

机 变 革 新 塑 造 卓 越
Machine Transformation, New Shaping of Excellence



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安徽东财机械科技有限公司

Anhui Dongcai Machinery Technology Co., Ltd



The Introduction of Our Company

公司简介

安徽东财机械科技有限公司(以下简称:东财机械),坐落于安徽滁州,是一座闻名于世的山水宝地,地址位于安徽省滁州经济技术开发区,与历史名城南京毗邻而居。东财机械现有安徽滁州、江苏常州两个生产基地,总面积达40000平方米,拥有核心人员100余人,配套有先进的零部件CNC机械加工基地和标准装配车间,公司拥有一支高素质的研发团队和多年经验丰富的电气调试工程师团队,是致力于塑料挤出成型设备研发、制造的高科技厂家。

东财机械以全新理念设计研发的高速节能管材挤出生产线、塑料复合管材挤出生产线等,具有高产量、低能耗、良好的熔体均质性及长期运行的稳定性,生产线采用模块化设计方案为产品的系列化、通用性提供便利,同时如何在如何节省原材料、提高自动化程度、确保高产率、高品质精密挤出以及为用户量身定制的极具竞争力的产品等方面都提供了完美的整体系统解决方案。从外观到软件系统,再到生产可视化、数据化,全面掌握生产情况,为终端客户创造触手可及的便利和实惠,用实际行动和技术来响应绿色环保的号召:节能、减排、减碳,为资源再生、绿色星球做出应有的贡献。

科技创新、先进制造、绿色发展

Anhui Dongcai Machinery Technology Co., Ltd. (hereinafter referred to as Dongcai Machinery), located in Chuzhou, Anhui Province, is a world-renowned scenic spot. Its address is in the Chuzhou Economic and Technological Development Zone of Anhui Province, adjacent to the historic city of Nanjing. Dongcai Machinery currently has two production bases in Chuzhou, Anhui and Changzhou, Jiangsu, with a total area of 40000 square meters and more than 100 core personnel. It is equipped with advanced CNC machining bases for parts and standard assembly workshops. The company has a high-quality R&D team and a team of experienced electrical debugging engineers. It is a high-tech manufacturer dedicated to the research and manufacturing of plastic extrusion molding equipment.

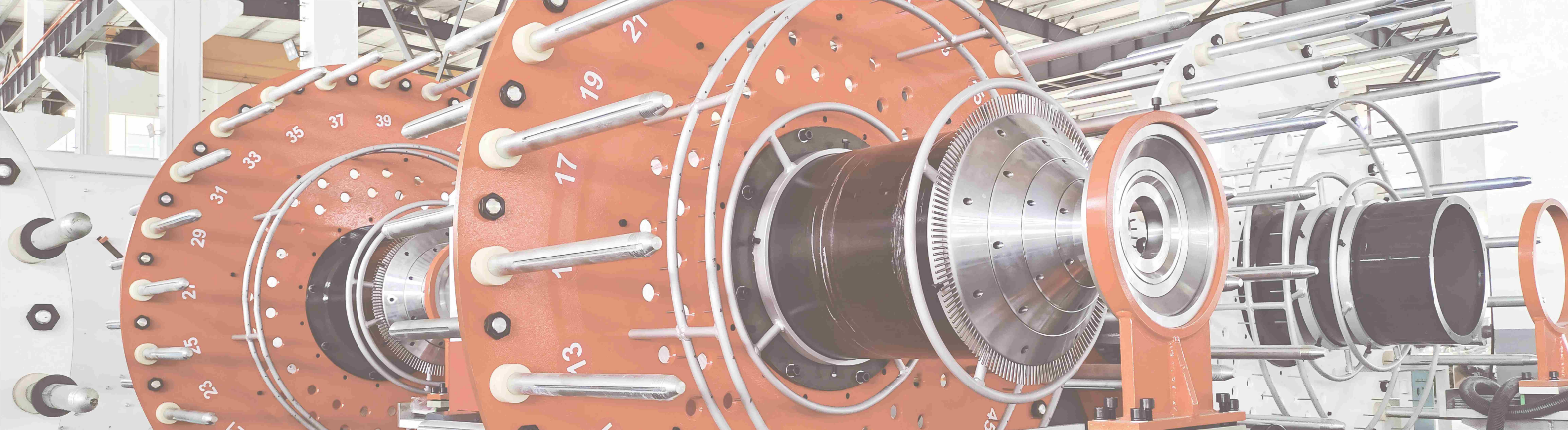
Dongcai Machinery has designed and developed high-speed energy-saving pipe extrusion production lines, plastic composite pipe extrusion production lines, etc. with a new concept, which have high output, low energy consumption, good melt homogeneity, and long-term stability. The production line adopts a modular design scheme to provide convenience for product serialization and universality. At the same time, it provides a perfect overall system solution for saving raw materials, improving automation level, ensuring high output rate, high-quality precision extrusion, and customized highly competitive products for users. From appearance to software system, to production visualization and dataization, comprehensively grasp the production situation, create convenient and affordable solutions for end customers, and respond to the call for green environmental protection with practical actions and technology: energy conservation, emission reduction, carbon reduction, and make due contributions to resource regeneration and green planet.

Technological innovation, advanced manufacturing, and green development.

专注研发生产塑料挤出设备 复合管道设备

Focused on research and development of plastic extrusion equipment and composite pipeline equipment.





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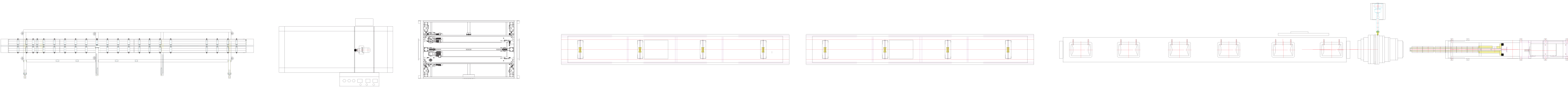
不同压力等级管材的规格尺寸及最小钢丝直径
Specification, size and minimum wire diameter of pipes with different pressure levels

HDPE high-speed and efficient extrusion production line

HDPE 高速高效挤出生产线



型号	model	DCS-63	DCS-110	DCS-160	DCS-250	DCS-315	DCS-450	DCS-630	DCS-800	DCS-1000	DCS-1200	DCS-1600	DCS-2000
管材直径 (mm)	Pipe diameter (mm)	Φ16-63	Φ20-110	Φ40-160	Φ50-250	Φ75-315	Φ90-450	Φ160-630	Φ315-800	Φ400-1000	Φ500-1200	Φ800-1600	Φ1200-2000
主机型号	Host model	60/38	60/40	60/40	75/38	75/38	75/40	90/38	90/38	120/38	120/38	90/38&90/38	90/38&90/38
生产能力 (kg/h)	Production capacity (kg/h)	200-400	300-500	400-550	500-650	500-650	600-700	850-1000	900-1300	1000-1400	1000-1400	1500-2000	1500-2000
主电机功率 (KW)	Main motor power (KW)	90	110	110	160	160	160	250	250	355	355	250+250	280+280



性能和特点

- › 高效率、大产量双倍螺旋设计

› 定径套设计先进, 确保在高速生产厚壁时, 管材的直径和圆度保持稳定

› 配备内冷装置, 抑制融垂, 高效节能

› 牵引力均匀可精准控制
- › 采用先进无屑式精准切割

› 集中控制和协调, 实现自动化生产

› 相比传统生产线, 节能可达35%

› 设备运行中噪音小, 对生产环境影响较小

Performance and Features

- › Efficient and high-yield double helix design

› The advanced design of the sizing sleeve ensures that the diameter and roundness of the pipe remain stable during high-speed production of thick walls

› Equipped with an internal cooling device to suppress sagging and achieve high efficiency and energy conservation

› Uniform traction force and precise control

› Adopting advanced chip free precision cutting technology

› Centralized control and coordination to achieve automated production

› Compared to traditional production lines, energy savings can reach 35%

› Low noise during equipment operation, with minimal impact on the production environment

HDPE high-speed solid wall pipe extrusion production line

HDPE 高速实壁管挤出生产线



东财机械的生产线生产效率较高,连续稳定的生产产品,能够精准的控制管材的尺寸和壁厚。

在产品质量方面,通过东财机械先进的生产线生产的管材质量好,产品物理性能优越,例如强度和韧性高,能承受较大的压力、抗冲击力、耐腐蚀、化学稳定性好,可用于输送多种化学物质。

Dongcai Machinery's production line has high production efficiency, continuous and stable production of products, and can accurately control the size and wall thickness of pipes.

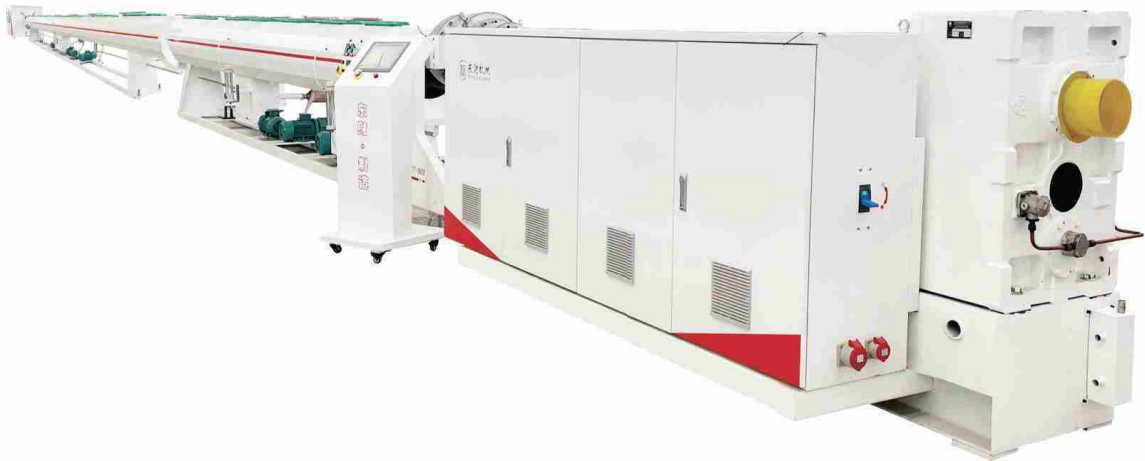
In terms of product quality, the pipes produced through Dongcai Machinery's advanced production line have good quality and superior physical properties, such as high strength and toughness, the ability to withstand large pressures, impact resistance, corrosion resistance, and good chemical stability. They can be used to transport various chemical substances.

High speed extrusion production line for PE PP-R/PP-RT/PP-B pipes

PE PP-R/PP-RT/PP-B 管材高速挤出生产线

PE PP-R/PP-RT/PP-B 管材高速挤出生产线设备引进先进的德国技术,采用高端高标准配置,配备高扭矩、低噪音减速机,可生产耐热性能优良的管材,使高质量和高品质充分体现。

The high-speed extrusion production line equipment for PE PP-R/PP-RT/PP-B pipes introduces advanced German technology, adopts high-end and high standard configurations, and is equipped with high torque and low-noise gearboxes, which can produce pipes with excellent heat resistance performance, fully reflecting high quality and excellence.



型号	model	DCS-63	DCS-110	DCS-160	DCS-250
管材直径 (mm)	Pipe diameter (mm)	Φ 20-63	Φ 20-110	Φ 40-160	Φ 50-250
主机型号	Host model	60/38	60/40	60/40	75/38
生产能力 (kg/h)	Production capacity (kg/h)	200-400	300-500	400-550	500-650
主电机功率 (KW)	Main motor power (KW)	90	110	110	160

PVC pipe extrusion production line

PVC 管材挤出生产线

承压水管管道、污水管道系统、排水管道系统、电气, 电信工程管道系统、农田灌溉网系统。

Pressure bearing water pipeline, sewage pipeline system, drainage pipeline system, electrical and telecommunications engineering pipeline system, farmland irrigation network system.



型号	model	DCS-63	DCS-110	DCS-160	DCS-250	DCS-315	DCS-450	DCS-630	DCS-800	DCS-1000
管材直径 (mm)	Pipe diameter (mm)	Φ16-63	Φ50-110	Φ50-160	Φ75-250	Φ110-315	Φ160-450	Φ315-630	Φ400-800	Φ710-1000
主机型号	Host model	65/132	65/132	65/132	65/132	80/156	80/173	92/188	95/191	110/220
生产能力 (kg/h)	Production capacity (kg/h)	250-350	250-350	250-350	250-350	300-400	450-550	650-800	800-1000	1000-1200
主电机功率 (KW)	Main motor power (KW)	37	37	37	37	55	55	110	132	160

Extrusion production line for profiles and sheets

型材, 板材挤出生产线

型材, 板材挤出生产线加工范围较广。参照国外最新技术, 对机组进行优化设计, 具有塑化均匀, 产量高, 使用寿命长等特点。

在建筑领域, 可加工户外地板, 木塑地板, 木塑快装墙板, 发泡板, pvc硬质/pvc木塑宽幅板, 异型材等。

The extrusion production line for profiles and sheets has a wide processing range. Referring to the latest foreign technology, the unit has been optimized and designed with features such as uniform plasticization, high output, and long service life.

In the field of construction, it can process outdoor flooring, wood plastic flooring, wood plastic quick installation wall panels, foam boards, PVC hard/PVC wood plastic wide boards, special-shaped materials, etc.



High speed steel wire mesh skeleton reinforced polyethylene composite pipe production line

高速钢丝网骨架增强聚乙烯复合管生产线

高速钢丝网骨架管设备, 现已遍布全国, 最新一代人性化设计, 该机组由高速挤出机、精密模具、真空定型台、牵引机组、切割机、翻料架等组成, 主要优势速度快产量高, 能耗低实现可视化, 操作方便, 噪音小, 使用寿命长。高速生产更加稳定, 且换钢丝不用降速, 废品率有效降低且运行更稳定可靠。

The high-speed steel wire mesh skeleton pipe equipment is now spread throughout the country, with the latest generation of humanized design. The unit consists of high-speed extruders, precision molds, vacuum forming tables, traction units, cutting machines, flipping racks, etc. Its main advantages are fast speed, high output, low energy consumption, easy operation, low noise, and long service life. High speed production is more stable, and there is no need to slow down when changing steel wires. The scrap rate is effectively reduced and the operation is more stable and reliable.



应用范围: 本书说明适用于 GSPE 钢丝网骨架(聚乙烯)复合管(执行:GB/T32439-2015)管材安全生产工艺标准。

Application scope: This book explains the safety production process standards applicable to GSPE steel wire mesh skeleton (polyethylene) composite pipes (execution: GB/T32439-2015).

钢丝公称直径、缠绕角度及方向
Steel wire nominal diameter, winding angle and direction

单位: mm
Unit: mm

型号	model	DCS-160	DCS-315	DCS-630	DCS-800	DCS-1000	DCS-1200
管材直径 (mm)	Pipe diameter (mm)	Φ 50-160	Φ 110-315	Φ 315-630	Φ 500-800	Φ 710-1000	Φ 800-1200
最大生产速度 (m/min)	Maximum production speed (m/min)	2.4	2.4	1.2	1.0	0.6	0.6
实际耗电约 (kw)	Actual power consumption is about (kw)	110	170	260	360	350	460
装机功率 (KW)	Installed power (KW)	385	545	855	1150	1150	1400
长*宽*高	Length * Width * Height	73*4.7*3	75*5.5*4	76*6*4	80*6*4	86*7*4	100*4.7*

公称外径	Nominal outer diameter	50—110	125—315	355—630	710—800
钢丝公称直径	Nominal diameter of steel wire	0.5~1.0	0.6~1.3	0.8~1.4	1.0~1.5
缠绕角度°	Winding angle °	54.7° ≤a≤60°			
缠绕方向	Winding direction	左旋+右旋 Left rotation+right rotation			
缠绕角度为钢丝与管材轴线的夹角，可去掉管材样品的聚乙烯外层测量					
The winding angle is the angle between the steel wire and the axis of the pipe, which can be measured by removing the outer layer of polyethylene from the pipe sample.					

New high-speed multi-layer steel wire mesh skeleton reinforced polyethylene composite pipe production line

全新高速多层钢丝网骨架增强聚乙烯复合管生产线

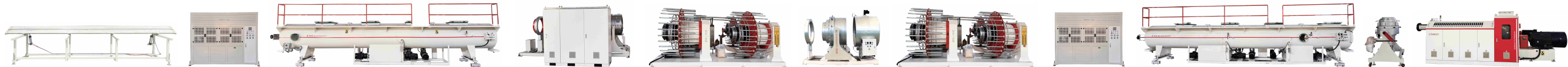


东财机械采用四层或多层连续缠绕增强,使得管材产品耐高压、耐磨、防静电等优点,主要用于石油和天然气领域,化工,电力传输管道,冶金矿山,海水运输,造船,农业和铺设光纤电缆。

该机组由高速挤出机、精密模具、真空定型台、牵引机组、切割机、翻料架等组成,新一代生产线比传统提高150%,全线自动化程度高,配搭全自动封口机组管材加工成本可节约60%。

Dongcai Machinery adopts four or more layers of continuous winding reinforcement, which makes the pipe products resistant to high voltage, wear, anti-static and other advantages. They are mainly used in the fields of oil and gas, chemical industry, power transmission pipelines, metallurgy and mining, seawater transportation, shipbuilding, agriculture, and laying fiber optic cables.

The unit consists of high-speed extruders, precision molds, vacuum forming tables, traction units, cutting machines, flipping racks, etc. The new generation of production lines has increased by 150% compared to traditional ones, with a high degree of automation throughout the entire line. Paired with fully automatic sealing units, the cost of pipe processing can be saved by 60%.



New high-speed automatic sealing machine

全新高速自动封口机

东财机械新一代高速自动封口机完全替代了传统封口:

- 封口成本低, 无需封口环
- 封口速度快, 满足高速钢丝网生产速度, 无需修边场地干净
- 封口端面一体化, 外观统一美观, 操作方便智能, 人工成本大大降低, 生产运行更稳定可靠

Dongcai Machinery's new generation high-speed automatic sealing machine completely replaces traditional sealing:

- with low sealing cost, no need for sealing rings
- fast sealing speed, meeting the production speed of high-speed steel wire mesh, no need for clean trimming site
- integrated sealing end face, uniform and beautiful appearance, easy and intelligent operation, greatly reducing labor costs, and more stable and reliable production operation

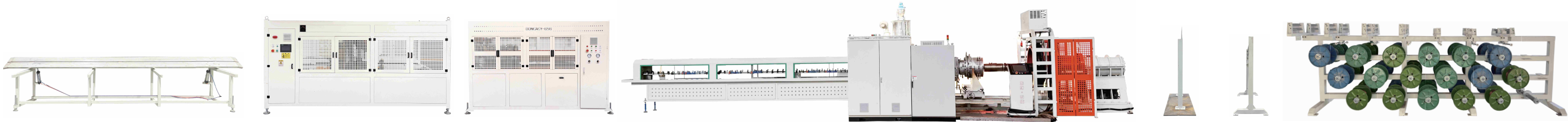


New high-speed automatic sealing machine

钢骨架增强聚乙烯复合管生产线

SRPE系列钢骨架管生产线,采用连续缠绕焊接成型的网状钢筋骨架与高密度聚乙烯为基体,在生产线上连续复合成型的钢骨架塑料复合管材,主要适用于石油、天然气工业油、气污水输送及混输,也适用于饮用水、消防及腐蚀性介质输送,常用于市政工程、化学工业、农业、造船业、热电工程等领域。

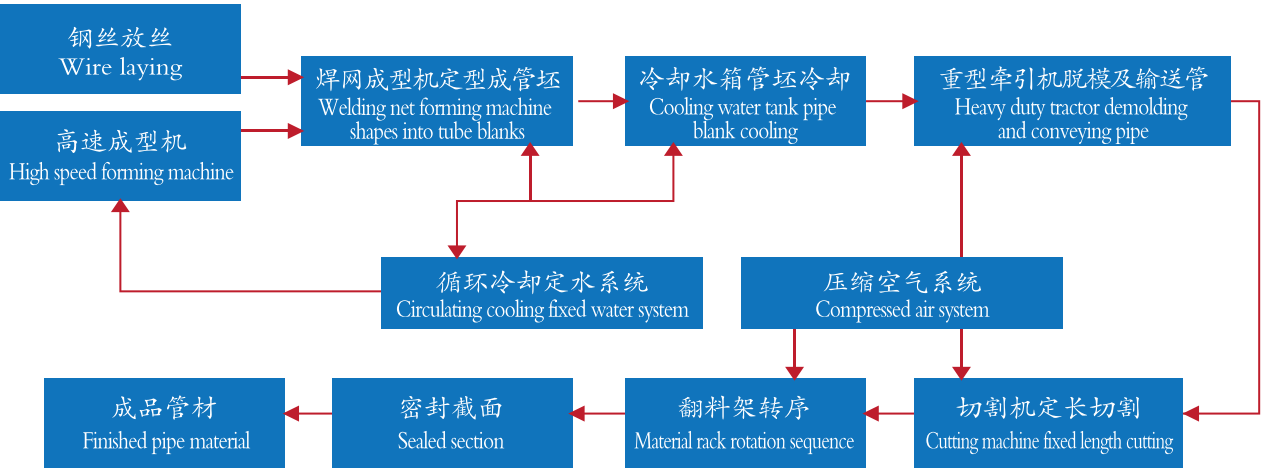
该生产线由放丝架,焊网成型机,高速挤出机,冷却定型台,重型牵引机,带锯切割机,翻料架等组成,焊网成型机采用高效中频阻焊装置,与传统焊机相比,效率更高,运行更稳定。整条生产线采用全自动PLC电脑控制,自动化程度高,操作安全便捷,机组性能可靠,生产稳定高效。



The SRPE series steel skeleton pipe production line uses a mesh steel skeleton formed by continuous winding and welding with high-density polyethylene as the matrix. The steel skeleton plastic composite pipe is continuously composite formed on the production line. It is mainly suitable for the transportation and mixed transportation of oil and gas wastewater in the petroleum and natural gas industries, as well as for the transportation of drinking water, fire protection, and corrosive media. It is commonly used in municipal engineering, chemical industry, agriculture, ship-building, thermal power engineering and other fields.

The production line consists of a wire feeding rack, a welding mesh forming machine, a high-speed extruder, a cooling and shaping table, a heavy-duty traction machine, a band saw cutting machine, a flipping rack, etc. The welding mesh forming machine adopts an efficient intermediate frequency solder mask device, which is more efficient and stable in operation compared to traditional welding machines. The entire production line adopts fully automatic PLC computer control, with high degree of automation, safe and convenient operation, reliable unit performance, and stable and efficient production.

生产工艺流程
Production Process Flow



RTP tape winding reinforced composite pipe production line

RTP 带材缠绕增强复合管生产线

带材缠绕增强复合管生产线将钢帘带、钢纤带、纤维带等增强材料缠绕至塑料芯管上形成复合管道,随着塑料芯管沿旋转框架的回转轴线向前输送,并释放带盘上的增强带材,从而将该增强带材螺旋缠绕在塑料芯管上,在临近缠入位置和缠绕完成后实施加热。

带材缠绕增强复合管可以很好地克服钢管的腐蚀问题以及塑料管道的耐压问题,可应用在石油、天然气开采,高压长距离输送天然气以及各种需要较高压力输送介质的管线领域。

The tape winding reinforced composite pipe production line wraps steel curtain tape, steel fiber tape, fiber tape and other reinforcing materials onto a plastic core pipe to form a composite pipe. As the plastic core pipe is transported forward along the rotation axis of the rotating frame, the reinforcing tape on the tape reel is released, and the reinforcing tape is spiral wound on the plastic core pipe. Heating is carried out near the winding position and after winding is completed.

Tape wrapped reinforced composite pipes can effectively overcome the corrosion problems of steel pipes and the pressure resistance problems of plastic pipelines. They can be applied in the fields of oil and gas extraction, high-pressure long-distance transportation of natural gas, and various pipeline applications that require high-pressure transportation media.



设备特点
Equipment features

高速效率高	High speed and efficiency	带材缠绕的方式能够快速成型满足生产进度	The method of winding the strip can quickly form to meet the production schedule
自动化程度高	High degree of automation	从带材的制造、输送到管材的缠绕、成型等环节，大多采用机械和自动化系统控制能够精准控制各生产环节的参数	From the manufacturing and transportation of strip materials to the winding and forming of pipes, mechanical and automated systems are mostly used to control the parameters of each production process accurately
材料结合性好	Good material adhesion	带材与管材之间的结合通常采用热熔或粘接等方式，这种良好的结合性保证了管材的整体性和密封性	The bonding between strip and pipe is usually achieved through methods such as hot melt or adhesive bonding, which ensures the integrity and sealing of the pipe
一机多用途	Multi functionality of one machine	适应多种增强带材，如玻纤带、钢帘绳带、钢带、芳纶带、涤纶带等	Suitable for various reinforcement tapes, such as fiberglass tape, steel curtain rope tape, steel tape, aramid tape, polyester tape, etc.

Fiber reinforced RTP polyethylene composite pipe production line

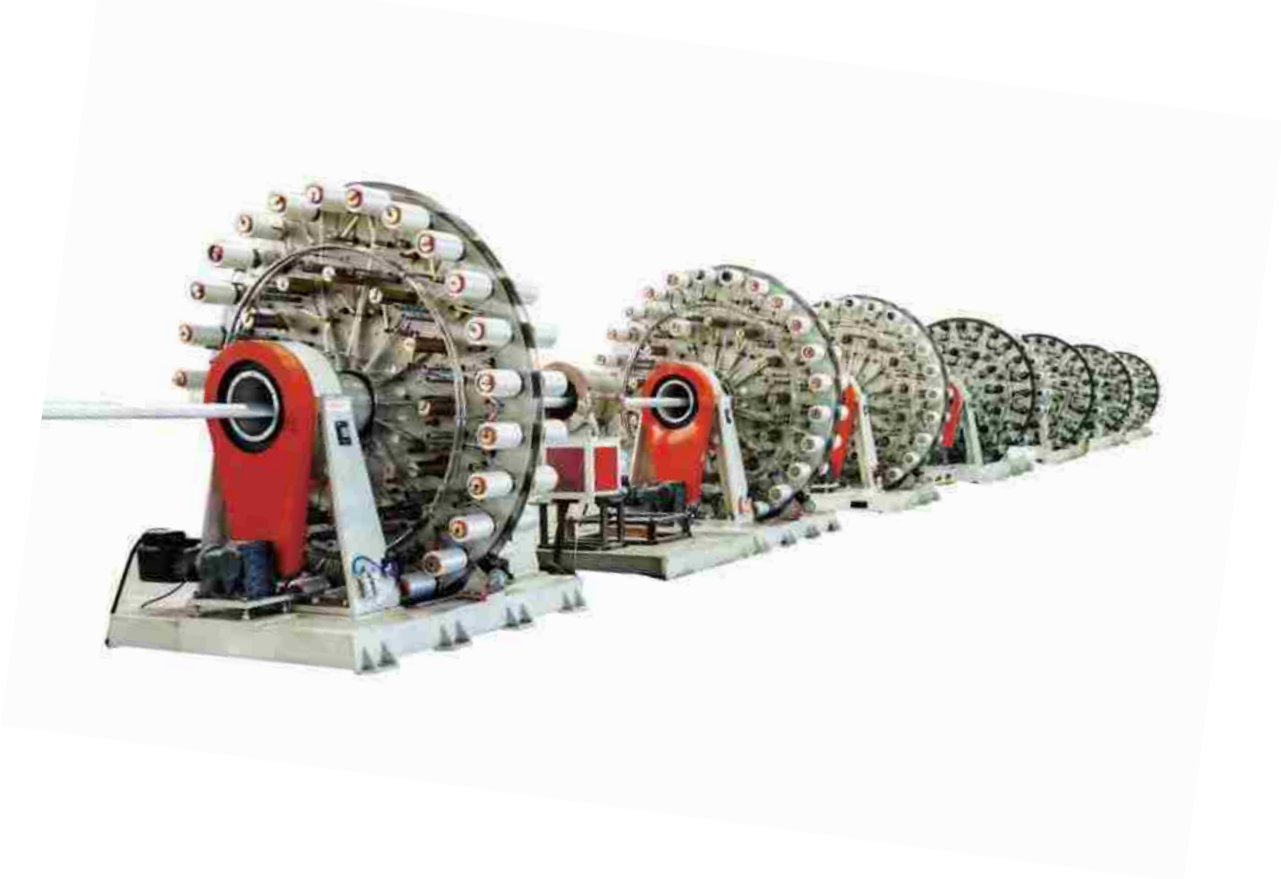
纤维丝增强 RTP 聚乙烯复合管生产线

热塑性复合管到在世界各地发挥着关键性的作用，为输送石油、天然气、输水、化工等高压领域都具有良好的耐压性和可靠性。

纤维丝具有较高的强度，如玻璃纤维、碳纤维等，与热塑性塑料复合后，大大提高了管材的强度，其耐压强度是同壁厚塑料及其复合管道的数倍甚至更高，能够满足高压输送的要求，如在石油、天然气等领域的长距离输送。

Thermoplastic composite pipes play a crucial role around the world, providing excellent pressure resistance and reliability in high-pressure fields such as oil and gas transportation, water delivery, and chemical engineering.

Fiber filaments have high strength, such as glass fiber, carbon fiber, etc. After being compounded with thermoplastic materials, the strength of the pipe is greatly improved. Its compressive strength is several times or even higher than that of plastic and its composite pipes with the same wall thickness, which can meet the requirements of high-pressure transportation, such as long-distance transportation in the fields of oil and natural gas.



Priority clients to work with

重点合作客户

国内主要服务客户（至2023年）
Main domestic service customers (until 2023)

此循序不分公司实力大小或先后排名 This order is not based on the strength or ranking of the company

国际客户
International customers

俄罗斯 Russia	伊朗 Iran	土耳其 Turkey	巴基斯坦 Pakistan
刚果金 Democratic Republic of Congo	哈萨克斯坦 Kazakhstan	南非 South Africa	印尼 Indonesia
越南 Vietnam			

Nominal wall thickness

公称壁厚

公称外径dn Nominal outer diameter dn	公称壁厚en/mm Nominal wall thickness en/mm							
	标准尺寸比 Ctandard dimension ratio							
	SDR9	SSDR11	SDR13.6	SDR17	SDR21	SDR26	SDR33	SDR41
	管系列 Tube series							
	S4	S5	S6.3	S8	S10	S12.5	S16	S20
	PE80级公称压力(MPa) PE80 nominal pressure (MPa)							
	1.6	1.25	1.0	0.8	0.6	0.5	0.4	0.32
	PE100级公称压力(MPa) PE100 nominal pressure (MPa)							
	2.0	1.6	1.25	1.0	0.8	0.6	0.5	0.4
16	2.3	—	—	—	—	—	—	—
20	2.3	2.3	—	—	—	—	—	—
25	3.0	2.3	2.3	—	—	—	—	—
32	3.6	3.0	2.4	2.3	—	—	—	—
40	4.5	3.7	3.0	2.4	2.3	—	—	—
50	5.6	4.6	3.7	3.0	2.4	2.3	—	—
63	7.1	5.8	4.7	3.8	3.0	2.5	—	—
75	8.4	6.8	5.6	4.5	3.6	2.9	—	—
90	10.1	8.2	6.7	5.4	4.3	3.5	—	—
110	12.3	10.0	8.1	6.6	5.3	4.2	—	—
125	14.0	11.4	9.2	7.4	6.0	4.8	—	—
140	15.7	12.7	10.3	8.3	6.7	5.4	—	—
160	17.9	14.6	11.8	9.5	7.7	6.2	—	—
180	20.1	16.4	13.3	10.7	8.6	6.9	—	—
200	22.4	18.2	14.7	11.9	9.6	7.7	—	—
225	25.2	20.5	16.6	13.4	10.8	8.6	—	—
250	27.9	22.7	18.4	14.8	11.9	9.6	—	—
280	31.3	25.4	20.6	16.6	13.4	10.7	—	—
315	35.2	28.6	23.2	18.7	15.0	12.1	9.7	7.7
355	39.7	32.2	26.1	21.1	16.9	13.6	10.9	8.7
400	44.7	36.3	29.4	23.7	19.1	15.3	12.3	9.8
450	50.3	40.9	33.1	26.7	21.5	17.2	13.8	11.0
500	55.8	45.4	36.8	29.7	23.9	19.1	15.3	12.3
560	62.5	50.8	41.2	33.2	26.7	21.4	17.2	13.7
630	70.3	57.2	46.3	37.4	30.0	24.1	19.3	15.4
710	79.3	64.5	52.2	42.1	33.9	27.2	21.8	17.4
800	89.3	72.6	58.8	47.4	38.1	30.6	24.5	19.6
900	—	81.7	66.2	53.3	42.9	34.4	27.6	22.0
1000	—	90.2	72.5	59.3	47.7	38.2	30.6	34.5
1200	—	—	88.2	67.9	57.2	45.9	36.7	29.4
1400	—	—	102.9	82.4	66.7	53.5	42.9	34.3
1600	—	—	117.6	94.1	76.2	61.2	49.0	39.2
1800	—	—	—	105.9	85.7	69.1	54.5	43.8
2000	—	—	—	117.6	95.2	76.9	60.6	48.8
2250	—	—	—	—	107.2	86.0	70.0	55.0
2500	—	—	—	—	119.1	95.6	77.7	61.2
注：公称压力按照C=1.25计算 Note: The nominal pressure is calculated based on c=1.25								

Specification, size and minimum wire diameter of pipes with different pressure levels

不同压力等级管材的规格尺寸及最小钢丝直径

公称 外径 dn mm Nominal outer diameter dn mm	平均外径 d _{av} Average outer diameter d _{av}		聚乙烯 外层 最小 壁厚 e _{y,min} mm Polyethylene outer layer Minimum wall thickness e _{y,min} mm	最小钢丝 公称直径 mm Minimum nominal diameter of steel wire mm	公称压力PN (MPa)				Nominal pressure PN (MPa)											
					0.8		1.0		1.6		2.0		2.5		3.5					
	任一点壁厚e取值范围/mm														Range of wall thickness e at any point/mm					
	d _{em, min} mm	d _{em, min} mm																		
					≥	≤	≥	≤	≥	≤	≥	≤	≥	≤	≥	≤				
50	50.0	51.2	1.5	0.5	—	—	—	—	5.0	6.2	5.5	6.7	6.0	7.5	6.5	8.0				
63	63.0	64.2	1.5	0.5	—	—	—	—	5.5	6.7	6.0	7.2	65	8.0	7.0	8.5				
75	75.0	76.2	1.5	0.5	—	—	—	—	6.0	7.2	6.5	7.7	7.0	8.5	7.5	9.0				
90	90.0	91.4	2.0	0.5	—	—	—	—	6.5	8.0	7.0	8.5	7.5	9.0	8.0	9.5				
110	110.0	111.5	2.0	0.5	—	—	6.0	7.5	7.0	8.5	7.5	9.0	8.0	9.5	8.5	10.0				
125	125.0	126.6	2.0	0.6	—	—	6.0	7.5	7.5	9.0	8.0	9.5	8.5	10.0	9.5	11.0				
140	140.0	141.7	2.0	0.6	—	—	6.0	7.5	8.0	9.5	8.5	10.0	9.5	11.0	10.5	12.0				
160	160.0	162.0	2.5	0.6	—	—	6.5	8.0	9.0	10.5	9.5	11.0	10.5	12.5	11.5	13.5				
200	200.0	202.3	2.5	0.6	—	—	7.0	8.5	9.5	11.0	10.5	12.5	12.5	14.5	13.0	15.2				
225	225.0	227.5	2.5	0.6	—	—	8.0	9.5	10.0	12.0	10.5	12.5	12.5	14.5	—	—				
250	250.0	252.5	2.5	0.6	8.0	9.5	10.5	12.5	12.0	14.2	12.0	14.22	13.0	15.2	—	—				
315	315.0	317.7	3.5	0.6	9.5	11.0	12.0	14.0	13.0	15.5	13.0	15.5	14.5	17.0	—	—				
355	355.0	357.8	3.5	0.8	10.0	11.8	12.5	14.7	14.0	16.5	—	—	—	—	—	—				
40	400.0	403.0	3.5	0.8	10.5	12.5	13.0	15.2	15.0	17.8	—	—	—	—	—	—				
450	450.0	453.2	3.5	0.8	11.5	13.5	14.0	16.5	16.0	18.8	—	—	—	—	—	—				
500	500.0	503.2	3.5	0.8	12.5	14.7	16.0	18.8	18.0	20.8	—	—	—	—	—	—				
560	560.0	563.2	3.5	0.8	17.0	20.0	20.0	23.0	21.0	24.0	—	—	—	—	—	—				
630	630.0	633.2	3.5	0.8	20.0	23.0	22.0	25.0	24.0	27.0	—	—	—	—	—	—				
710	710.0	713.8	3.5	1.0	23.0	26.0	26.0	29.5	—	—	—	—	—	—	—	—				
800	800.0	803.8	3.5	1.0	27.0	30.0	30.0	33.5	—	—	—	—	—	—	—	—				
管材聚乙烯内层壁厚不小于管材壁厚的1/3 The inner wall thickness of polyethylene pipe shall not be less than 1/3 of the pipe wall thickness																				