

年产1.8万吨 PVC软管生产工艺流程说明/PVC HOSE Processing Flow Chart 18000MT/YEAR

步骤	STEP	步骤说明: Step description:					
1	物料准备	MATERIAL PREPARATION	PVC SG-5	DBP/丁酯	PFW/石蜡	Methyl tin181/稳定剂	COLOR/颜色
2	混合	MIX	使所有物料均匀混合约30~45分钟/Mix all materials evenly for about 30~45 minutes				
3	加温	HEATING	140--160°C加温融化, 增强塑化效果Heating and melting at 140--160°C to enhance the plasticizing effect				
4	挤出	CO-EXTRUSION	螺杆加温塑化根据软管使用环境挤出不同硬度的颗粒The screw is heated and plasticized to extrude particles with different hardness according to the environment in which the hose is used				
5	造粒	GRANULE	将PVC塑料颗粒收集, 备用Collect PVC plastic granule for later use				
6	冷却	COOL DOWN	等待塑料颗粒自然降温Waiting for PVC granule to cool down naturally				
7	再融	HEATING AND REMELTING	140--160°C加温融化, 二次塑化使软管生产塑化更均匀, 增强使用强度和软管寿命Heating and melting at 140--160°C, the secondary plasticization makes the plasticization of the hose production more uniform, and enhances the service strength and hose life				
8	挤出	SQUEEZE OUT	将颗粒通过模具做成客户要求的内外径规格Pass the granule through the mold to make the inner and outer diameter specifications required by the customer				
9	牵引	TRACTION	根据不同规格适当调整速度Properly adjust the speed according to different specifications				
10	绕线/钢丝	WINDING/STEEL WIRE	根据不同规格绕线或者钢丝, 绕线可分为彩线、合股线等, 钢丝可以调整簧距和钢丝直径。线管可做6层, 钢管可做线管复合According to different specifications of winding or steel wire, the winding can be divided into colored wire, ply wire, etc. The steel wire can adjust the spring distance and wire diameter. The fiber hose can be made of 6 layers, and the steel wire hose can be used as a fiber reinforced composite				

11	喷码	PRINTING CODE	根据客户要求喷码、米标或者商标Spray code, meter mark or trademark according to customer requirements
12	检测	TEST	检测内径、壁厚、偏壁、剥离强度、重量、体积等是否符合要求Detect whether the inner diameter, wall thickness, partial wall, peel strength, weight, volume, etc. meet the
13	包装	PACKING	按照体积包装, 缠膜并贴标签Packed by volume, wrapped and labeled
14	成品	FINISH PRODUCTS	检查订单数量, 检查包装和标签粘贴是否牢固, 准备入库Check the order quantity, check whether the packaging and labeling are firm, and prepare for storage
15	入库	STORAGE	阴凉干燥处, 避光室温储存Store in a cool and dry place, away from light and room