kg/hr	600-800kg/hr
SJ200	200	28	32	50rpm, 355kw / 60rpm, 400kw	700-900kg/hr	800-1000kg/hr
SJ220	220	28	32	40rpm, 400kw / 50rpm, 500kw	1000-1200kg/hr	1200-1500kg/hr
SJ240	240	28	32	40rpm, 500kw / 50rpm, 600kw	1200-1500kg/hr	1500-2000kg/hr

SHJ SERIES TWIN SCREW COMPOUNDING EXTRUDER

SHJ系列同向平行双螺杆挤出机组

SHJ系列同向平行双螺杆挤出机组特点

同向平行双螺杆挤出机筒，螺杆采用积木式原理设计制造。根据加工物料体系与工艺配方要求其长径比机筒结构、螺杆排列、环网结构、排气数量位置、加料方式、电气控制方式等，均可优化合理配置。实现多功能、多用途来适应加工高分子材料。新型减速机传动系统，高扭矩设计，高精度齿轮加工，采用进口轴承，合理的浸油式结合强制润滑装置，及连锁保护装置，确保主机可靠平稳运行。

充分利用有限的空间设计最新式渐开线花键形式结构芯轴。保证最大的承载能力，实现高扭矩传递。

采用计算机辅助设计的螺纹组件为捏合型。具有优异的自洁功能，良好的互换性，其规格有输送块、混炼块、捏合块、逆流块及齿型盘等，通过适当的合理组合，实现物料的输送、塑化、剪切、分散、均化、排气、建压等，完成高分子材料的工艺加工过程。

根据物料的不同状态，喂料系统采用多种结构形式，有单螺杆、双螺杆、双螺杆非啮合型，空芯弹簧式、双阶式及计量泵等体积计量喂料。也可配备失重式计量加料来完成更高的计量要求。

机组的电气控制系统主要件均为进口，可设计为：分立单元控制、模拟面板显示、PLC系统、PEC系统控制等供选择。

造粒系统可采用多种方式来满足要求，水冷拉条切粒；风冷模面热切；水环模面热切；偏心水雾热切；水中、水下模面热切等。

常规机筒采用优质氮化钢表面渗氮处理或高性能双金属合金套，也可采用工具钢衬套，螺纹元件采用优质氮化钢表面处理，接触面高速工具钢及耐腐蚀耐磨损的特殊表面处理方式，适应各类不同加工。

整机安装采用无基础方式。要求地面平整即可，无须水泥浇灌，十分便捷。

适应：填充改性、玻纤（碳纤）增强各类色母、橡胶共混、塑料合金、功能母粒、各类电缆料、反应挤出、脱挥处理、粉末涂料等。



SHJ-92型双螺杆挤出机

SHJ-92 TWIN SCREW COMPOUNDING EXTRUDE



SHJ-36型双螺杆挤出机

SHJ-36 TWIN SCREW COMPOUNDING EXTRUDE



CONFIGURATION&FEATURES

- Twin screw is parallel and co-rotation. The screw is modular design and exchangeable. The barrel is segmented and exchangeable.
- Widely using for different process and material.
- New designed gear box and transmission system for high torque.
- High precision gears, imported bearings and forced lubricating unit guaranteed high performance and reliable running.
- Multifunction feeder system can be used for specialized and various process.
- More options for control system, i.e. PLC, PCS, etc.
- Multifunction pelletizing system for different solution, i.e. strand pelletizing, die face pelletizing, water spraying pelletizing, water-ring pelletizing, under water pelletizing.
- Easy arrangement and operation, no foundation required.

APPLICATION

- Masterbatch
- Plastics modification
- Fiber glass reinforcement
- Cable compounds
- Alloy plastics
- Powder coating and toners, etc.

技术参数 Technical parameter

型号 Model	螺杆直径 Screw diameter (mm)	螺杆转速 Screw speed (rpm)	螺杆长径比 LD ratio	驱动功率 Motor power (kw)	参考产量 Output for reference (kg/h)
SHJ26	26	600	28-56	5.5/7.5	5-30
SHJ36	36	600	28-56	15/18.5	30-80
SHJ52	52	500	28-56	45/55	80-250
SHJ60	60	400/500	28-56	55	150-300
SHJ62	62	400/500	28-56	55/75	200-300
SHJ62A	62	400/500/600	28-56	75/90	300-450
SHJ72	72	400/500	28-56	90/110	300-450
SHJ72A	72	400/500/600	28-56	132/160	400-700
SHJ82	82	400/500	28-56	185/200	800-1000
SHJ92	92	400	28-56	250/350	1000-1500
SHJ132	132	300	28-56	500/600	2000-3000



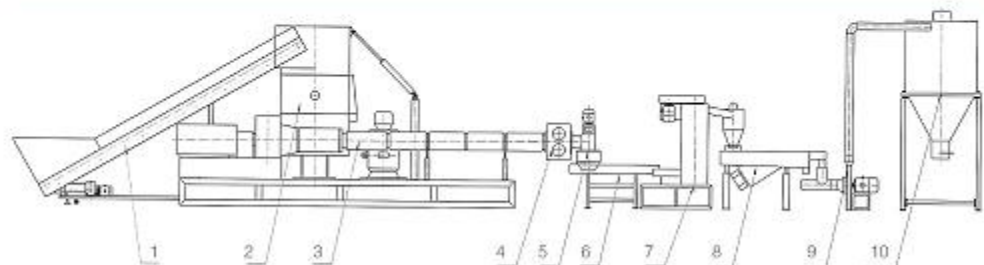
PE/PP Film pelletizing line

PE/PP薄膜造粒生产线

LY series film recycling pelletizer production line is the special equipment for the film recycling and pelletizing. With compacting machine, it could pre-compact the thin material into the small granule, making the automatic feeding material easier, and its efficiency improves the production. Cylinder type hydraulic changer with vacuum gas exhausting enables the non-stop changing filter and no leaking material. Pelletizing by Die-Face-Cut improves the pelletizing quality.

技术参数 Technical parameter

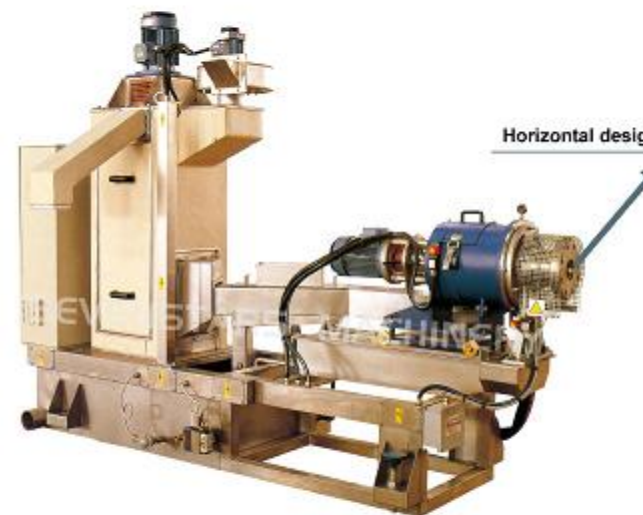
Model	Screw Diameter (mm)	Rotary Speed (rpm)	Main Motor Power(kw)	Compacting Machine Power(kw)	Output (kg/h)
SJ85-33	φ85	10-120	55	37	100-150
SJ100-30	φ100	10-120	90	55	200-300
SJ130-30	φ130	10-120	132	75	300-400
SJ160-30	φ160	10-120	160	90	500-600



1. Belt Conveyor 2. Compacting Machine 3. ML-100/30 Single Screw Extruder 4. Hydraulic Filter Changer 5. Die-Face-Cut System
6. Down Spouting 7. Centrifugal Drier 8. Vibration Screen 9. Air Loading System 10. Storage Hopper



Vertical design water-ring pelletizer



Horizontal design water-ring pelletizer

Water ring pelletizer with horizontal axis 水环切粒
For production varying from 100 to 1500kg/hr.
Suitable for the pelletization:
SAN, LDPE, HDPE, PP, ABS, PC, TPR.



Customer in Jordan



Customer in England



Customer in USA



Customer in Vietnam



Customer in Russian



Customer in Iran



Customer in Nigeria



Customer in Australia



Customer in Libya

SDJ SERIES TWO-STAGE COMPOUNDING EXTRUDER

SDJ系列双阶（双螺杆/单螺杆）混炼造粒机组

SDJ-72/180双阶（双螺杆/单螺杆）混炼造粒机组

SDJ-72/180 TWO-STAGE COMPOUNDING EXTRUDER
(TWIN SCREW EXTRUDER AND SINGLE SCREW EXTRUDER)



特点

- 机组为上阶同向平行双螺杆，混炼挤出自由落至下阶大口径单螺杆后加压、低速平稳、降温挤出造粒，两者呈垂直丁字型布置。
- 上阶同向平行双螺杆完成输送、高效塑化混炼，强剪切分散，由于无机头，整个加工过程处于无机头背压状态，避免了强剪切过热并大大提高生产能力，下阶单螺杆完成已塑化分散均匀物料的降温、高压、低速挤出造粒。
- 双阶机组的组合，将加工工艺分解为两步，提高了设备的独立加工变量，十分有利于材料的加工。
- 适应：热敏性高分子材料加工，如PVC各类电缆料，透明料，PE各类交联料，及PE屏蔽电缆料，鞋底发泡料等。

CONFIGUTATION&FEATURES

- 1ST stage is the twin screw extruder without die head, 2nd stage is the large size single screw extruder
- Twin screw is for shearing, dispersing and compounding process, no counter pressure because of no die head, which avoid temperature peak and ensure high output.
- Single screw is for cooling and creating pressure for extruding and cutting.
- Excellent compounding effectiveness and high output.

APPLICATION

- PVC compounds, foaming material, thermosets as well as all kinds of cable compounds i.e. PVC, XLPE, semiconductive, etc.

SDJ-82/190双阶（双螺杆/单螺杆）混炼造粒机组

SDJ-82/190 TWO-STAGE COMPOUNDING EXTRUDER
(TWIN SCREW EXTRUDER AND SINGLE SCREW EXTRUDER)



技术参数 Technical parameter

型号规格 Model Type	SDJ38/80		SDJ52/120		SDJ62/150		SDJ72/180		SDJ82/190		SDJ92/200	
	双 Twin	单 Single	双 Twin	单 Single	双 Twin	单 Single	双 Twin	单 Single	双 Twin	单 Single	双 Twin	单 Single
螺杆直径 Screw diameter(mm)	36	80	52	120	62	150	72	180	82	190	92	200
螺杆转速 Screw speed(rpm)	600	65/85	500	65-85	400/500	65-85	400/500	68/85	400/500	68/85	400	65/85
螺杆长径比 L/D ratio	26-48	7-10	26-48	7-10	26-48	7-10	26-48	7-10	26-48	7-10	26-48	7-10
驱动功率 Motor power(kw)	15-18.5	11-15	37-45	22-30	55-75	37-45	90-132	55-75	185-220	75-90	250-315	90-110
参考产量 (kg/h) Output for reference	15-150		100-350		300-500		600-1000		1000-1500		2000-3000	

UNDERWATER PELLETIZING SYSTEM

水下切粒机组



特色 Characteristic

- 超硬合金模头：寿命至少两年以上；
- 耐磨合金刀片：寿命至少一年
- 特殊的模头控温装置：功率可调，热效率高，最高功率可达10Kw；
- Ultra hard alloy die head: above life at least two years;
- Antifriction metal knives: life at least one year
- The special die head temperature control unit: adjustable power, the thermal efficiency is high, the max power possible to reach 10Kw;

适用物料 Suitable material

- 投条切粒粒外观差，水环无法切的情况，用此设备可以切除象原料一样的粒子，如PA、PET、纯PP等，或者PP含量较高的物料等。
- 目前已成功用在：TPU热熔胶、弹性体、EVA、PP（包括高熔指）、TPR、TPV、TPE、SBS、SEBS、PP微粒。
- The brace cuts a grain of outward appearance to be bad, and the water ring is unable to do. On this situation, this unit may cut some granule likely the raw material, like PA, PET, pure PP, or with high PP content material and so on.
- At present it has succeeded used in: TPU hot sol, elastomer, EVA, PP (refers including high melt refers), TPR, TPV, SBS, SEBS, PP micropellets.

技术参数 Technical parameter

型号 Model	产量 Throughput (kg/h)	模头孔径规格 Hole dia of die (mm)	机头加热功率 Heating power of die (kw)	切粒电机功率 Power of pelletizer (kw)	切粒电机转速 Speed of pelletizer (kw)	切刀调刀模式 Blade adjustment	水泵功率 Power of pump (kw)
UW10	5-100	0.6-0.4	4.8	1.1	1500-3000	机械调刀manual	0.55
UW10	100-300	0.6-0.4	3	4	1500-6000	机械或气动液压 Manual or Hyero Pneumatically	2.2
UW10	100-300	0.6-0.4	4.8	4	1500-8000		3
UW10	300-500	0.6-0.4	6.4	5.5	1500-3000		4
UW10	800-1500	2.0-4.0	导热油或蒸汽 Oil or steam	11	1500-3000		5.5



SJSZ Series Counter Rotation Conical Twin-screw Pelletizing Extruder

SJSZ 系列异向锥双造粒挤出机

特点 Features

该机组是由系列锥形双螺杆挤出机与相应造粒辅机组成的成套设备，主要适用于PVC、PE类原料添加木粉或填充料的造粒。生产的塑料颗粒均匀、密实、美观，辅机采用模面切粒，风送集料，振动分离冷却，具有自动化程度高，生产效率佳等特点。

This pelletizing machine is composed by a conical twin-screw extruder and the correspondingly pelletizing downstream equipment, it is suitable for the pelletizing of PVC, PE raw material with wood powder or other additives. The pellets produced by this machine is evenly, solid, elegant. The pelletizing downstream equipment is the die face cutter, air transferring unit, vibration separating and cooling unit. This pelletizing downstream equipment has the features of high automation and high production efficiency.



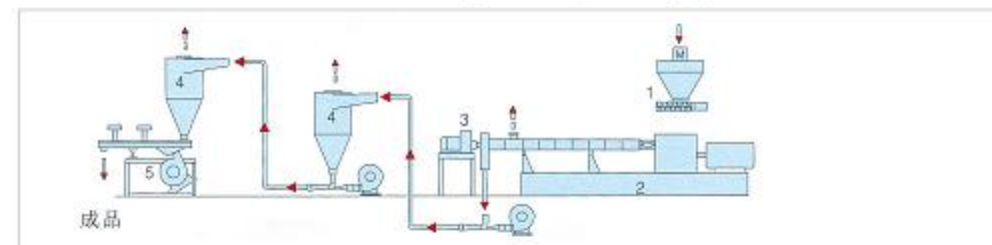
技术参数 Technical parameter

主机型号 Model	螺杆规格 mm	主电机功率 Power of main motor { KW }	生产能力 Output { kg/h }
SJSZ55/110	55/110	30	60-180
SJSZ65/132	65/132	37	180-250
SJSZ80/156	80/156	55	280-350
SJSZ92/188	92/188	110	350-500

Extruding & Palletizing Flow Scheme

物料挤出造粒流程图

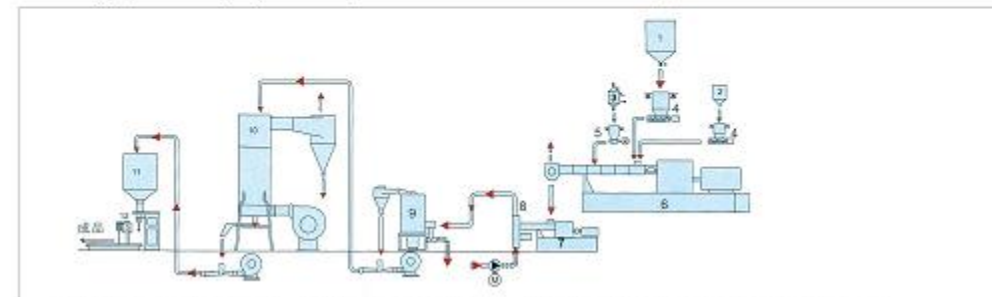
双螺杆风冷模面热切机组 Twin-screw air-cooling hot-face pelletizing system



1.计量喂料机 2.双螺杆主机 3.风冷热切粒机 4.旋风分离器 5.风冷振动筛
1. metering feeder 2. twin-screw extruder 3. air-cooling hot-face pelletizer 4. cyclone 5. vibrator

过氧化物交联电缆料双阶式机组

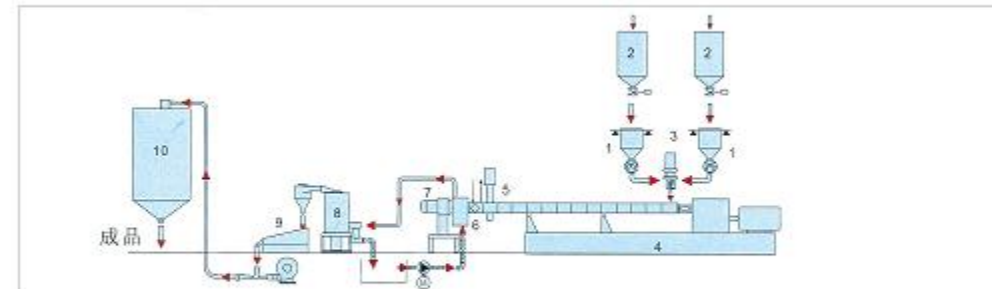
Two-stage pelletizing system for peroxide crosslinked cable compounds



1. PE原料仓 2. 抗氧剂料仓 3. DCP储罐 4. 失重电子秤 5. 失重式计量泵 6. 双螺杆主机 7. 单螺杆主机 8. 偏心水雾切粒机 9. 离心脱水机
10. 流化床 11. 成品料仓 12. 自动包装机

1. PE bin 2. anti-oxidants 3. DCP bin 4. loss-in-weight feeder 5. loss-in-weight pump 6. twin-screw extruder 7. single-screw extruder
8. eccentric fog-jetting pelletizer 9. centrifugal dewaterer 10. fluidized bed 11. finished product bin 12. automatic bagging

双螺杆水下造粒机组 Twin-screw under-water pelletizing system

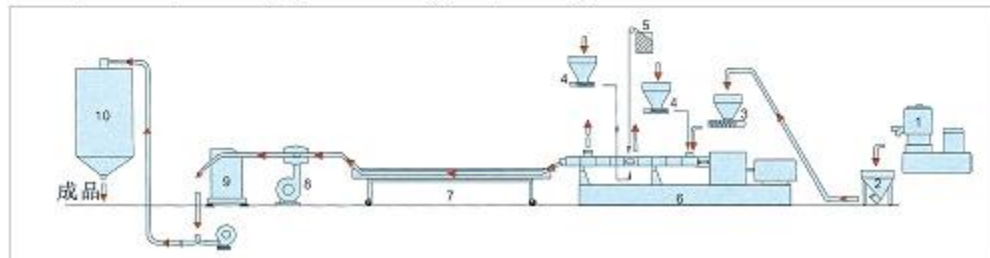


1. 失重式计量秤 2. 原料仓 3. 混合喂料系统 4. 主机 5. 开闭阀 6. 换网器 7. 水下切粒机 8. 离心脱水机 9. 振动筛 10. 成品料仓

1. loss-in-weight weigher 2. material bin 3. mixing & feeding 4. main extruder 5. diverter valve 6. screen changer 7. under water pelletizer 8. centrifugal dewaterer 9. vibrator 10. finished product bin

填充、共混、增强等拉条冷切粒机组

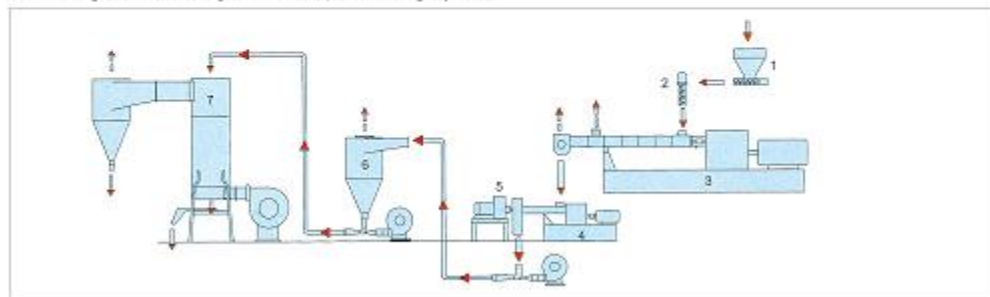
Cooling strands pelletizing system for filling, compounding and reinforcement



1.高混机2.螺旋上料机3.主喂料机4.侧向辅助喂料机5.玻纤长纱6.双螺杆主机7.水槽8.吹风机9.切粒机10.成品料仓
1.high-speed mixer 2.Upward screw-conveyer 3.main feeder 4.side feeder 5.glass fiber 6.twin-screw extruder 7.water trough 8.drying blower 9.pelletizer 10.finished product bin

双阶式风冷模面热切粒机组

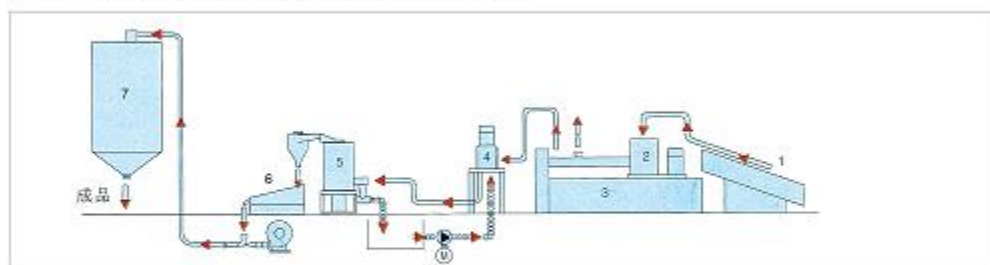
Two-stage air-cooling hot-face pelletizing system



1.计量喂料机2.立式强制加料机3.双螺杆主机4.单螺杆造粒机5.风冷热切粒机6.旋风分离器7.流化床
1.metering feeder 2.force-feeder 3.twin-screw extruder 4.single-screw extruder 5.air-cooling hot-face pelletizer 6.cyclone 7.Fluidized bed

废膜回收单螺杆造粒机组

Single-screw pelletizing system for film reclamation



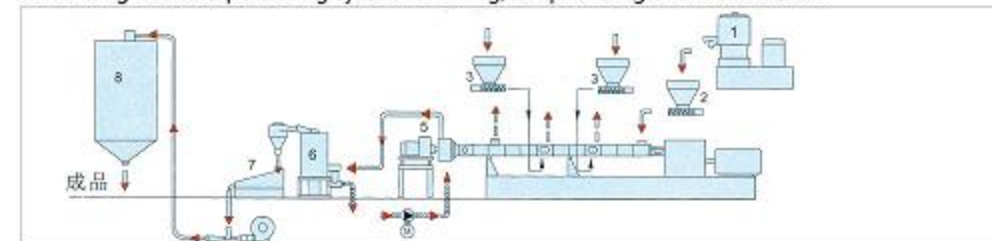
1.皮带输送机2.薄膜破碎机3.单螺杆排气挤出机4.立式水环切粒机5.离心脱水机6.振动筛7.成品料仓
1.belt conveyor 2.film compactor 3.single-screw devolatilization extruder 4.vertical water-ring hot-face pelletizer 5.centrifugal dewaterer 6.vibrator 7.finished product bin

Extruding & Palletizing Flow Scheme

物料挤出造粒流程图

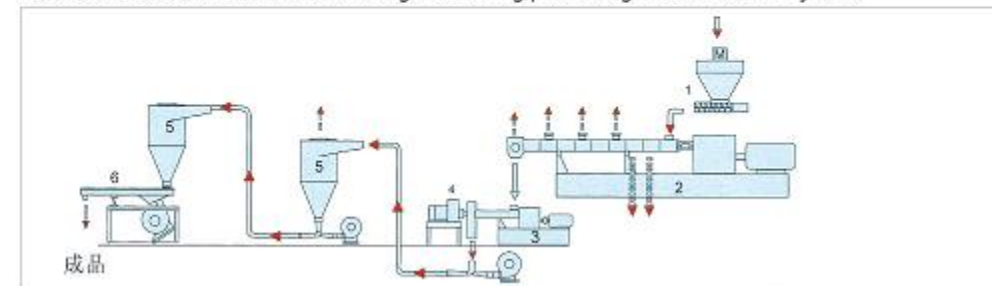
填充、共混改性水环热切粒机组

Water-ring hot-face pelletizing system for filling, compounding and modification



1.高混机2.主喂料机3.侧向辅助喂料机4.双螺杆主机5.水环热切粒机6.离心脱水机7.振动筛8.成品料仓
1.high-speed mixer 2.main feeder 3.Side-feeder 4.twin-screw extruder 5.water-ring hot-face pelletizer 6.centrifugal dewaterer 7.vibrator 8.finished production

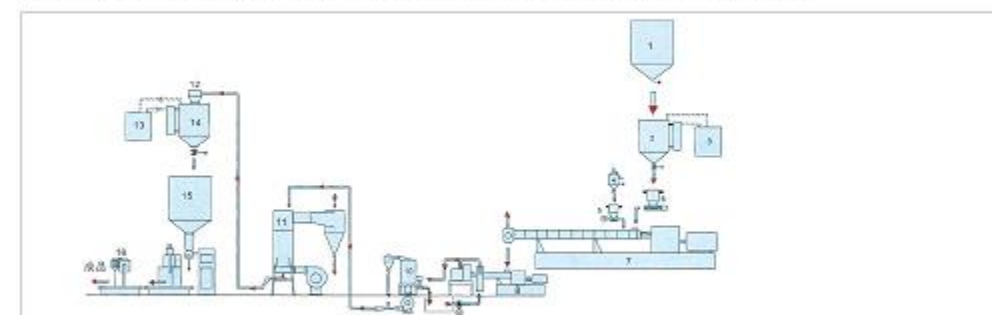
双阶式挤压脱水后处理造粒机组 Two-stage extruding, pelletizing and dewaterer system



1.湿粉喂料2.双螺杆排气、脱水主机3.单螺杆造粒机4.风冷热切粒机5.旋风分离器6.风冷振动筛
1.wet powder feeder 2.twin-screw extruder for dewatering and devolatilization 3.single-screw extruder 4.air-cooling hot-face pelletizer 5.cyclone 6.Vibrator

双阶式硅烷交联电缆料、管材料切粒机组

Two-stage pelletizing system for silane-crosslinked cable and pipe compounds



Downstream auxiliary equipment

造粒辅机系列



进料装置
Feed-in device



搅拌装置
Mixing equipment



螺旋上料机
Upward screw-conveyer



挡料块
Barring block



失重式计量称
Loss-in-weight weigher



筒体
Screw canister



螺杆元件
Screw elements



真空排气室
Vacuum extractor chamber



离心脱水机
Centrifugal de-water machine



旋风分离器
Cyclone



着色搅拌机
Repaint mixer



各类多路喂料系统
Various multipath feeding systems

Downstream auxiliary equipment

FS SERIES PLASTIC CRUSHER

FS系列粉碎机

适用于各种塑料、橡胶、织物、皮革、硬纸板、木料及铝箔的破碎，粉碎物外形可以是薄膜、片状、管状、浇口料及各类中空容器。

当粉碎量较大时，可配置喂料输送机、吸料风机、储料仓及除尘系列。

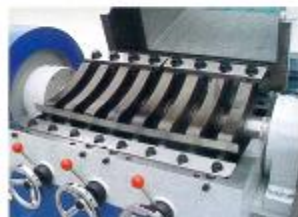
FS series is specially designed for crushing all kinds of plastic, rubber, fabric, leather, cardboards, timber, aluminum foil in the shape of film, sheet, sprue, tubular construction or container.

Conveyor belt, ventilator, storage silo and dust collecting system are available for larger output.



机体采用钢结构，刚性强，具有良好的抗冲击性。主轴系统经过平衡处理，机器运转稳定可靠。动刀呈V形排列，切削时工作物从两侧向中心滑动，减少机器两侧壁之摩擦。根据不同材料的粉碎要求，主轴上的动刀可设计成3组、4组或5组。

Rigid steel body to be resistant to impact. Balanced main shaft to ensure safety and smoothly running V-shape cutting geometry to minimize friction between crushing material and both interior sidewalls 3 groups, 4 groups or 5 groups of rotors available depending on different crushing material.



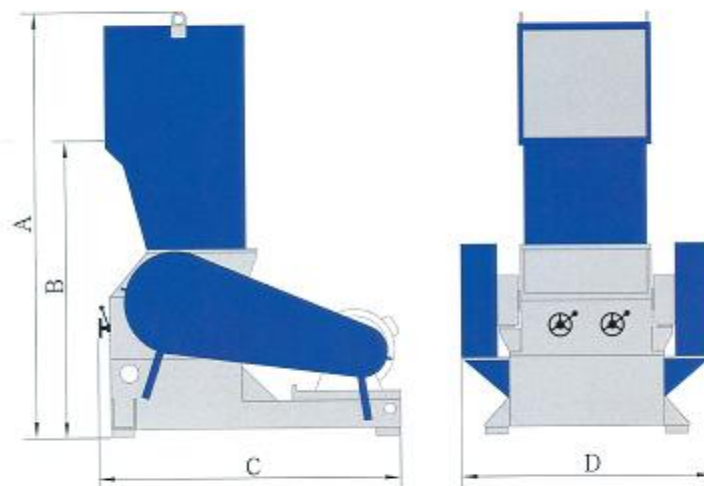
轴承安装在机体外部，粉尘或水不易侵入，散热良好，保养及维修简便易行。

External bearing built outside the main body for easy maintenance and optimum crushing abstraction.



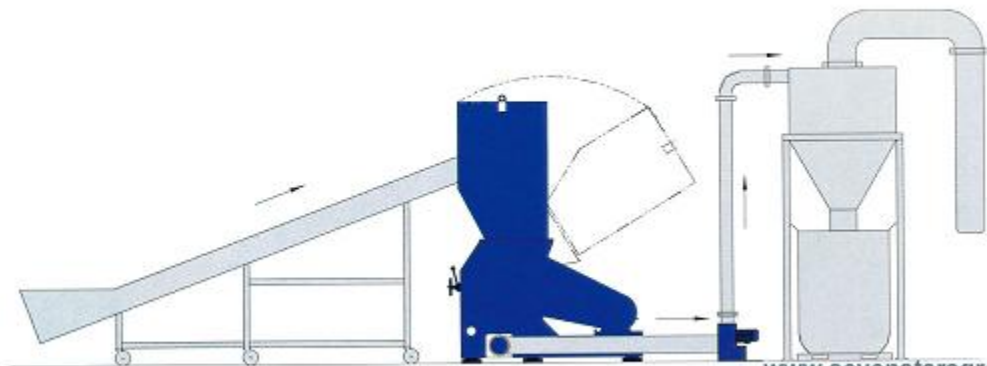
定刀、动刀刃磨后，刃口至支承螺钉的距离的调整在机外专用调整器内完成，换刀省时省力。

Separate calibration support for easily renewing blades and adjusting distance between blade edge and supporting bolts.



技术参数 Technical parameter

型号 Model	入料口径 FEED INLET (mm)	功率 POWER (kw)	定刀 STATOR (pc)	动刀 POTOR (pc)	料斗开启 HOPPER OPEN	重量 WEIGHT (kg)	A (mm)	B (mm)	C (mm)	D (mm)
FS300	300 × 310	4~5.5	2	3	手扳Manually	500	1600	1150	1180	670
FS450	350 × 460	5.5~11	2	6	手扳Manually	800	1700	1250	1280	1100
FS560	450 × 570	11~15	2	6	手扳Manually	1300	2100	1500	1450	1300
FS700	580 × 710	15~22	4	6	手扳Manually	2600	2450	1620	1900	1500
FS800	580 × 810	22~37	4	6	手扳Manually	3200	2550	1900	1900	1600
FS800A	750 × 810	37~45	4	8	液压Hydraulically	3800	2800	2100	2450	1700
FS1000	750 × 1010	45~55	4	8	液压Hydraulically	4200	2900	2050	2450	1900
FS1200	750 × 1210	55~75	4	8	液压Hydraulically	4600	2900	2050	2450	2150
FS1200Z	1000 × 1210	75~110	4	10	液压Hydraulically	7500	3500	2350	2800	2250



CLAW/TRIANGLE CRUSHER

爪刀及三角刀破碎机

特点 Features

- 爪刀型适用各种塑料之粉碎再利用，尤其对各类又硬又韧的塑胶（尼龙、工程塑胶、聚苯乙烯等）效果更佳。三角刀型适用于各类薄膜塑料。
- 破碎机操作方便，换刀更快捷。刀座利用剪刀原理制成独特的“爪刀式”，可分散受力度，使得每片刀的剪切力加大，提高刀具切削，减少刀具磨损。
- Claw style suitable for recycle and restore of all kinds of plastics, particularly for various hard and tough plastics such as nylon, polystyrene. Triangle style more suitable for film plastic.
- The crusher is easy to operate and easy to replace the cutters. The bearings of the cutters are specially designed to increase cutting power effectively and reduce wear and tear.



BDXPS HEAVY CRUSHER UNIT

BDXPS系列强力破碎机

特点 Features

BDXPS系列强力破碎机采用经济的设计完美的优质钢材焊接结构。转子采用最新的V形切割技术，可将破碎材料送至转刀中央，这避免了材料在侧壁上的冲击，同时也增加了侧壁的耐磨性，减少破碎粉尘。主轴采用优质材料加工而成，总成经动、静平衡校验，具有韧性好、工作中不易变形、工作状态稳定震动小等特点。

适用于破碎小管材、型材、板材、注塑浇口料、各类塑料包装容器及薄膜等。SEVENSTARS还可根据用户的要求提供配套的破碎辅助设备，如：集料抽吸机组、送料输送带、金属分离器。

BDXPS series crushers have the economical design and perfect jointing structure of good grade steel. The rotor with new V type cutting technology not only can ensure the material be delivered in the center of the rotating blades and avoid the impact on the sidepiece, but also can make the sidepiece wearable and reduce working powder. The main axis is processed with high quality steels after verifying the balance. Good toughness, stable working state, low shake are the main features.

This kind of crusher can be used in crushing small size pipe, sheet material, plastic material or various of packing containers, film and so on. SEVENSTARS also can provide relevant auxiliary equipment in accordance with our customers' requirements such as material collection pumping sets, feeding conveying system and metal segregator.



技术参数 Technical parameter 爪刀 CLAW BLADES

型号 Model	粉碎口径 (mm) Crushing Chamber	粉碎能力 (kg/h) Crushing Ability	旋转刀 (pcs) Rotary Blade	固定刀 (pcs) Fixed Blade	电机功率 (kw/hp) Motor Power	外形尺寸 (mm) Dimensions	重量 (KG) Weight
PS390	390×270	200-300	21	2	4/5.5	1200×870×1350	680
PS490	490×300	300-350	21	2	7.5/10	1400×970×1530	900
PS580	580×340	300-400	27	4	11/15	1650×1060×1640	1000
PS720	720×480	450-600	27	4	15/20	2400×1640×2200	1800

技术参数 Technical parameter 三角刀 TRIANGLE BLADES

型号 Model	粉碎室口 (MM) Crushing Chamber	破碎能力 (KG/H) Crushing Ability	动刀 (PCS) Rotary Blade	定刀 (PCS) Stationary Blade	功率 (KW/HP) Motor Power	机械尺寸 (MM) Dimensions	重量 (KG) Weight
PC400	420×275	350-500	3	2	7.5/10	1250×910×1340	500
PC500	520×300	450-600	6	2	11/15	1410×1020×1500	650
PC600	620×340	600-800	6	4	15/20	1810×1200×1770	900
PC800	773×460	800-1000	9	4	22/30	2400×1700×2200	1860
PC800	773×460	800-1000	9	4	37/50	2400×1700×2200	1860
PC900	870×460	1000-1200	9	4	37/50	2400×1800×2200	2000
PC900	870×550	1000-1200	9	4	37/50	2400×1800×2200	2000
PC800	870×550	1000-1200	9	4	45/60	2400×1800×2200	2000

技术参数 Technical parameter

型号 Model	进料口尺寸 Feed inlet (mm)	主电机功率 Power of main motor (kw)	转刀数量 (件) Rotors	定刀数量 (件) Stators	转子旋转直径 Rotor diameter (mm)	参考产能 Output (kg/h)
BDXPS180	270×300	4	30	2	Ø 180	50
BDXPS180	300×200	5.5	6	2	Ø 200	100
BDXPS180	450×350	7.5-11	6	2	Ø 350	150
BDXPS180	560×400	11-22	6	2	Ø 400	300
BDXPS180	700×500	22-37	6-10	4	Ø 500	500
BDXPS180	800×600	37-75	6-10	4	Ø 600	600

FX SERIES PLASTIC PIPE CRUSHER

FX系列管材粉碎机

适用于细长的型材及管材的粉碎。

FX series is specially designed for crushing long and narrow profile shapes or pipes.



足够大的刀具回转直径，使得细长的粉碎物可从圆周自动切入。
轴承安装在粉碎腔外，避免粉尘侵入，延长使用寿命，易于维护。

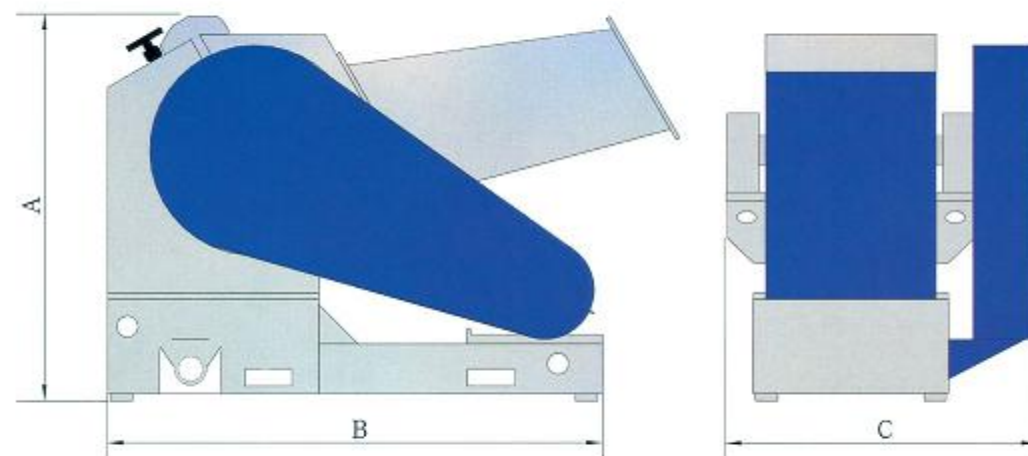
Enough blades gyration diameter for easily cutting long and narrow profile shapes or pipes.
External bearing built outside the main body for easy maintenance and longer service life.



采用筛网托架开合机构设计，方便筛网的拆装。
Screen-bracket mechanism for easily removing or changing screen

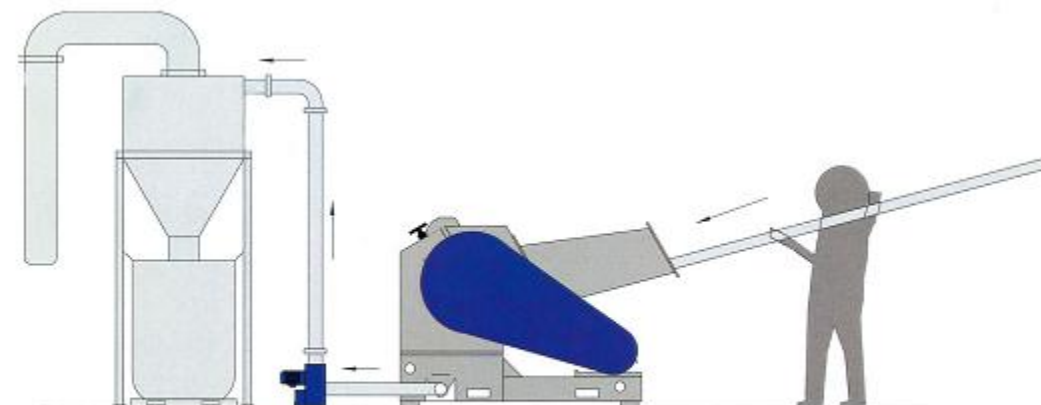


独特的料斗开合摇手机构设计，料斗打开、关闭更安全方便。
Crank handle for safely and easily opening or closing hopper



技术参数 Technical parameter

型号 Model	功率 POWER (kw)	定刀 STATOR (pc)	动刀 POTOR (pc)	回转直径 GYRATION DIAMETER (mm)	切削宽度 CUTTING WIDTH (mm)	A (mm)	B (mm)	C (mm)
FX500	22	2	4	500	450	1400	1900	1000
FX700	30	2	5	700	600	1600	2470	1250



FG SERIES PLASTIC PIPE CRUSHER

FG系列管材粉碎机

适用于大口径厚壁PE管、PPR管、PVC管的粉碎。
可与FS系列粉碎机配套使用，粉碎颗粒更细小。

FG series is specially designed for quickly milling and cutting large thick-wall plastic pipes

It is integrated with FS series optionally for smaller granular.



技术参数 Technical parameter

型号 Model	主电机功率 MOTOR POWER (kw)	牵引功率 DRAFTER POWER (kw)	最大粉碎直径 MAX. PIPE (mm)	主轴回转直径 GYRATION DIAMETER (mm)	重量 WEIGHT (kg)	长 LENGTH (mm)	宽 WIDTH (mm)	高 HEIGHT (mm)
FG400	18.5	4	Φ400	Φ500	3000	2400	1200	2800
FG600	22	5.5	Φ630	Φ700	3500	2800	1400	3000
FG800	30	7.5	Φ800	Φ700	4000	2800	1600	3200

BDXSSG the tubing tears into shreds the unit

BDXSSG管材撕碎机组

特点 Features

BDXSSG系列撕碎机可用于直径1200MM的PE、PP、PVC管材撕碎，长度达6-9M的管材直接无需切割，其转速缓慢运转平稳，各种管材放入水平的喂料槽中，喂料槽自动关闭由液压推进将管材推向轴中心进行破碎。撕碎机破碎后的材料通过输送机带入二次破碎完成需要的破碎颗粒直径。BDXSSG系列撕碎系统最主要的优势在于避免电流高，节省能耗，整个系统由一个中心控制系统控制。

BDXSSG Crusher is able to crush the PE, PP, PVC pipe with dia.1200mm, the length of 6-9m pipe can be crushed directly without cutting, and the rotary speed is slow and stable. Variety of pipes is put into the flat feeding tank, and the tanks closed automatically, and push the pipe by hydraulic into the center axis for crushing. The material after crushing is transported by conveyor for secondary crushing in order to get the requested granule.

BDXSSG Crusher has the main advantage of energy saving, and the system is controlled by center control system.



技术参数 Technical parameter

型号 Model	喂料口 (mm) Feed dia	转子刀片直径 (mm) Rotor blade swing diameter	转速 (rpm) Rotor speed	驱动功率 (kw) Drive power	转子刀片数 (pcs.) Rotor blade quantity	定刀数 (pcs.) Fixed blade quantity	筛网尺寸 (mm) Screen Size	破碎腔最大尺寸 (mm) Crush chamber size max	整机功率 (kw) Mechanical pusher power
BDXSSG-630A/B	750×750	Φ800	41	2×30/37	56	3	20-100		11
BDXSSG-800A/B	1000×1000	Φ1000	37	2×45	96	4	20-100		15
BDXSSG-1200A/B	1500×1500	Φ1500	23	2×55	200	6	20-100		15

通用型，广泛用于各种材料的细化。General type, it is broad applied to refine variety of material

A型转子刀片为通用，适合大块空心体及厚壁材料，Type "A" rotor blade is relative general, which is suitable for the massive hollow material

B型转子刀片适合轻型材料，如纸板、纸浆木材和食品，Type "B" rotor blade is suitable for light material, such as cardboard, sheet wood and foodstuff

C型转子刀片相对更具有切割性及耐磨性，适合薄膜和纤维材料，Type "C" rotor blade is relative provided with slicing and antirend, which is suitable for film and fiber material

GL SERIES TWO SHAFT SHREDDER

GL系列双轴撕碎机

特点 Features

为了环保并适合不同的产量要求和破碎对象, SEVENSTARS推出GL型撕碎机。该机坚固、耐用。适用于废旧轮胎、中空油桶、废旧电器外壳、电线、电缆的破碎回收。低速的转子刀, 低噪音、高产量、更节能。

To protect environment and suit for different output requirement, SEVENSTARS produce GL shredder, this kind of shredder is solid and has long using time, it is suitable for crushing wood, different kind of plastic, plastic film and paper. Low speed rotor knife, low noise, high output and high save energy.



技术参数 Technical parameter

Model	GL32120	GL2160	GL40130	GL3260	GL32100
Rotor diameter(mm)	Φ284	Φ284	Φ514	Φ430	Φ430
Spindle speed (r/min)	15	14	14	15	15
Qty of rotary blade (PCS)	25	40	32	20	25
Thickness of blades (mm)	40	20	40	40	40
Motor power (KW)	22+22	7.5+7.5	37+37	15+15	22+22
Weight (KG)	7000	2400	12000	4600	5400
Capacity of the machine (kg/h)	depend on different kinds of plastic and rubber material				

Our double shaft shredding machine adopts the advanced technology introduced from Europe, and passed the CE Certification of Quality System. Low speed, high torque, low noise.



Plastic Drums Shredding



Metal Drums Shredding



Wood Shredding



Film Shredding



WT SERIAL SINGLE AXLE SHREDDER

WT系列单轴撕碎机

特点 Features

为了环保并适合不同的产量要求和破碎对象，SEVENSTARS推出WT型撕碎机。该机型坚固、耐用。适合用于木材的破碎利用、各种塑料大块实心体、难处理材料、塑料薄膜、纤维、纸张的破碎回收。低速的转子，低噪音，高产量、更节能。

To protect environment and suit for different output requirement, SEVENSTARS produce WT shredder, this kind of shredder is solid and has long using time. It is suitable for crushing wood, different kind of plastic, plastic film and paper. Low speed rotor knife, low noise, high output and high save energy.



技术参数 Technical parameter

型号(model)	WT300	WT400	WT500	WT600
动刀数量 (qty of rotated blade)	22	20	24	28
定刀数量 (qty of fixed blade)	2	2	2	4
回转直径 (mm) (rotated diameter)	Φ 150	Φ 220	Φ 220	Φ 220
进口料尺寸 (mm) (input size)	300 × 300	400 × 400	500 × 500	600 × 800
功率 (kw) (motor power capacity)	4	11	15	18.5
液压功率 (kw) (hydraulic power capacity)	0.75	0.75	2.2	2.2
重量 (kg) (weight)	300	1100	1100	2200
长 × 宽 × 高 (mm) (L × W × H)	1200 × 800 × 1100	1300 × 170 × 2000	1300 × 170 × 2000	1300 × 170 × 2000
筛网直径 (mm) (mesh diameter)	22	22	22	22
转速 (rotation speed)	80-100	80-100	80-100	80-100

型号(model)	WT800	WT1000	WT4080	WT40120	WT4080
动刀数量 (qty of rotated blade)	46	64	46	10	10
定刀数量 (qty of fixed blade)	4	4	4	2	2
回转直径 (mm) (rotated diameter)	Φ 400	Φ 400	Φ 400	Φ 400	Φ 400
进口料尺寸 (mm) (input size)	800 × 800	1000 × 1000	800 × 800	120 × 120	150 × 150
功率 (kw) (motor power capacity)	37	45	37	1.5	1.5
液压功率 (kw) (hydraulic power capacity)	2.2	3	2.2	0.25	0.25
重量 (kg) (weight)	3100	1500	3100	3000	3000



Blocks Shredding



Crates And Drums Shredding



Film Shredding



Wooden Pallets Shredding



High performance rotor;

This rotor is suitable for medium and soft material such as PE, PP, PET plastics, wood, paper, cables and etc.



Hard Material Rotor;

This rotor is suitable for very strong material such as ABS, PC and Nylon; deep segments make the cutting points closer to the axis of groove to protect knives and reduce noise.



Film Rotor;

Special arrangement of cutting tools can prevent flexible film from winding on the rotor; agricultural film contains lots of sands and mud, hardox painted surface can protect the rotor to avoid the abrasion caused by sands.

FILM AGGLOMERATOR

薄膜团粒机

特点 Features

适用于塑料化纤及塑料薄膜回收后造粒。具有高速造粒，是造粒机的必备设备之一。

可对软聚氯乙烯、高低压聚乙烯、聚苯乙烯、聚丙烯及其它热塑性塑料的废弃制品或薄膜进行团粒，亦可对发泡聚苯乙烯的废弃制品进行造粒。

Plastic Agglomerate will be a waste of thermoplastic film and wall thickness of less than 2 millimeters products direct granulation equipment, it can make granule for soft PVC, high-low-pressure polyethylene, polystyrene, thermoplastic polypropylene plastics and other waste products, or the films, also be of granulation for the abandoned polystyrene foam products.

The main shaft is metal processed after being heat-treated and adjusted straight and this machine is of low noise but high output, with the removable blade as the fixed blade, resulting in convenient repair and maintenance.

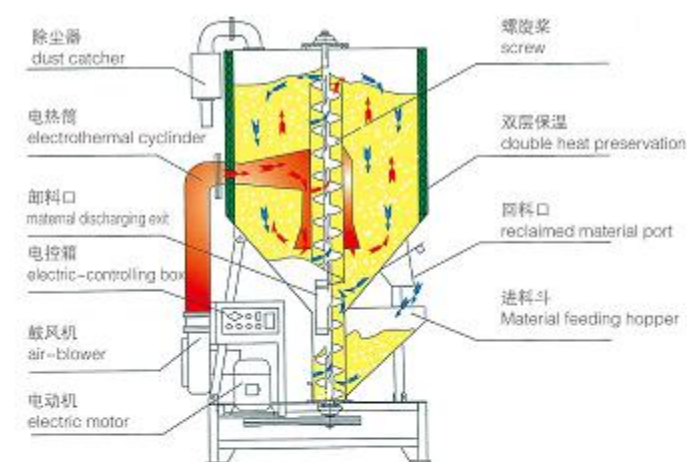


技术参数 Technical parameter

型号 Model	Motor Power(Kw)	Volume(L)	Output(kg/h)	Rotary blade(pc)	Fixed blade(pc)	Dimension (L x W x H)(MM)	Rotating speed(rpm)
GHX200	55	200	150-180	6	2	2200 x 800 x 1600	950
GHX300	75	300	200-250	6	2	2200 x 900 x 1800	850
GHX500	90	500	270-350	6	2	2400 x 800 x 1600	850

PLASTIC PELLET MIXING DRYER

塑料粒子干燥混色机



落地式干燥混色机工作原理示意图

Sketch map of performance principles of floor type drying & color-mixing machine

heated wind flow material flow



BDX-V series of color-mixing machine

本机提供螺旋反转清料功能，使螺旋桨面的原料落回底部清料口处，便于清料操作。

This machine offers the function of reverse discharging, which enables the material on the screw to fall back to discharging exit on the bottom that is convenient for discharging operation.

技术参数 Technical parameter

型号 Model	容量* Capacity (Kg)	电热功率 Electrothermal power (Kw)	鼓风机功率 Fan Power (Kw)	螺旋桨功率 Screw Power (Kw)	机械尺寸 Machine Dimensions L x W x H (mm)	重量 Weight (Kg)
BDX-F300	300	9	0.75	2.2	1500 x 1050 x 2280	400
BDX-F500	500	9	0.75	2.2	1600 x 1100 x 2460	440
BDX-F1000	1000	15	1.1	4	1800 x 1350 x 3150	610
BDX-V300	300			2.2	1370 x 1050 x 2280	310
BDX-V500	500			2.2	1450 x 1100 x 2460	350
BDX-V1000	1000			4	1650 x 1350 x 3150	520