

High speed Flat Drip Irrigation Tape Line

This flat drip irrigation tape production line is further developed and manufactured, optimizing all the technology of our thousands of high speed & composite pipe production line, absorbing the advanced technology of world class level equipment. It is the leader with the highest speed, fully automation, and outstanding stability.



Model	Extruder	Production speed	Dripper identifying speed	Tape thickness range	Punching Speed	Nominal Power
KDDG- II	SJ-60/36	180m/min	1000-1200pcs/min	0.15-0.6mm	≤900pcs/min	120KW
KDDG-III	SJ-60/36	180m/min	1000-1200pcs/min	0.15-0.9mm	≤900pcs/min	125KW
KDDG-IV	SJ-60/36	180m/min	1000-1300pcs/min	0.15-1.2mm	≤900pcs/min	145KW

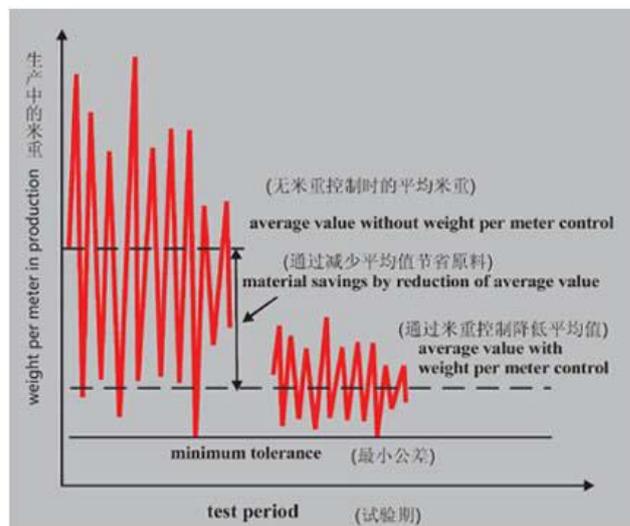
● Control system



©Advanced Siemens PCC control system was applied into this Flat drip irrigation tape line. KAIDE is the only manufacture in China, who had successfully adopt such control system.

©Intelligent functions of this system, such as whole line sync control without any deviation. One touch speed increase or decrease control, high precision temperature control etc, ensure the reliable and convenient operation of the line.

● Gravimeter system



© High precise control system of pipe weight per meter is applied in this flat drip irrigation tape line. Such device will feed material precisely according to the weight per meter and line speed changing; to get a precise gram weight control of produced pipe. Which can shorten the start-up time and save raw materials.

● Dripper sorting system



© Most advanced detecting technologies are applied, such as nanoscale laser identifying device and dripper anti-direction rejecting device, ensuring drippers in production are 100% qualified.

© Dripper Sorting Speed: 1100 pcs/min

● Haul-off machine & Punching Machine



◎ The two-stages haul-off machine of this drip irrigation pipe machine adopted servo control, and the haul-off speed can be synchronously adjusted according to the production requirement, with stable and reliable pulling, low noise.

◎ Punching machine

This drip irrigation pipe machine is equipped with online blind-hole detecting system, once the system detects the not-punched pipe, it will cut off the pipe automatically, meanwhile change over the coiling work position, and report the waste pipe conditions on time.

● Automatic Winding Machine



◎ Automatic winding machine is driven by servo motor and controlled by SIEMENS PLC system.

◎ Application of servo traversing and tension control system in this flat drip irrigation tape line, can ensure the high sync condition of winding speed and line speed, making winded coils even and neat.

◎ During production, the winder can cut pipes and change reels automatically according to the setting length. And also print length tag of each coil.

High Speed Round Drip Irrigation Pipe Line

The Round Drip irrigation pipe machine, is independently developed by KAIDE company, with high highest speed and stable performance. Have been exported to many countries and areas: Egypt, Iran, Saudia Arabia, Morrocco, Cyprus, Mexico, Ukraine, Russia, Korea, etc...



Line Model	Screw Diameter	L/D	Production Scope	Production Speed	Nominal Power
SJ-80	Φ60mm	36:1	Φ8-20mm	60m/min	91KW
SJ-65	Φ65mm	33:1	Φ8-20mm	35m/min	75KW
SJ-45	Φ45mm	30:1	Φ8-20mm	20m/min	37KW

● Drinker sorting & conveying system

This drip irrigation pipe line adopted centrifugal screening device for drippers screening & sequence. With below advantages,:

- ◎ High precision screening
- ◎ Drinker identifying speed 400pcs/min

which ensure the precise dripper supply during high speed production.



●Punching system

◎The round drip irrigation pipe line adopted mechanical punching mode, automatically tracking the pipe production speed, guaranteed the accuracy of punching position.

◎ 2 or 4 or 6 Holes punching

◎ Punching speed: 400pcs/min



● Synchronous control

The synchronous control is realized from dripper feeding, screening & sequence, conveying & inlaid, haul-off, to punching and coiling, which ensures the precise control and stable running of high speed production.

2 Layers Brown Color Round Drip Irrigation Pipe Machine

2 Layers Brown Round Drip Irrigation Pipe is mainly application in garden irrigation system, as brown has the similar color with the soils, not influence the garden beautiful view.

© This drip irrigation pipe machine adopts two extruders for two layers extrusion, and equipped with composite die head moulds(Patented product).



© The outer layer thickness is take about 10%-15%, very thin. And certain percent of recycled raw materials can mixed into the inner layer for saving cost.

© Specially designed two layers composite die head moulds, high quality alloy steel 40Cr. Each layer thickness can be adjusted freely, no need to stop the machine.



© Pipe Diameter: 6mm,8mm,10mm,12mm,16mm,20mm as customerized .

© Pipe Thickness: 0.5m-1.2mm

© Single Layer/2 Layers pipe production

© Holes Punching: 2holes/4holes/6holes



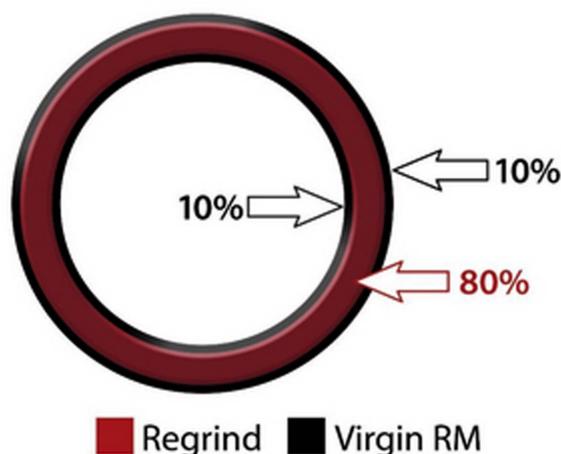
3 Layers Round Drip Irrigation Pipe Making Machine

This 3 layers Round Drip Irrigation Pipe Machine, is used to produce round drip pipe with 3 layers. Its layers distribution: 10%(outer layer)+80%(middle layer)+10% (inner layer).

New materials is for inner/outer layer, recycled raw materials was applicated for middle layer,which can largely reduce the materials cost,and also can get elegant inner/outer layer surface.

Line Model	Screw Diameter	L/D	Production Scope	Production Speed	Nominal Power
SJ-80/65	Φ80/65mm	33:1	Φ6-20mm	60m/min	105KW
SJ-45/45	Φ45/45mm	33:1	Φ6-20mm	20m/min	50KW

● **Composite 3 Layers Die Head Moulds**



© Die Head Material: High Quality Alloy Steel:40Cr

© Pipe Size Range: 6mm/8mm/12mm/16mm/20mm



● **Punching System**

- ◎ The round drip irrigation pipe line adopted servo mechanical punching mode;
- ◎ 2 or 4 or 6 Holes punching
- ◎ Punching speed: 400pcs/min

Dual Use HDPE+Round Drip Irrigation Pipe Machine

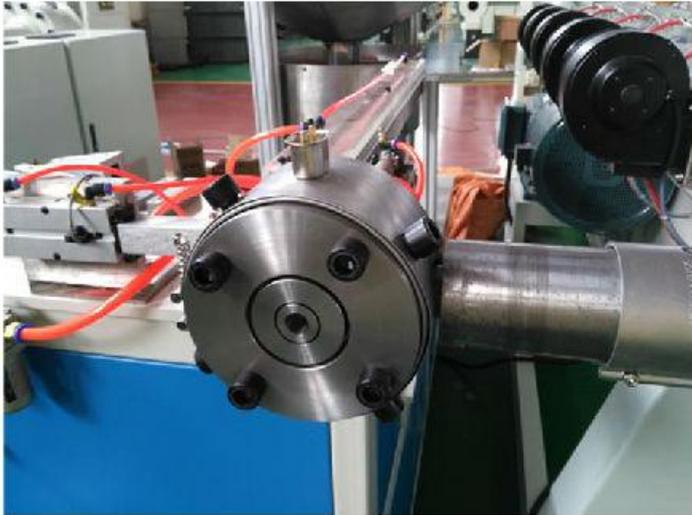
The line has two purposes, it can be as HDPE Pipe production line, and Round Drip Irrigation pipe machine, saving purchase cost.



◎ **Productoin Line Composition**

- High output PE Pipe Extruder
- Water Dripper Sorting & Conveying System
- Cross Design Die Head Moulds for Drip irrigation Pipe
- HDPE Pipe Die Head Moulds
- Vacuum Calibration Tank
- Cooling Flumes

- Pipe Punching Machine
- Haul-off Machinery
- Double Working Position Coiler
- Pipe Stacker



© Manufactured Pipe (HDPE+Round Drip Pipe)



© Round Drip Irrigation pipe specification

- Pipe Diameter:6mm,8mm,12mm,16mm,20mm
- Pipe Thickness: 0.5mm-1.5mm
- Dripper distance: 15cm-200cm
- Holes quantity:2pcs/4pcs/6pcs

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