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**三联机械**  
S.L MACHINERY

## 泉州市三联机械制造有限公司

QUANZHOU CITY SANLIAN MACHINERY MANUFACTURE CO.,LTD.

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# MACHINERY

**高端伺服 三联品质 领航固废制砖技术新风向**  
High End Servo, Sanlian Quality, Leading The New Trend Of Solid Waste Brick Making Technology

**高端伺服制砖生产线**  
**海绵透水生态砖生产线**  
**高端PC仿石景观砖生产线**  
**建筑固废再生骨料制砖生产线**  
**装配式墙板生产线**

High-end Servo Brick Making Equipment  
Permeable Brick Making Plant for Spnoge City  
Imitation Stone Precast Concrete Block Production Line  
Brick Making Equipment for Recycling Solid Wasted Resources  
Wall Panel Production Line





**三联机械**  
S.L MACHINERY

关于我们 ABOUT US

泉州市三联机械制造有限公司是专业制造，销售智能化多功能砌块成型设备、装配式保温墙板设备、混凝土搅拌站及沥青混合料搅拌设备的国家高新技术企业。

公司成立于1993年，拥有3大厂区，140,000平方米现代化工业园区，50,000平方米标准厂房，已通过ISO9001、14001、OHSAS18001，知识产权管理体系和CE等认证，产品遍布全球6大洲，远销欧洲、美洲、非洲、中东、东南亚等上百个国家和地区。截止2023年12月，累计用户已超过6500个。是南安市“纳税大户”和“明星企业”，泉州市产业龙头企业，泉州市和福建省“守合同重信用企业”，“泉州市军民融合企业”，泉州市数控一代示范项目产品，中国农业银行福建分行“AAA级信用企业”，福建省科技型及创新型企业，福建省科技小巨人领军企业，福建省智能制造重点项目，福建省首台套重大技术装备认定，中国全军武器装备采购平台会员单位及“十二五”全国墙材革新创新标杆企业，国家高新技术企业，董事长傅俊元同志2019年被授予“改革开放40年福建机械行业创新贡献企业家”荣誉称号，2021年6月荣获“全国建筑固废资源化最佳实用技术（BAT）”称号。

公司秉承“致力于全球环保事业”及“成就完美建筑”的经营理念，至今已在机械市场挥斥方遒近30年。凭借强大的研发能力，目前已拥有多项科研成果，200多项专利技术及3项国家版权局计算机软件著作权登记证书覆盖所有产品领域，引领产业发展，成为中国墙体材料技术装备制造先锋。

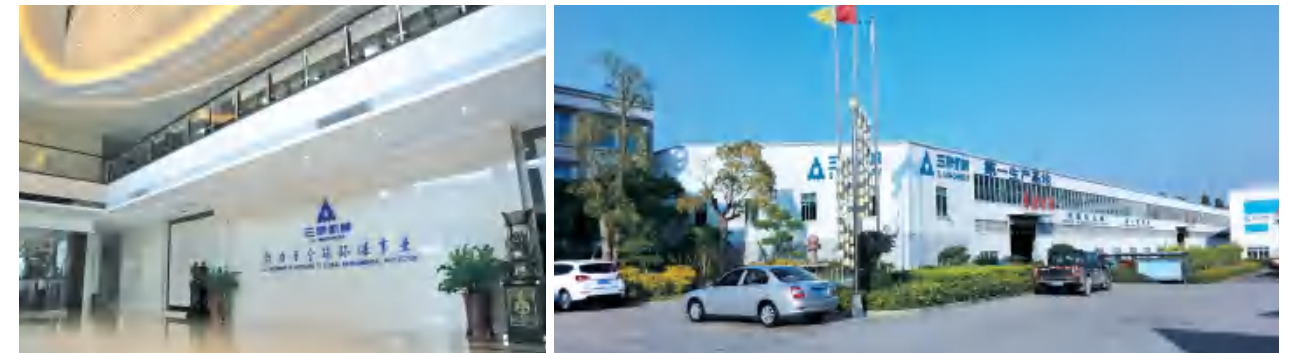
Quanzhou Sanlian Machinery Manufacturing Co., Ltd. is a national high-tech enterprise specialized in manufacturing and selling intelligent multifunctional block machine, prefabricated thermal insulation wall panel production line, concrete mixing plant and asphalt mixture mixing equipment.

Sanlian Machinery was founded in 1993, with 3 large factories, 140,000 square meters of modern industrial parks, 50,000 square meters of standard factory buildings, has passed ISO9001, 14001, OHSAS18001, intellectual property management system and CE certification, the products are all over the world six continents, exported to Europe, America, Africa, the Middle East, Southeast Asia and other hundreds of countries and regions. By December 2023, the total number of users has exceeded 6,500. Nanan "large taxpayer" and "star enterprise", and "defend the contract heavy credit enterprise" of fujian province quanzhou city, fujian branch of agricultural bank of China "" AAA grade credit enterprise", science and technology and innovative enterprises in fujian province, a member of the Chinese army weapon equipment procurement platform and the "twelfth five-year" national wall materials innovation benchmarking enterprise, chairman comrade Fu Jun yuan in 2019 was awarded the "reform and opening up 40 years fujian machinery industry innovation contribution entrepreneurs" title of honor.

Adhering to the business philosophy of "commitment to global environmental protection" and "achievement of perfect architecture", the company has been in the machinery market for more than 30 years. With strong research and development ability, many scientific research achievements and hundreds of patented technologies should cover the products, leading the industrial development, and becoming the pioneer of wall material technology and equipment manufacturing in China.



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# Patents Collection

## 专利集锦



外观专利/Appearance Patents

发明专利/Invention Patents

实用新型专利/Utility Model Patents







SLST1500 - 500T  
SLST1500 - 1500T  
SLST2000 - 500T  
SLST2000 - 1500T

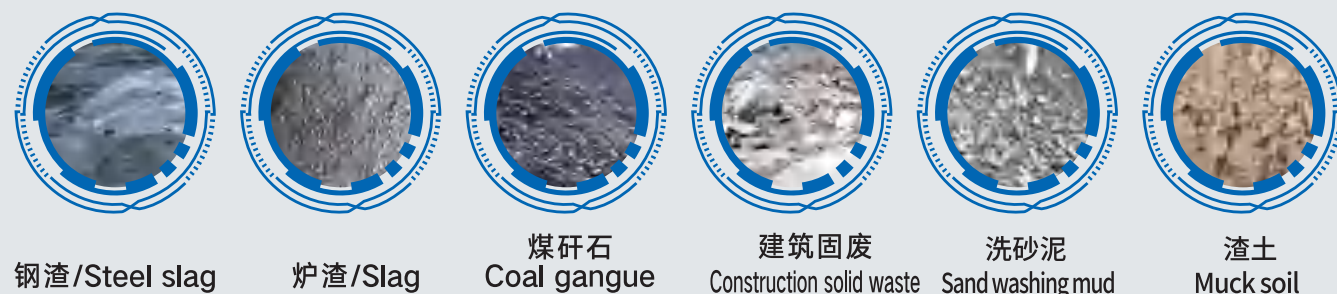


全自动伺服振压一体机设备，最大吨位可达1500t，主要针对新型固废材料，如渣土、泥土等细粉料，以及常规的建筑垃圾、钢渣、炉渣、煤矸石、工业尾矿等。整体铸件成型，稳固可靠，高吨位油缸，有效保证产品抗压强度、抗折强度、透水系数、抗冻溶等相关指标。

The fully automatic servo vibration and compression integrated machine equipment can reach a maximum tonnage of 1500t, mainly targeting new solid waste materials such as slag, soil and other fine powder materials, as well as conventional construction waste, steel slag, furnace slag, coal gangue, industrial tailings, etc. Integrated casting molding, stable and reliable, high tonnage oil cylinder, effectively ensuring product compressive strength, flexural strength, permeability coefficient, frost resistance and other related indicators.

#### 原材料 / In Terms Of Raw Materials

01



钢渣/Steel slag

炉渣/Slag

煤矸石  
Coal gangue

建筑固废  
Construction solid waste

洗砂泥  
Sand washing mud

渣土  
Muck soil

#### 技术参数/Technical Parameters

型号/Model	SLST1500-500T	SLST1500-1500T	SLST2000-500T	SLST2000-1500T
托板尺寸(mm) Pallet Size(mm)	1400*1200		1400*1350	
最大成型面积(mm) Max.Molding Area(mm)	1310*1150		1310*1300	
成型高度范围(mm) Product Height(mm)	45-500		45-500	
生产模式 Production Mode	振压一体 Vibration and compression	振压一体/纯振动/纯静压 Vibration and compression/ Pure vibration/ Pure hydraulic pressure	振压一体 Vibration and compression	振压一体/纯振动/纯静压 Vibration and compression/ Pure vibration/ Pure hydraulic pressure
伺服驱动轴 Servo Drive Shaft	4		8	
主油缸吨位/T Main Oil Cylinder Tonnage/ T	500	1500	500	1500
激振力/KN Excitation Force/KN	400		470	
如果所要求的托板尺寸或产品高度未在此列举，我们非常乐意为您制定特殊方案。 If the required pallet size or product heights are not listed here, we are happy to make special plans for you				

#### 产能表/Production Table

型号/Model	砖样规格 Brick Size	产能(单板) Production(Per mould)	产能(8小时/班) Production(8h one shift)
SLST1500-500T	空心砖Hollow Brick 390x190x190mm	15	约28,000块 394m³
SLST1500-1500T	实心砖Solid Brick 240x115x53mm	94	约225,600块 330m³
	路面砖Paver 200x100x60mm	60	约86,400块 1700m²
SLST2000-500T	空心砖Hollow Brick 390x190x190mm	18	约34,000块 480m³
SLST2000-1500T	实心砖Solid Brick 240x115x53mm	105	约252,000块 368m³
	路面砖Paver 200x100x60mm	72	约103,000块 2000m²
不同材料不同配比产量有所区别 / Difference between different raw material and ratio 如配排砖码垛系统产量可能会受影响 / If a cuber is required, the capacity may be affected			



#### 主油缸/Main Cylinder

02

主油缸最大吨位可达到500-1500T，湿法与干法工艺结合，多模式可选，模拟双压模式/单压振动模式/纯振动模式，使产品面层和底层集合更加可靠，面层质量强度更高，最大降低深加工对面层造成的影响；主机部分采用铸件工艺，一体成型，确保设备在高吨位施加压力时不会出现变形或者开焊问题，稳定、可靠。

The maximum tonnage of the main oil cylinder can reach 500-1500T. It combines wet and dry processes and has multiple modes to choose from. Simulated dual pressure mode/single pressure vibration mode/pure vibration mode, making the surface and bottom layers of the product connect more firmly and improving the quality of the surface layer. Higher strength, minimizing the impact of deep processing on the surface layer; the main machine adopts casting technology and is integrally formed to ensure that the equipment will not deform or open welding when high tonnage pressure is applied, making it stable and reliable.

#### 侧移装置/ Main Oil Cylinder Lateral Displacement Device

03

侧移装置：做路沿石时，路沿石模具可增加侧移装置，满足产品横面和立面添加面层的要求，使产品横面和立面均能达到光面要求。

Lateral displacement device: When making curbstones, the curbstone mould can be added with a side shifting device to meet the requirements for adding surface layers to the side and vertical surfaces of the product, so that both the side and vertical surfaces of the product can meet the smooth surface requirements.



#### 上模加热系统/ Upper Mould Heating System

04

上模加热系统：保证上模在恒温40°下工作，生产面层时可以增加材料的水分，不会造成黏膜，使之强度等级更高。

Upper mould heating system: Ensure that the upper mould works at a constant temperature of 40°. When producing the surface layer, the moisture of the material can be increased without causing mucous membrane, making the strength level higher.





# SLST2400 大型水工生态墙生产线

## SLST2400 Large Hydraulic Ecological Wall Production Line



2022年新推出SLST2400超大型水工砖生产设备，产品主要针对大型水工砖、挡土墙的生产。同时在满足水工砖的生产前提下，也可更换模具，生产PC仿石砖、路沿石、透水砖等高附加值的产品，为客户快速实现经济效益。

In 2022, SLST2400 ultra large hydraulic brick production equipment was launched, mainly targeting the production of large hydraulic bricks and retaining walls. At the same time, on the premise of meeting the production requirements of hydraulic bricks, molds can also be replaced to produce high value-added products such as PC imitation stone bricks, curbstones, permeable bricks, etc., to quickly achieve economic benefits for customers.

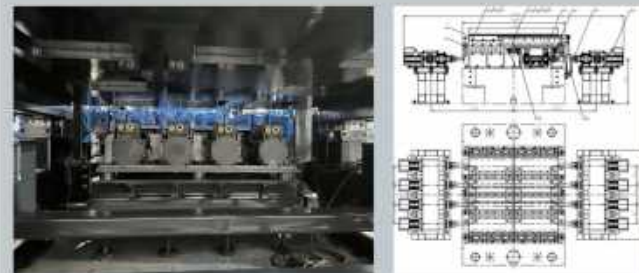
### 功能优势 / Functional Advantages

#### 01 超大成型面积 Extra Large Molding Area

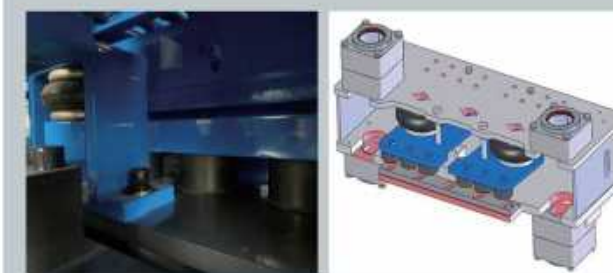
可支持最大成型面积1500\*1300\*600mm  
突破行业成型极限1300\*1300\*500mm  
The biggest feature: can support a maximum forming area of 1500mm\*1300mm\*600mm  
breaking the industry's molding limit of 1300mm\*1300mm\*500mm



#### 02 高端伺服八轴双振系统 High End Servo Eight Shafts Dual Vibration System



#### 03 振动台悬浮系统 Vibration Table Suspension System



#### 04 布料前后双驱设计，精准快速卸料 Front And Rear Dual Drive Design On Material Charging For Precise And Fast Unloading



### 技术参数/Technical Parameters

型号/Model	SLST2400
托板尺寸(mm)Pallet Size(mm)	1580*1380mm
最大成型面积(mm)Max.Molding Area(mm)	1500*1300
成型高度范围(mm)Product Height(mm)	45-600
生产模式 Production Mode	纯振动 Pure vibration
伺服驱动轴 Servo Drive Shaft	8
主油缸吨位T Main Oil Cylinder Tonnage/T	28
激振力KN Excitation Force/KN	550

### 产能表/Production Table

砖样规格 Brick Size	产能(单板) Production(Per mould)	产能(8小时/班) Production(8h one shift)
空心砖Hollow Brick 390x190x190mm	21	约40,000块 560m³
实心砖Solid Brick 240x115x53mm	120	约288,000块 420m³
路面砖Paver 200x100x60mm	78	约112,300块 2200m²

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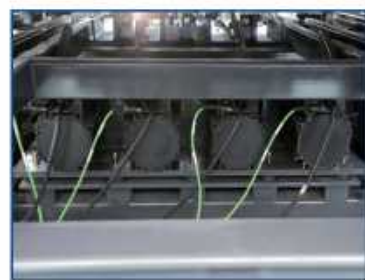


# SLST Series Servo Block Machine

## SLST系列全伺服砌块成型机

全自动伺服墙地砖生产线，以伺服振动、伺服液压为技术依托，可搭配侧移、抽芯、苯板输送、快速换模等功能，最大限度的满足客户的生产需求，可支持路沿石、空心砖、PC仿石砖、标砖、水利护坡砖等各种标准混凝土制品。

The fully automatic servo wall and floor brick production line is based on servo vibration and servo hydraulic technology, and can be equipped with functions such as lateral shifting, core pulling, EPS board conveying, and quick mould changing to meet customer production needs to the maximum extent. It can support various standard concrete products such as curbstones, hollow bricks, PC imitation stone bricks, solid bricks, and water slope protection bricks.



伺服振动系统  
Servo Vibration System



伺服控制系统  
Servo Control System



高效伺服液压系统  
Efficient Servo Hydraulic System



快速换模  
Quick Mould Changing



模框减震气囊  
Mould Box Damping Airbag



压头位移装置  
Mould Head Shifting Device

### 技术参数/Technical Parameters

型号/Model	SLST2000	SLST1500	SLST1400	SLST1300	SLST1000
托板尺寸(mm) Pallet Size(mm)	1400x1350	1400x1200	1400x950	1400x750	1220x900
最大成型面积(mm) Max. Molding Area(mm)	1310x1300	1310x1150	1310x900	1310x700	1100x860
最小成型高度(mm) Min. Product Height(mm)	45	45	45	45	45
最大成型高度(mm) Max. Product Height(mm)	500	500	500	500	350
成型周期(s) Cycle Time(s)	标砖 Solid Brick- 12-15 路面砖 Paver- 12-25	标砖 Solid Brick- 12-15 路面砖 Paver- 12-25	标砖 Solid Brick- 12-15 路面砖 Paver- 12-25	标砖 Solid Brick- 12-15 路面砖 Paver- 12-25	标砖 Solid Brick- 12-15 路面砖 Paver- 12-25

如果所要求的托板尺寸或产品高度未在此列举，我们非常乐意为您制定特殊方案。  
If the required pallet size or product heights are not listed here, we are happy to make special plans for you.

### 产能表/Production Table

型号/Model	砖样规格 Brick Size	产能(单板) Production(Per mould)	产能(8小时/班) Production(8h one shift)
SLST2000	空心砖Hollow Brick 390x190x190mm	18	约34,500块 480m <sup>3</sup>
	实心砖Solid Brick 240x115x53mm	105	约252,000块 368m <sup>3</sup>
	路面砖Paver 200x100x60mm	66	约95,000块 1900m <sup>2</sup>
SLST1500	空心砖 Hollow Brick 390x190x190mm	15	约28,000块 394m <sup>3</sup>
	实心砖Solid Brick 240x115x53mm	94	约225,600块 330m <sup>3</sup>
	路面砖 Paver 200x100x60/80mm	60	约86,000块 1700m <sup>2</sup>
SLST1400	空心砖 Hollow Brick 390x190x190mm	12	约22,400块 315m <sup>3</sup>
	实心砖 Solid Brick 240x115x53mm	73	约175,200块 256m <sup>3</sup>
	路面砖Paver 200x100x60/80mm	48	约68,800块 1350m <sup>2</sup>
SLST1300	空心砖Hollow Brick 390x190x190mm	9	约17,200块 240m <sup>3</sup>
	实心砖Solid Brick 240x115x53mm	55	约132,000块 193m <sup>3</sup>
SLST1000	路面砖Paver 200x100x60mm	36	约51,800块 1030m <sup>2</sup>
	空心砖 Hollow Brick 390x190x190mm	10	约18,600块 262m <sup>3</sup>
	实心砖Solid Brick 240x115x53mm	62	约148,000块 216m <sup>3</sup>
	路面砖 Paver 200x100x60/80mm	40	约57,300块 1130m <sup>2</sup>

不同材料不同配比产量有所区别 / Difference between different raw material and ratio  
如配排砖码块系统产量可能会受影响 / If a cuber is required, the capacity may be affected





# Q(F)T-A Automatic Block Machine

## Q(F)T-A系列全自动伺服同步砌块成型机

### 技术参数/Technical Parameters

型号/Model	Q(F)T10	Q(F)T8	Q(F)T7	Q(F)T6	Q(F)T4
托板尺寸(mm) Pallet Size(mm)	1220x900	970x880	1150x750	880x680	880x500
最大成型面积(mm) Max. Molding Area(mm)	1100x860	920x830	1090x700	830x640	830x460
最小成型高度(mm) Min. Product Height(mm)	50	50	45	50	50
最大成型高度(mm) Max. Product Height(mm)	250	200	250	200	200
成型周期(s) Cycle Time(s)	标砖Solid Brick 15-18 路面砖 Paver 20-25	标砖Solid Brick 15-18 路面砖 Paver 20-25	标砖Solid Brick 15-18 路面砖 Paver 20-25	标砖Solid Brick 15-18 路面砖 Paver 20-25	标砖Solid Brick 15-18 路面砖 Paver 20-25
如果所要求的托板尺寸或产品高度未在此列举，我们非常乐意为您制定特殊方案。 If the required pallet size or product heights are not listed here, we are happy to make special plans for you.					

### 产能表/Production Table

型号/Model	砖样规格 Brick Size	产能(单板) Production(Per mould)	产能(8小时/班) Production(8h one shift)
Q(F)T10	空心砖Hollow Brick / 390x190x190mm	10	约14,400块 / 202m <sup>3</sup>
	实心砖Solid Brick / 240x115x53mm	62	约100,000块 / 135m <sup>3</sup>
	路面砖Paver / 200x100x60/80mm	40	约52,000块 / 1000m <sup>2</sup>
Q(F)T8	空心砖Hollow Brick / 390x190x190mm	8	约11,500块 / 160m <sup>3</sup>
	实心砖Solid Brick / 240x115x53mm	48	约80,000块 / 117m <sup>3</sup>
	路面砖Paver / 200x100x60/80mm	32	约44,000块 / 880m <sup>2</sup>
Q(F)T7	空心砖Hollow Brick / 390x190x190mm	7	约10,080块 / 140m <sup>3</sup>
	实心砖Solid Brick / 240x115x53mm	46	约77,000块 / 147m <sup>3</sup>
	路面砖Paver / 200x100x60mm	30	约40,000块 / 800m <sup>2</sup>
Q(F)T6	空心砖Hollow Brick / 390x190x190mm	6	约8,640块 / 120m <sup>3</sup>
	实心砖Solid Brick / 240x115x53mm	32	约53,700块 / 73m <sup>3</sup>
	路面砖Paver / 200x100x60/80mm	21	约29,000块 / 577m <sup>2</sup>
Q(F)T4	空心砖Hollow Brick / 390x190x190mm	4	约5,760块 / 80m <sup>3</sup>
	实心砖Solid Brick / 240x115x53mm	21	约35,000块 / 48m <sup>3</sup>
	路面砖Paver / 200x100x60/80mm	14	约20,100块 / 400m <sup>2</sup>

不同材料不同配比产量有所区别 / Difference between different raw material and ratio





# Servo Vibration System

## 伺服振动系统

在压制前伺服振动系统开启，振动台以较低的频率振动进行布料；布料完成后，振动台以较高的频率振动同时进行砖块的压制。

### ■ 调节相位角起振、消振

1. 速度提前加速到预定工作转速，改变相位角起振。（加速时保持相位角180°无激振力）。
2. 与普通电机加减速起振消振相比，周期节省1.5s以上。
3. 提高产品质量，成型特殊砖更容易。

### ■ 振幅、振频可调

1. 转速控制振频，角度控制激振力，达到振幅、振频的同时可调。
2. 生产特殊砖更容易，提高产品质量。
3. 产品密实度提高。

### ■ 较于传统变频控制，综合优势有：

1. 更高效。振动加速时间 < 1S，脱模消振时间 < 0.3S。
2. 低能耗。每台伺服电机均为独立控制，克服了需同步造成的能量抵消及损耗问题，节能更明显。
3. 振动效果更佳。全闭环控制，同步性高，激振力更稳定。
4. 便于维护。每台伺服电机无需机械上的同步装置，都是独立单元，维护更加方便。

The servo vibration system consists of a servo controller, four servo drivers and four servo motors (the number of servo drivers and servo motors can be increased or decreased according to needs); The vibration table is composed of a vibration box and a vibration table. Before pressing, the servo vibration system is turned on and the vibration table is distributed at a lower frequency. When the cloth is finished, the vibrator vibrates at a higher frequency while the brick is pressed.

### ■ Adjust the phase Angle vibration, vibration elimination

1. The speed is accelerated in advance to the predetermined working speed, and the phase Angle is changed to start vibration. (No excitation force is maintained at a phase Angle of 180° while accelerating)
2. Compared with ordinary motor acceleration, deceleration, vibration lifting and vibration elimination, the cycle saving is more than 1.5s.
3. Improve product quality and make it easier to shape special bricks.

### ■ The amplitude and frequency can be adjusted

1. The rotational speed controls the frequency of vibration and the Angle controls the exciting force to achieve the amplitude and frequency of vibration, which can be adjusted at the same time.
2. It is easier to produce special bricks to improve product quality.
3. Improved product compactness.

### ■ Compared with the traditional frequency conversion control, the comprehensive advantages include:

1. More efficient. The vibration acceleration time can be less than 1s (molding acceleration), and the vibration elimination time can be less than 0.3s (molding deceleration).
2. Lower energy consumption. Each servo motor is individually controlled, without interference between each other, which overcomes the problem of energy offset and energy loss caused by synchronization, and achieves better energy-saving effect.
3. Better vibration effect. Adopt full closed loop control, high synchronization, more stable excitation force.
4. Easy to maintain. Each servo motor is a separate unit, no mechanical synchronization between each other, more convenient maintenance.



# Servo Hydraulic Station

## 电液伺服液压系统

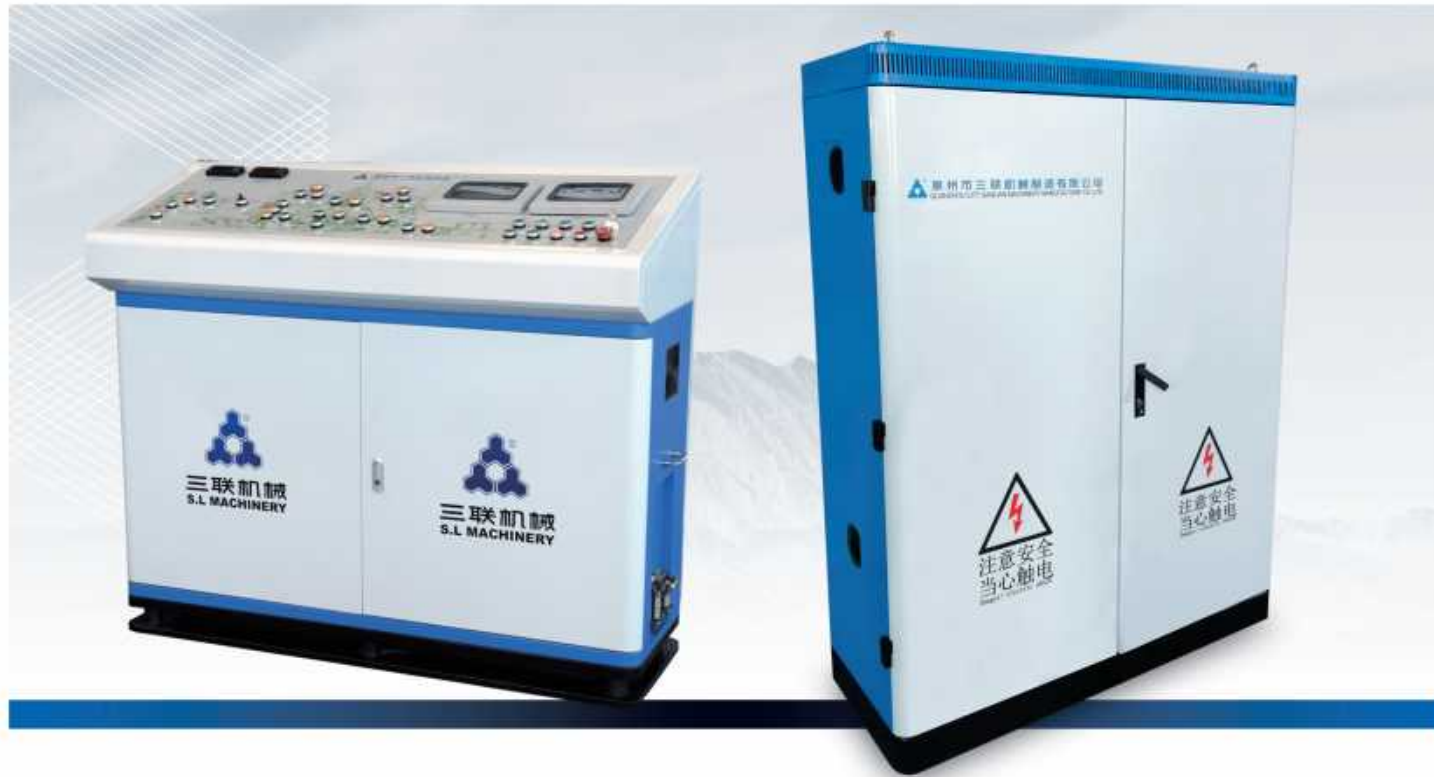
### ■ 液压系统具有的优点：

1. 节能。相较于普通液压系统，可节能 > 30%。
2. 低噪。相较于普通液压系统，噪声可降低10~20db。
3. 发热少。无溢流发热，无动作时无流量流动，故无阻力发热，发热量为普通液压系统10~30%。
4. 柔性好，精度高。压力，速度，位置均为全闭环数字控制，自动化程度高，精度高。
5. 效率高。相较于普通液压系统，工作节拍可提高10~20%。

### ■ Advantages of hydraulic system:

1. Energy saving: Compared with ordinary hydraulic system, the servo hydraulic system can save more than 30% of energy;
2. Low noise: When the servo hydraulic system presses and returns, the motor operates at the rated speed, and its emission noise is 10dB ~ 20dB lower than that of the traditional hydraulic system.
3. Less heat: Because the servo hydraulic system has no overflow heat and no flow when the action is static, there is no hydraulic resistance heat. The heat generated by the hydraulic system is generally 10% ~ 30% of that of the traditional hydraulic press.
4. Good flexibility and high precision: the pressure, speed and position of the servo hydraulic system are fully closed-loop digital control, with high degree of automation and good precision.
5. High efficiency: Through proper acceleration and deceleration control and energy optimization, the speed of the servo hydraulic system can be greatly improved, and the working beat is 10-20% higher than that of the traditional hydraulic system.





## PLC Controller System

### 电控系统

- 先进的德国自动化控制技术和智能交互系统可视化操作，实现人机对话。
- 可实现生产线的全自动控制及每个系统独立控制。
- 系统程序具有联动，互锁，通过计算机实现状态显示，故障诊断及数据输入。
- 电气配件主要采用国际名牌，如西门子，SEW，施耐德，托利多，费斯托，欧姆龙等，性能更稳定。
- Advanced Germany automation control technology and intelligent interactive visualization system operation, realize man-machine conversation;
- Realize automatic control of production line whole and independent control of each system;
- System program is provided with linkage, interlock status display through the computer implementation, failure diagnosis and data input;
- Electrical accessories mainly adopt international famous brand, such as Siemens, SEW, Schneider, Toledo, Festo, Omron, etc. More stable performance.

**SIEMENS**  
Ingenuity for life

**Schneider**  
Electric

**Danfoss**

**METTLER** **TOLEDO**

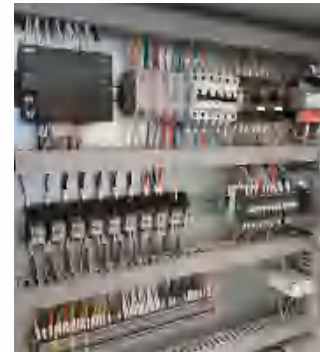
**SEW**  
EURODRIVE

**Rexroth**  
力士乐

**FESTO**

**OMRON**

**SICOMA**



## Batching Machine

### 配料机

具有计量许可标准，可实现快，慢配料计量，配有振动装置，确保落料畅通。根据不同生产骨料，不同生产产品的级配，按预先设定好的骨料配合比，采用高精度三点式感应传感器的自动称量。

With the standard of measurement permission, fast and slow batching measurement can be realized, equipped with vibration device, to ensure smooth blanking. According to different aggregate and the gradation of different production products, and the pre-set aggregate mix ratio, it adopts the automatic weighing of high-precision three-point induction sensor.

### 主要技术参数/Main Technical Parameters

机型/Type	PL400	PL1600-2	PL1600-3	PL1600-4
储料斗容量/Volume of Storage Hopper(m <sup>3</sup> )	7m <sup>3</sup> x1	7m <sup>3</sup> x2	7m <sup>3</sup> x3	7m <sup>3</sup> x4
称量斗容积/Volume of Weiging Hopper(m <sup>3</sup> )	0.6	1.6	1.6	1.6
输送量/Productivity ( m <sup>3</sup> /h)	25	80	80	80
最大称量值/Maximum Weighing Value	0.5T	2T	3T	4T
可配骨料种数/Batching Category of Aggregate	1	2	3	4
上料高度/Height of Loading (mm)	2950	2950	2950	2950
配料及卸料方式/Batcing & Unloading Method	水平电动皮带机/Horizontal belt conveyer			
功率/Power(kw)	2.2	7.5	7.5	11
质量/Net Weight(T)	2.3	4	5.4	7.3
外形尺寸/Frame Dimension ( mm)	3755x2387x3196	5470x2387x3196	8510x2387x3196	11240x2387x3196



# Double Horizontal Shaft Compulsory Mixer

## 双卧轴强制式搅拌机

- **特点:** 搅拌速度快。
- **应用场合:** 更适用于中大骨料粒径的搅拌。
- **Features:** Fast stirring speed;
- **Application:** It is more suitable for mixing medium & large aggregate particle size.



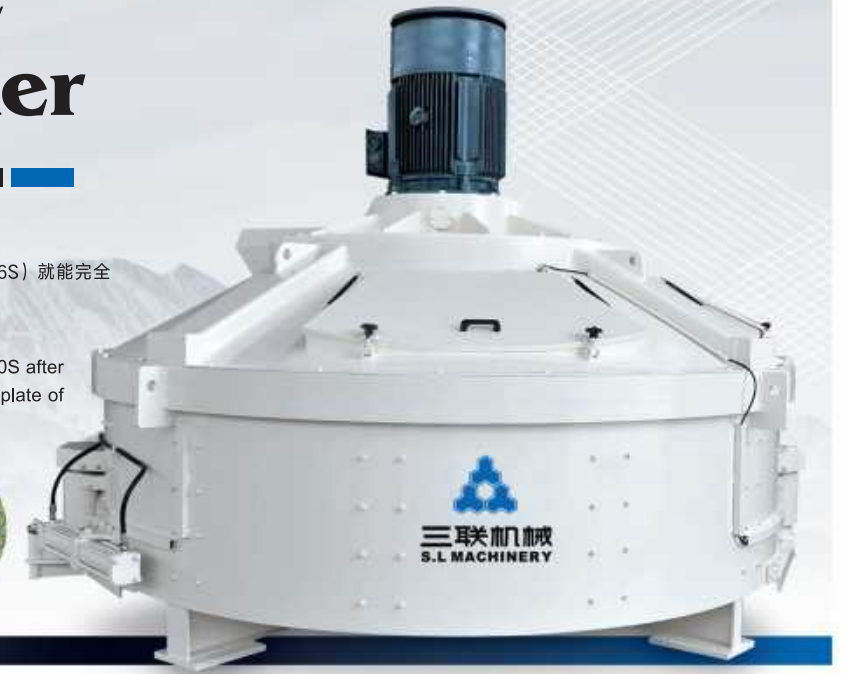
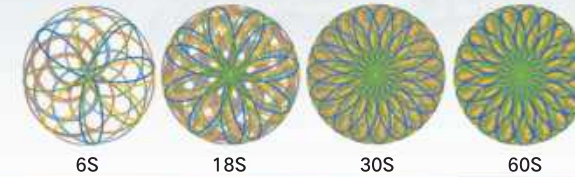
### 主要技术参数/Main Technical Parameters

机型/Type	LJB350	JS500	JS750	JS1000
进料容量 Charging Volume(L)	560	800	1200	1500
出料容量 Discharging Volume(L)	350	500	750	1000
生产率 Productivity(m <sup>3</sup> /h)	≥17.5	≥25	≥37.5	≥50
骨料最大粒径/Max.Grain Diameter of Aggregate (mm)	60	60	60	60
搅拌叶片转速 Speed of Mixing Blade(r/min)	35	35	32.6	32.6
搅拌叶片数量 Mixing Blade(PCS)	3	14	14	16
搅拌电机型号 Model of Mixing Motor	Y132m-4	Y180m-4	Y200L-4	Y180L-4
搅拌电机功率 Power of Mixing Motor(kw)	7.5	18.5	30	22
卷扬机型号 Model of Hoist	JS350	JS500	JS750	JS1000
卷扬机功率 Power of Hoist(kw)	4.5	5.5	7.5	11
卸料高度/Height of Unloading Material(mm)	1200	1500	1600	2080
水泵电机型号 Model of Water Pump Motor	25ZB27-0.75	65JDB-30	65JDB-30	KQW65-100
水泵电机功率 Power of Water Pump(kw)	75D	1.1KW	1.1KW	1.5KW
外形尺寸工作状态/Frame Dimension in Working condition(mm)	3618X1222X3453	4461X3050X5225	4950X3636X6530	7922X3510X6064
运输状态外形尺寸/Transport State Frame Dimension(mm)	1721X1222X2450	3050X2300X2500	4150X3636X2500	4200X3110X2780
机台重量 Net weight(T)	2	4	6.8	9

# Vertical Shaft Planetary Mixer

## 立轴行星式搅拌机

- **搅拌运行轨迹图:**  
下图为在投料后从6S到60S过程中的搅拌运动轨迹,每运转四转(6S)就能完全覆盖一次搅拌机底板,没有任何死角区域。
- **Stirring Running Track Diagram:**  
The following figure shows the mixing motion track from 6S to 60S after feeding. Every four turns (6S) can completely cover the bottom plate of the mixer without any dead area.



- **特点:** 搅拌运动轨迹复杂,运动强烈,搅拌均匀,效率高,检修及清洗方便。
- **应用场合:** 尤其适用于目前市面上的高端海绵透水生态砖和PC仿石景观砖等高端水泥制品领域。
- **Features:** Complicated stirring motion track, strong stirring motion, uniform stirring, high efficiency, convenient maintenance and the cleaning.
- **Application:** It is especially suitable for high-end cement products such as sponge permeable ecological brick and PC imitation stone landscape brick on the market.

### 技术参数/Technical Parameters

项目/Item	MPC	50	100	150	250	330	500	750	1000	1250	1500	2000	2500	3000
进料容量 Filling Volume	L	75	150	225	375	500	750	1125	1500	1875	2250	3000	3750	4500
进料容量 Filling Capacity	Kg	120	240	360	600	790	1200	1800	2400	3000	3600	4800	6000	7200
出料容量 Output Volume	L	50	100	150	250	330	500	750	1000	1250	1500	2000	2500	3000
搅拌功率 Mixing Power	Kw	4	5.5	7.5	11	15	18.5	30	37	45	55	75	90	110
行星 Mixing Star	Qty	1*2	1*2	1*2	1*2	1*2	1*2	1*3	2*2	2*2	2*2	3*2	3*3	3*3
搅拌叶片数量 Mixing Blade														
侧刮板/卸料刮板数量(Side Scraper/Discharge Scraper)	Qty	1/-	1/-	1/1	1/1	1/1	1/1	1/1	1/1	1/1	1/1	1/2	1/2	1/2
卸料功率 Discharging Power	Kw	气动卸料/Pneumatic Discharging							3	3	3	4	4	4
搅拌桶直径 Mixing Hopper Diameter	mm	750	1000	1300	1300	1600	1900	2200	2500	2800	2800	3100	3400	3400
整机重量 Weight	Kg	500	850	1300	1500	2200	2500	3500	5500	6000	6500	8500	10500	11000

注:由于我们不断对产品进行性能完善和改进,产品参数以实物为准  
 Note: As we continue to improve and improve the performance of our equipment, the parameters are subject to the actual equipment.



# Block Machine Fully Automatic Production Line

## 全自动制砖流水线

- |  |                                     |
|--|-------------------------------------|
| 1 底料配料机/Base Material Batching Machine                       | 17 自动降板机/Automatic Lowerator        |
| 2 底料粉罐/Base Material Silo                                    | 18 节距送砖机/Chain Block Conveyor       |
| 3 底料螺旋输送机/Base Material Screw Conveyor                       | 19 托板分离机/Pallet Separator           |
| 4 底料搅拌机 (含电子秤)<br>Base Material Mixer(With Electronic Scale) | 20 翻板机/Pallet Turnover Machine      |
| 5 面料配料机/Pigment Batching Machine                             | 21 托板返回装置/Pallet Return Device      |
| 6 面料粉罐/Pigment Silo  | 22 人行天梯/Industry Overpass           |
| 7 面料螺旋输送机/Pigment Screw Conveyor                             | 23 码垛机/Cuber                        |
| 8 面料搅拌机 (含电子秤)<br>Pigment Mixer(With Electronic Scale)       | 24 成品托盘仓/Wooden Rack Storage        |
| 9 底料皮带输送机/Belt Conveyor For Base Material                    | 25 板式输送带/Wooden Rack Conveyor       |
| 10 面料皮带输送机/Belt Conveyor For Pigment                         | 26 电控系统/PLC Controller              |
| 11 送板机/Pallet Feeder   | 27 水平打包机/Horizontal Packing Machine |
| 12 砌块成型机/Block Making Machine                                | 28 穿剑式打包机/Vertical Packing Machine  |
| 13 接砖机/Green Block Conveyor                                  | 29 薄膜缠绕机/Film Wrapping Machine      |
| 14 清扫装置/Cleaning Machine                                     | 30 叉车/Forklift                      |
| 15 自动升板机/Automatic Elevator                                  | 31 养护窑/Curing Room                  |
| 16 程控子母车/Finger Cart   |                                     |



# Curing

## 运转养护



### 高位窑系统/High Position Curing Room System

由伺服子母车和升降板机组成，子母车可根据场地需求，做旋转模式，层数范围10-22，自动对轨定位装置、自动收线装置，伺服控制，高低位运行平稳、精准定位、安全可靠。

Composed of servo finger cart and elevator & lowerator, the finger cart can be rotated according to site requirements, with a range of 10-22 layers. The automatic track positioning device and automatic wire collection device are equipped with servo control, ensuring smooth and precise positioning of high and low positions, safe and reliable operation.



### 带架养护模式/ With Rack Curing Mode

采用单层新能源搬运车、上卸板机、吊架机互相衔接配合构成闭环自动生产线。

A single-layer new energy truck, upper pallet unloading machine, and hanger machine are used to connect and cooperate with each other to form a closed-loop automatic production line.

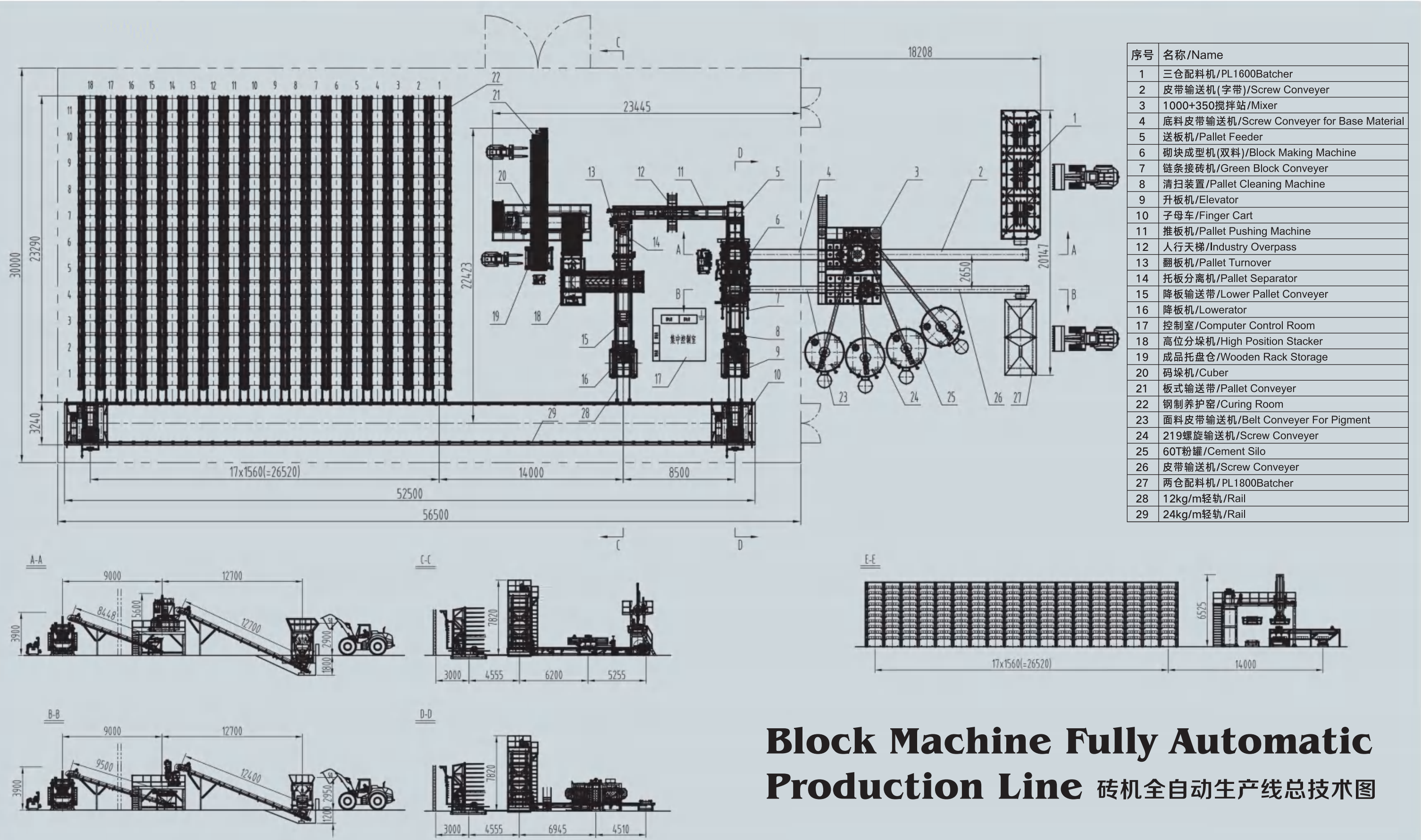


### 摆渡搬运系统/ Ferry Carrying System

与简易生产线及智能码砖机实现无缝连接，组成砌块砖成型、养护、打包全流程生产机械自动化，实现智能制砖，母摆渡采用伺服传动定位，搬运小车出入窑养护和码垛。从而解决简易生产线叉车转运的人工及油耗问题。

It is seamlessly connected with the simple production line, automated production machinery for the entire process of molding, curing, and packing blocks, realize intelligent block making. The primary ferry cart adopts servo drive positioning, and the transport trolley enters and exits the curing room for curing, and cubing This solves the labor and fuel consumption problems of forklift transportation in simple production lines.





序号	名称/Name
1	三仓配料机/PL1600Batcher
2	皮带输送机(字带)/Screw Conveyor
3	1000+350搅拌站/Mixer
4	底料皮带输送机/Screw Conveyor for Base Material
5	送板机/Pallet Feeder
6	砌块成型机(双料)/Block Making Machine
7	链条接砖机/Green Block Conveyor
8	清扫装置/Pallet Cleaning Machine
9	升板机/Elevator
10	子母车/Finger Cart
11	推板机/Pallet Pushing Machine
12	人行天桥/Industry Overpass
13	翻板机/Pallet Turnover
14	托板分离机/Pallet Separator
15	降板输送带/Lower Pallet Conveyor
16	降板机/Lowerator
17	控制室/Computer Control Room
18	高位分垛机/High Position Stacker
19	成品托盘仓/Wooden Rack Storage
20	码垛机/Cuber
21	板式输送带/Pallet Conveyor
22	钢制养护窑/Curing Room
23	面料皮带输送机/Belt Conveyor For Pigment
24	219螺旋输送机/Screw Conveyor
25	60T粉罐/Cement Silo
26	皮带输送机/Screw Conveyor
27	两仓配料机/PL1800Batcher
28	12kg/m轻轨/Rail
29	24kg/m轻轨/Rail

**Block Machine Fully Automatic Production Line** 砖机全自动生产线总技术图



# Economic Production Line with Independent Cubing System

## 自动简易线配套离线码垛系统

- |  |   |
|--|---|
| ① 底料配料机/Base Material Batching Machine                   | ⑩ 面料搅拌机 (含电子秤) Pigment Mixer(With Electronic Scale) |
| ② 底料粉罐/Base Material Silo                                | ⑪ 砌块成型机/Block Making Machine                        |
| ③ 底料螺旋输送机/Base Material Screw Conveyor                   | ⑫ 送板机/Pallet Feeder                                 |
| ④ 底料搅拌机(含电子秤)/Base Material Mixer(With Electronic Scale) | ⑬ 接砖机/Green Block Conveyor                          |
| ⑤ 底料皮带输送机/Belt Conveyer For Base Material                | ⑭ 叠板机/Stacker                                       |
| ⑥ 面料配料机/Pigment Batching Machine                         | ⑮ 液压系统/Hydraulic System                             |
| ⑦ 面料粉罐/Pigment Silo                                      | ⑯ 电控系统/PLC Controller System                        |
| ⑧ 面料螺旋输送机/Pigment Screw Conveyor                         | ⑰ 叉车/Forklift                                       |
| ⑨ 面料皮带输送机/Belt Conveyer For Pigment                      | ⑱ 成品堆放区/Finished Product Curing Area                |



# Independent Cubing System

## 离线码垛系统

离线码垛系统 (可留叉车孔) /

Independent Cubing System(Forkhole Reservable )

适用于自动简易线的干产品码垛，一般情况下独立设置于产品养护堆场附近(也可与主机生产线在线连接)，对于养护好的制品就地码垛。可将不同型号砖机生产的不同规格的砌块进行砖板分离，排块整理最后排成方垛进行码放，经出砖可选择进行缠绕膜或捆扎带打包，可预留叉车孔。分砖排砖及码垛可采用伺服控制，定位更准确，运行更平稳。

It is suitable for dry product palletizing of simple lines. In general, it is independently set near the product maintenance yard (it can also be connected with the main engine production line on line), and palletizing in place for the maintained products. The blocks of different specifications produced by different models of brick machines can be separated from each other. The blocks can be arranged into a square stack for stacking. The bricks can be packaged wrapping film or strapping tape film and forklift hole can be reserved. The servo control can be used for brick-sorting, brick-lining and palletizing. The positioning is more accurate and the operation is more stable.

### 高位离线码垛/High Position Independent Cubing



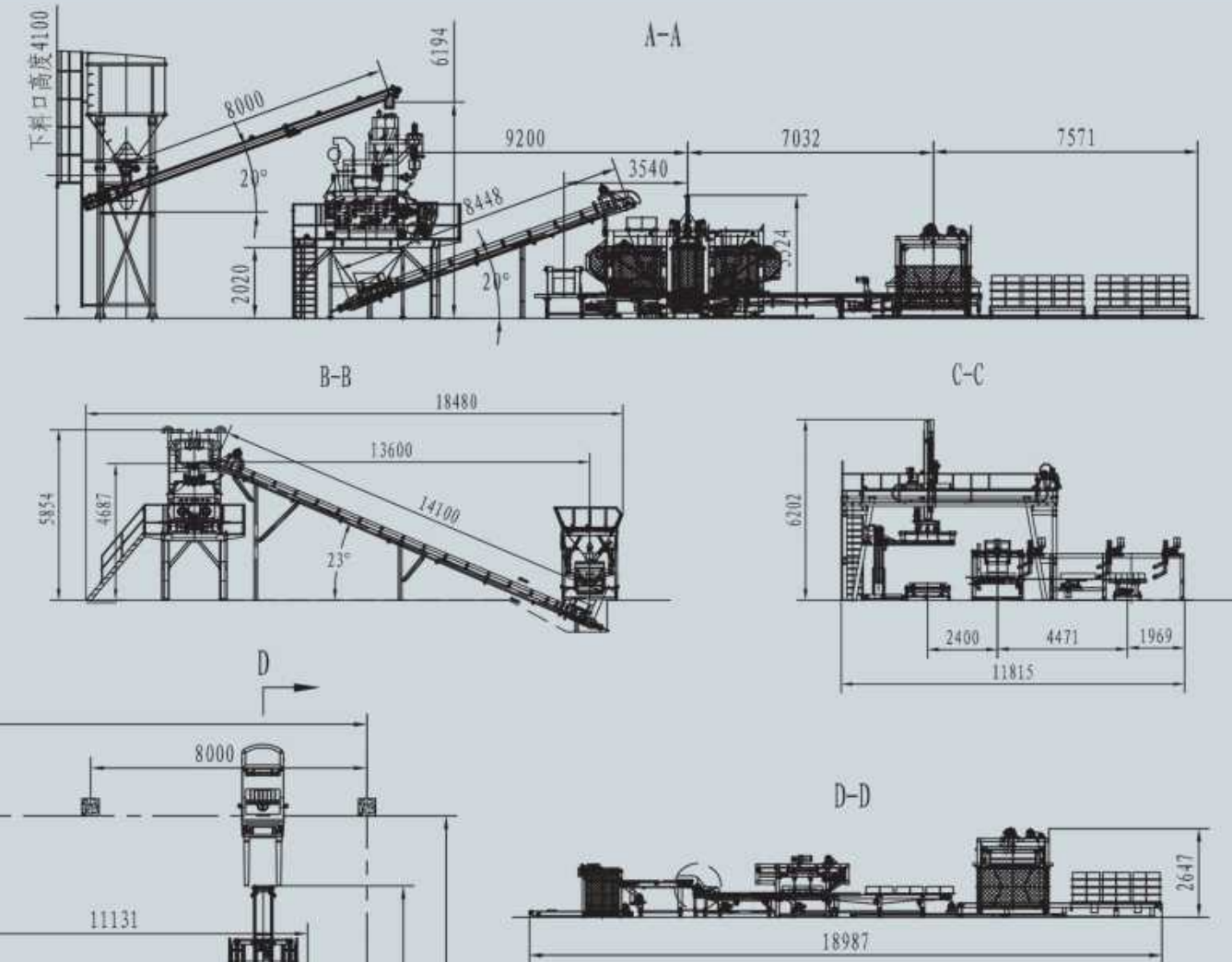
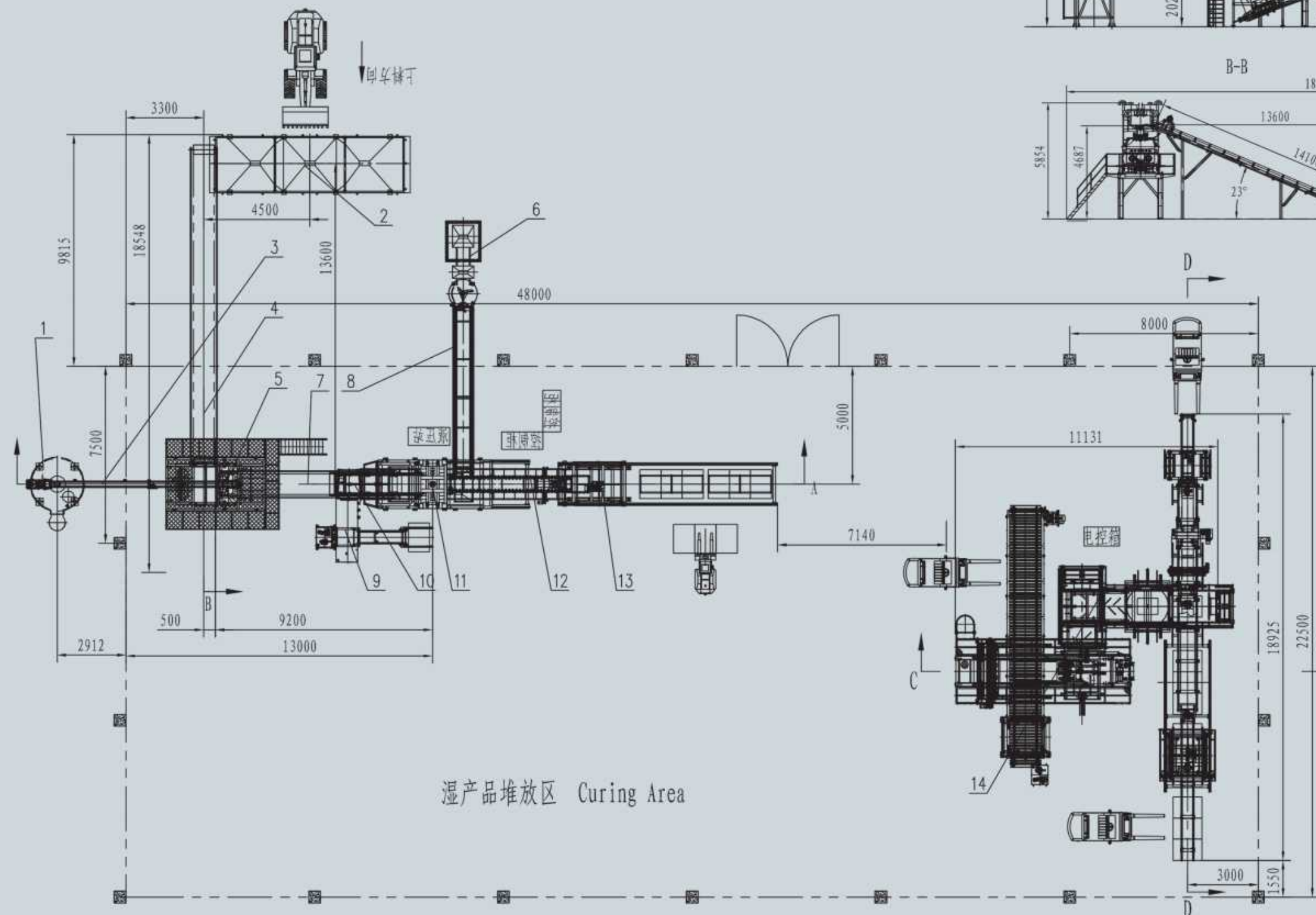
### 低位离线码垛/Low Position Independent Cubing





# Block Machine Economic Production Line (With Independent Cuber)















自动简易线带离线码垛系统 (技术总图)





序号	名称	数量
1	粉罐/Silo	1
2	配料机/Batcher	1
3	螺旋输送机/Screw Conveyer	1
4	原料皮带输送机/Conveyer Forraw Material	1
5	底料搅拌机/Mixer For Base Material	1
6	面料搅拌机/Mixer For Pigment	1
7	皮带输送机(底料)/Belt Conveyer	1
8	皮带输送机(面料)/Belt Conveyer	1
9	液压自动供板机/Auto Pallet Onloader	1
10	送板机/Pallet Feeder	1
11	砌块成型主机/Block Machine	1
12	接砖机/Green Block Conveyer	1
13	叠砖机(三板式两驱)/Stacker	1
14	高位离线码垛/Off-line Cuber	1



# Capacity of Different Model Block Machine 砖样表

机型/Type	Q(F)T 4-15	Q(F)T 6-15	Q(F)T 7-15	Q(F)T 8XL-15	SLST 1000	SLST 1300	SLST 1400	SLST 1500	SLST 2000	SLST 2400		
托板尺寸 Pallet Dimension(mm)	880x500	880x680	880x680	970x880	1220x900	1400*750	1400x950	1400x1200	1400x1400	1580*1380		
<b>空心砌块/Hollow Block</b>												
砖样 Sample	型号 Item No.	砖型尺寸/Block Dimension(mm)	Q(F)T 4-15	Q(F)T 6-15	Q(F)T 7-15	Q(F)T 8XL-15	SLST 1000	SLST 1300	SLST 1400	SLST 1500	SLST 2000	SLST 2400
	SLH01	390x190x190	4	6	7	8	10	9	12	15	18	21
	SLH02	390x240x190	3	5	6	6	8	8	10	12	15	18
	SLH03	390x90x190	8	12	14	18	20	21	24	30	36	42
	SLH04	240x240x115	3	6	8	9	12	10	15	20	25	30
	SLH05	240x190x115	6	9	12	12	15	15	18	24	30	35
	SLH06	240x115x115	9	15	20	21	27	25	30	40	50	55
	SLH07	390x140x190	6	8	10	12	14	12	16	21	24	27
	SLH08	530x200x200	2	4	6	4	8	7	8	12	12	14
	SLC09	390x100x190	8	10	14	16	20	18	24	30	33	39
	SLC10	390x150x190	5	8	9	10	12	12	16	21	24	27
	SLC11	80x80x180	28	35	54	56	63	60	77	90	100	120
	SLC12	100x60*210	30	36	44	50	60	60	78	91	104	120
<b>实心砖/Solid Brick</b>												
	SLS01	240x53x115	21	32	46	48	62	55	73	94	105	120
	SLS02	250x75x120	15	21	32	30	39	40	50	65	70	85

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 Note: We reserve the rights to amend the technology, specification and appearance of the products and will not be notified separately.

市政工程系列砖/Color Paving Stone													
砖样 Sample	型号 Item No.	砖型尺寸/Block Dimension(mm)	Q(F)T 4-15	Q(F)T 6-15	Q(F)T 7-15	Q(F)T 8XL-15	SLST 1000	SLST 1300	SLST 1400	SLST 1500	SLST 2000	SLST 2400	
	SLC01	400x400xD	2	2	2	4	4	3	6	6	9	9	
	SLC02	400x200xD	4	6	7	8	10	9	12	15	18	21	
	SLC03	300x300xD	2	4	6	6	6	8	8	12	16	16	
	SLC04	250x250xD	3	6	8	9	12	10	15	20	25	25	
	SLC05	250x125xD	9	12	20	18	24	25	30	40	45	50	
	SLC06	200x100xD	14	21	30	32	40	36	48	60	66	78	
	SLC07	300x150xD	7	10	12	15	15	16	20	28	32	36	
	SLC08	900x600xD	-----	-----	1	1	1	1	2	2	2	2	
	SLC09	600x600xD	-----	1	1	1	1	1	2	2	4	4	
	SLC10	600x300xD	1	2	3	3	3	4	4	6	8	8	
	SLC11	225x112.5xD	9	15	20	21	28	25	35	45	50	60	
	SLC12	200x165xD (工字)	8	12	18	16	24	24	30	36	42	48	
	SLC13	125x125xD (六边)	6	6	12	12	16	15	20	27	30	35	
	SLC15	250x250xD	3	6	8	9	12	10	15	20	25	25	
	SLC16	φ 220xD	8	11	14	14	21	18	25	35	39	44	

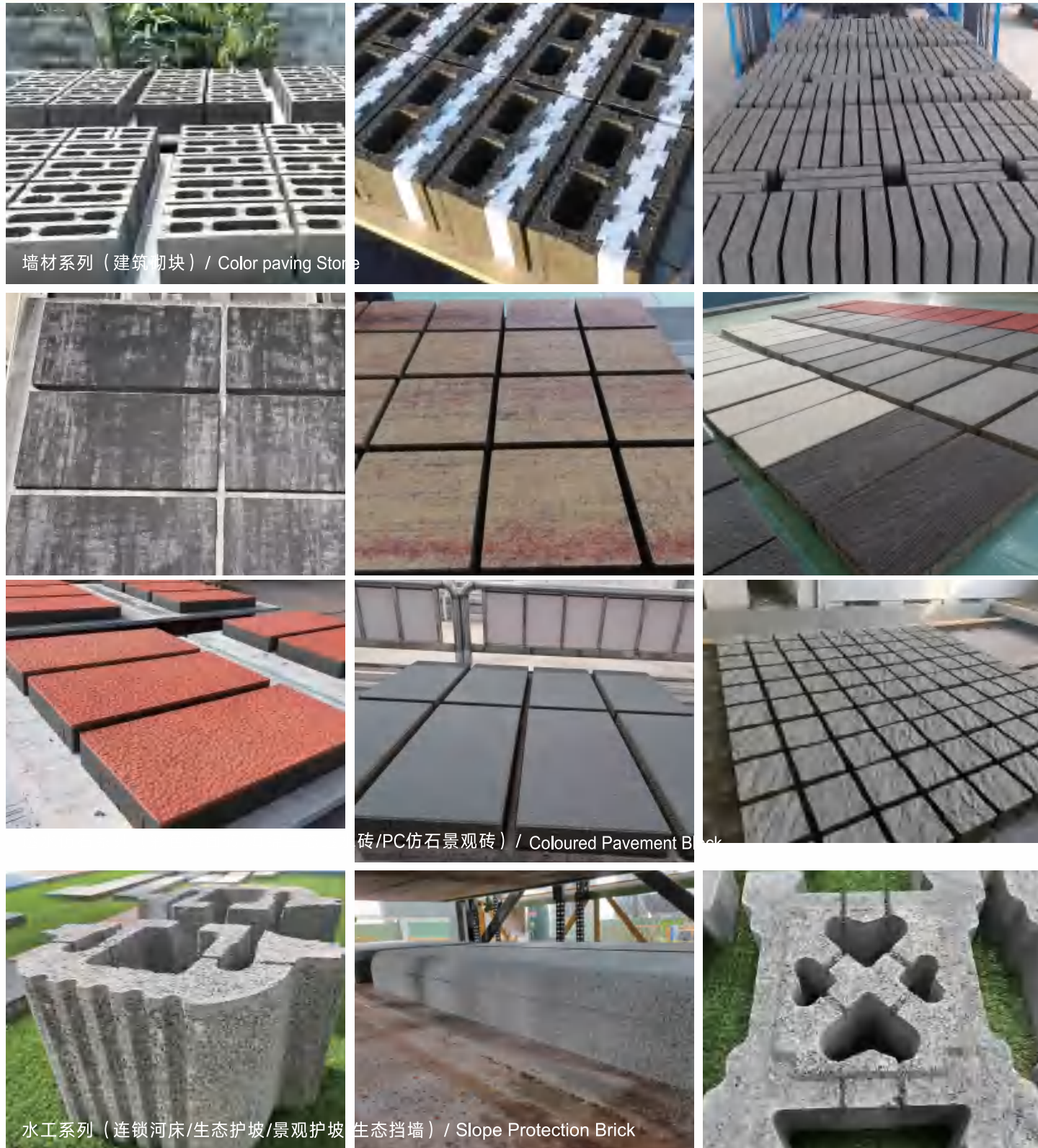
路沿石/Curbstone													
砖样 Sample	型号 Item No.	砖型尺寸/Block Dimension(mm)	Q(F)T 4-15	Q(F)T 6-15	Q(F)T 7-15	Q(F)T 8XL-15	SLST 1000	SLST 1300	SLST 1400	SLST 1500	SLST 2000	SLST 2400	
	SLK01	1000x200x80	-----	-----	6	-----	8	6	8	12	12	14	
	SLK02	500x305x150	1	2	4	2	8	8	10	14	14	16	
	SLK03	980x300x(70+110)	-----	-----	2	-----	6	5	6	9	9	11	

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# Brick Example

砖样实例



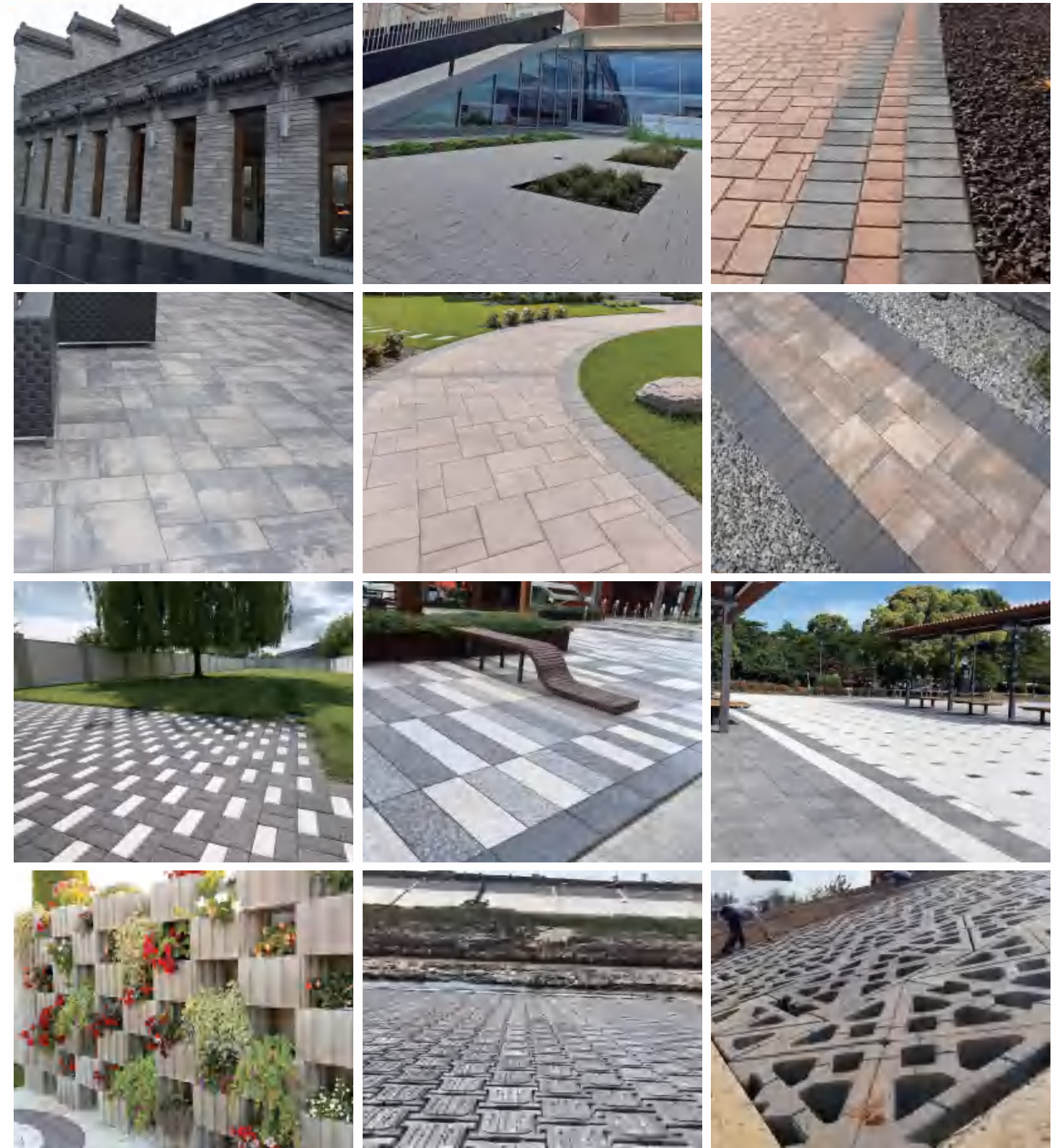
墙材系列 (建筑砌块) / Color paving Stone

砖/PC仿石景观砖) / Coloured Pavement Brick

水工系列 (连锁河床/生态护坡/景观护坡生态挡墙) / Slope Protection Brick

# Real Application

实景应用





# Lightweight Wall Panel Machine

装配式墙板设备

## Double Layers Wall Panel Production Line-Horizontal Type

双层卧式复合轻质墙板生产线



## Wall Panel Production Line-Vertical Type

立式复合轻质墙板生产线



## Wall Panel Production Line- Vertical&Horizontal Type

卧立式复合轻质墙板生产线



# Lightweight Wall Panel Machine

装配式墙板设备



## Wall Panel Production Line-Horizontal Type

卧式复合轻质保温墙板生产线

- |  |  |
|--|--|
| 1. 粉罐/Silo   | 10. 复合式摆渡车/Composite Ferry Cart          |
| 2. 螺旋输送机/Screw Conveyor  | 11. 自动脱模码垛机/Automatic Demoulding Machine |
| 3. 搅拌机 (含粉料计量系统和发泡机)<br>Mixer(with Powder Measuring System and Steep Making Machine) | 12. 电控系统/PLC Controller                  |
| 4. 自动注浆泵/Automatic Slurry Injection Pump   | 13. EPS熟化料仓/EPS Silo                     |
| 5. 移动式成型机/Movable Molding Machine  | 14. EPS预发机/EPS Pre-expander              |
| 6. 脱模推车/Demoulding Area Pushing Cart   | 15. 锅炉/Boiler                            |
| 7. 装模推车/Mould Installation Area Pushing Cart   | 16. 叉车/Forklift                          |
| 8. 注浆推车/Slurry Injection Pushing Cart  | 17. 堆场/Storage Yard                      |
| 9. 运转推车/Transferring Pushing Cart  |  |



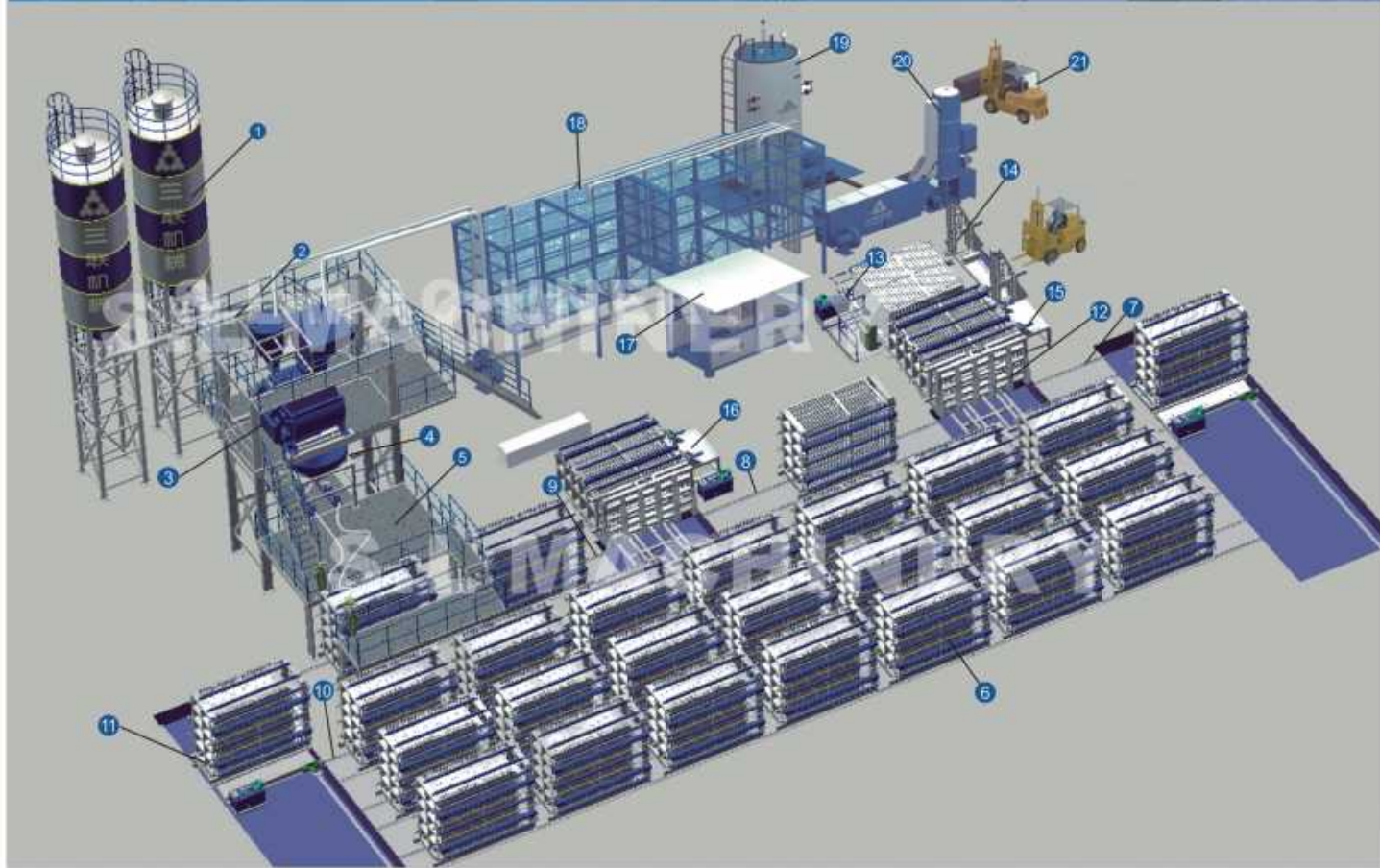
## Mobile Type Wall panel Molding Machine

移动式墙板成型主机



# Lightweight Wall Panel Machine

装配式墙板设备



## Wall Panel Production Line-Vertical Type

### 立式立模复合轻质保温墙板生产线

- |  |   |
|--|---|
| 1.粉罐/silo  | 12.立式翻转机/Vertical Overturn Cart         |
| 2.螺旋输送机/Screw Conveyor   | 13.自动脱模码垛机/Automatic Demoulding Machine |
| 3.搅拌机(含粉料计量系统和发泡机)<br>Mixer(with Powder Measuring System and Steep Making Machine) | 14.墙板分离机/Wall Panel Separator           |
| 4.自动注浆泵/Automatic Slurry Injection Pump  | 15.辅助脱模机/Demoulding Auxiliaries         |
| 5.注浆平台/Slurry Infusing Platform  | 16.辅助装模机/Mould Installation Auxiliaries |
| 6.立式成型机/Vertical Type Molding Machine  | 17.电控系统/PLC Controller                  |
| 7.脱模推车/Demoulding Area Pushing Cart  | 18.EPS熟化料仓/EPS Silo                     |
| 8.装模推车/Mould Installation Area Pushing Cart  | 19.锅炉/Boiler                            |
| 9.注浆推车/Slurry Injection Pushing Cart   | 20.EPS预发机/EPS Pre-expander              |
| 10.运转推车/Transferring Pushing Cart  | 21.叉车/Forklift                          |
| 11.复合式摆渡车/Composite Ferry Cart   |   |

# Vertical Type Wall Panel Molding Machine

## 立式立模墙板成型主机



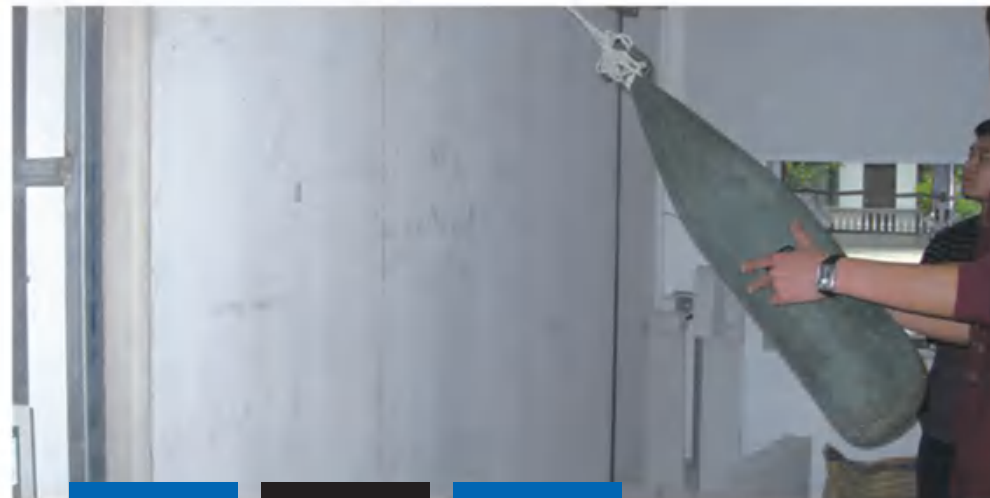
墙板成型机技术参数/  
Technical Parameters of Wall Panel Molding Machine

进料容量/Feeding Capacity	5m <sup>3</sup>	75mm	46张(PCS)
成品墙板尺寸 Finished Wall Panel Dimension	2440X600X75	90mm	40张(PCS)
	2440X600X90	100mm	36张(PCS)
	2440X600X100	120mm	30张(PCS)
	2440X600X120	150mm	26张(PCS)
	2440X600X150		
成型周期 Molding Time	2小时(高铝水泥) Two hours (High aluminium cement)	系统最大压力 Maximum Pressure of System	
模具间隙 Mould Clearance	≤2mm	≈16MPa(立式翻转车) ≈16MPa(vertical type overturn cart)	
单次出板量 Output of Wall Panel With Different Thickness			



# Project Case

## 工程案例



## Performance Of Wall Panel 墙板性能

隔音, 防水, 防火, 隔热保温, 增加利用面积  
高强度不变形  
凹凸槽咬合结构, 衔接牢固  
用工数少  
整体性好  
快速安装  
抗震能力强  
一站式的建筑安装技术服务  
装配式建筑  
埋盒、布管、设线容易  
抗冲击力大  
易切割加工, 防水性能好  
抗弯破坏荷载大  
导热系数低  
降低结构成本, 缩短施工时间

Sound proof, waterproof, fire insulation, thermal insulation, increase the usable area  
High intensity without deformation  
Strong joint structure of male & female channels  
Involve less workers at site  
Perfect integrity  
Fast installation  
Earthquake proof  
One-stop services of technology, formula, installation construction technology  
Prefabricated construction  
Simple boximbedding, pipe and pipeline installation  
Better anti-impact capacity  
Easy cutting and processing, better water proofing  
More anti-bending breaking load  
Low thermal conductivity  
Reduce structure cost and save constuction time





# Selected Domestic Customer Cases

国内客户案例精选



湖南客户生产线案例 / Hunan Customer Production Line Case



安徽客户生产线案例 / Anhui Customer Production Line Case



贵州客户生产线案例 / Guizhou Customer Production Line Case



陕西客户生产线案例 / Shanxi Customer Production Line Case



# Selected Cases Of Foreign Customers

国外客户案例精选



沙特客户生产线案例 / Saudi Arabia Customer Production Line Case



巴西客户生产线案例 / Brazil Customer Production Line Case



阿尔及利亚客户生产线案例 / Algeria Customer Production Line Case



迪拜客户生产线案例 / Dubai Customer Production Line Case







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