



上海金东
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铁路信号电缆生产设备

Railway Signal Cable Equipment

皮-泡-皮(SFS)物理发泡拉丝绝缘串列生产线
Wire Drawing SFS Insulation Tandem Line for Railway Cables

适用于：铁路数字信号电缆及宽带小同轴电缆皮泡皮绝缘线芯的生产
Suitable for the production of SFS insulation of Railway digital signal cables and Broadband mini-coaxial cables



上海金东在2004年成功研发了中国第一条高速皮泡皮（SFS）铁路信号电缆用物理发泡串列生产线，中国市场占有率80%以上
In year 2004 SKS was successfully developed the first High speed Wire-Drawing / SFS Insulating Tandem line for Railway signal cable. Market share is more than 80% in China.

技术参数 TECHNICAL PARAMETERS

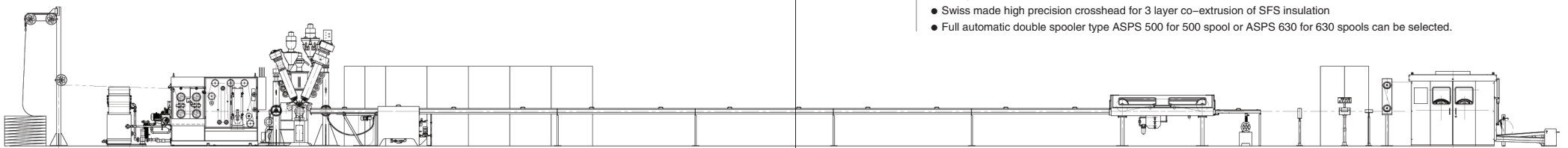
最大进线直径 Max. Entry Diameter	3.5 mm
导体直径 Diameter of conductor	0.65 ~ 1.55 mm
最大绝缘外径 Max. Diameter over insulation	4.0 mm
绝缘形式 Type of insulation	PE 皮泡皮三层共挤 PE skin-foam-skin
最大生产线速 Max. Line speed	600 m/min
绝缘外径最大平均偏差 Max. Tolerance over insulation	± 0.02 mm
水中电容最大平均偏差 Max. Tolerance of capacitance	± 2 pF/m
同心度 Concentricity	≥ 96%
最大发泡度 Max. Foaming degree	70%
双盘自动收线 Automatic Dual spooler	ASPS 500型 全自动双盘收线及换盘 ASPS 500 Full automatic dual spooler
电控及在线控制 Electric Control and In line control	全线工控机控制，15英寸带薄膜功能键彩色液晶屏。 在线控制：铜丝直径，绝缘外径，电容，偏心，发泡度，C/D综合处理智能控制 Computerized control for whole line. 15" touch screen monitor. In-line Control: Cu wire diameter, Diameter of insulation, Capacitance, Eccentricity, Foaming degree, Automatic C-D control.

技术特征：

- 采用DA 250-13型拉丝-带连续退火-预热一体机，铜导体与绝缘的粘附良好。
- 特殊设计的螺杆，发泡度均匀，增强绝缘层的抗张，抗压机械强度，保证出胶量的持续稳定。
- 内、外皮挤出机采用变频电机以及可逆矢量控制变频器，绝缘线芯的电容和外径波动极小。
- 氮气注气系统通过生产线控制
- 瑞士原装进口三层共挤皮泡皮(SFS)机头
- 采用ASPS 500型全自动双盘收线，也可选用ASPS 630型自动双盘收线。

TECHNICAL FEATURES:

- Type DA250-13 Wire drawing-Annealing-Preheating Integrated machine is used. precise preheating temperature control to ensure good adhesion between copper conductor and insulation.
- Special designed screw for foaming extrusion to get more homogeneous mixing and micro-foaming for higher tensile strength / resistance to compression of insulation.
- Frequency inverter vector control motors are used for inner and outer layer extrusion to ensure very uniform thin layers.
- Nitrogen injection system is controlled by the whole line
- Swiss made high precision crosshead for 3 layer co-extrusion of SFS insulation
- Full automatic double spooler type ASPS 500 for 500 spool or ASPS 630 for 630 spools can be selected.



QM 630 / QM 800 高速星绞机 Quadding Machine QM 630 / QM 800

主要用途：铁路数字信号电缆4线组绞合及特种电缆绞合
Suitable for quadding of railway signal cables and special cables



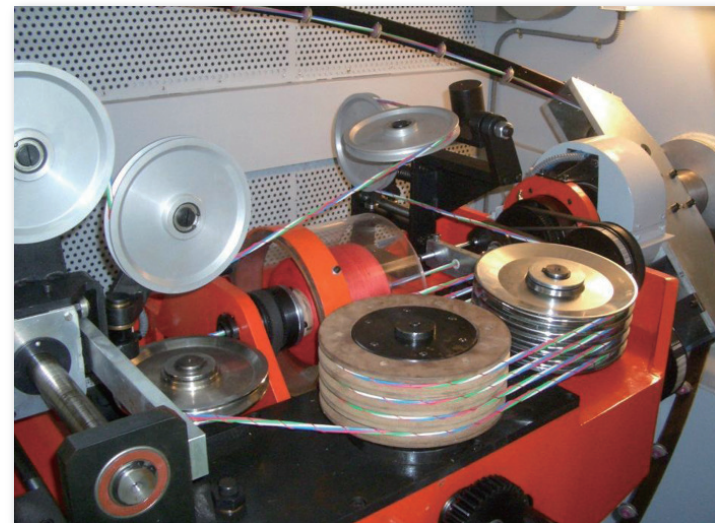
SKS在2000年成功的研发了中国第一台QM 630型的高速星绞机用于铁路数字信号电缆4线组的绞合。

SKS was successfully developed the first quadding machine QM 630 for the manufacturing Railway digital signal cable in China.

技术特征 TECHNICAL FEATURES

- ◆ 主动放线架由单独调频交流电机驱动，由张力摆杆控制同步，张力均匀
Pay-off bobbins driven by independent AC motors controlled by dancers.
- ◆ 采用特殊预扭装置，确保四线组电容不平衡降至最低
Special pretwisting device to minimum the capacitance unbalance.
- ◆ 高速同心式扎纱头（最高可达每分钟5000转），保证高效生产
High speed concentric thread binder (up to 5000 rpm) for high efficient production.
- ◆ 收线卷绕由低惯量高灵敏电磁粉末离合器及PLC控制，保证张力均匀
The take-up spool is controlled by fast responding magnetic powder clutch and PLC control to ensure constant winding tension.
- ◆ 采用人机对话互动操作站，主要工作参数可在此设定和显示
Man-machine interactive operator's workstation for set-up and display of main operating parameters.
- ◆ 自带电机驱动的收线盘升降系统，便于上下线盘
Integrated motor driven loading / unloading systems for spools.

上海金东已成功地向中国高铁数字信号电缆制造厂提供了近60套生产设备
SKS was successfully delivered nearly 60 sets of production equipment to Railway digital Signal cable maker in China for High speed Train projects.



技术参数 TECHNICAL PARAMETERS

型号 Type	QM 630型 星绞机	QM 800型 星绞机	
绝缘单线外径 Diameter of single wire	1.0 ~ 4.0 mm	1.0 ~ 4.0 mm	
四线组外径 Max. diameter after quadding	2.80 ~ 10.0 mm	2.8 ~ 10.0 mm	
绞合节距范围 Lay length	51 ~ 300 mm	51 ~ 300 mm	(12档, 变换齿轮) (12 steps, change gear)
成缆绞合方向 Direction of twisting	左绞或右绞 LH or RH	左绞或右绞 LH or RH	
最大绞合速度 Max. twisting speed	1600 扭/分 T/min	1200 扭/分 T/min	
绞弓最大转速 Max. speed of bow:	800 转/分 rpm	600 转/分 rpm	
最大出线速度 Max. line speed	250 米/分 m/min	250 米/分 m/min	
最大扎纱转速 Max. thread binder speed	5000 转/分 rpm	5000 转/分 rpm	
放线盘尺寸 Pay-off spool dimensions	Φ500 x Φ250 x 375 x Φ56	Φ630 x Φ315 x 475 x Φ56 mm	(盘径 x 筒径 x 外宽 x 孔径) (flange dia. x barrel x OW x bore)
收线盘尺寸 Take-up spool dimensions	Φ630 x Φ315 x 475 x Φ56	Φ800 x Φ400 x 600 x Φ80 mm	(盘径 x 筒径 x 外宽 x 孔径) (flange dia. x barrel x OW x bore)



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