Twin Screw Extruder ABS PC Alloy Compounding Machine 600-800 kg h 12 Month Warranty for Plastic Modification

Our Product Introduction

Basic Information

- Place of Origin: Nanjing, China
- Brand Name: HLD
- Certification: CE, ISO 9001:2015
- Model Number: Customized
- Minimum Order Quantity: 1 Set
- Price: USD 92000-126000 / Set
- Packaging Details: Bubble wrap, stretch film and fumigation-free plywood case for sea shipment
- Delivery Time: 35-45 working days after deposit received
- Payment Terms: T/T, L/C, Western Union
- Supply Ability: 20 Sets per Month



Product Specification

- Screw Design: Co-rotating Intermeshing Twin Screw
- Screw Diameter: 71.5 Mm
- L/D Ratio: 44:1
- Main Motor Power: 200 KW
- Screw Speed: 500 Rpm Max
- Output Capacity: 600-800 Kg/h
- Venting: Two Stage Deep Vacuum Venting
- Side Feeder: Downstream Side Feeder For Fillers And Additives
- Melt Filtration: Hydraulic Screen Changer 80 Mesh
- Pelletizing System: Water Ring Pelletizing With Centrifugal Dryer
- Suitable Materials: ABS, PC, PC ABS Alloy, PBT, HIPS
- Control System: Siemens PLC With Recipe Management
- Highlight: **ABS PC alloy compounding extruder**, **twin screw extruder engineering plastics**, **600 kg h plastic alloy pelletizer**



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Product Description

Alloying is a compatibility problem before it is a capacity problem

ABS and PC do not blend by themselves. They need a compatibiliser dispersed at the right shear, at the right temperature, in the right order. Add to that the residual monomer that PC carries and the moisture that ABS absorbs, and the machine has to do three jobs at once: disperse, devolatilise and keep the melt from degrading. Capacity only matters after those three are solved.

The melt train, stage by stage

Feeding is gravimetric on both polymer streams, so the alloy ratio stays where the formulation says. Melting is followed by a dispersive kneading section that breaks the compatibiliser down to the scale where it can sit at the interface. Filler, flame retardant or pigment is then added through a downstream side feeder, which keeps abrasive additives away from the high shear zone.

Two vent stages follow. The first is atmospheric and releases the bulk of the volatiles; the second runs deep vacuum and pulls residual monomer and moisture down to the levels that injection moulders notice as splay. An 80 mesh hydraulic screen changer then removes gels and contamination before the die.

Series data

Model	Screw Diameter	L/D	Motor Power	Screen Changer	Capacity
TSE-20B	21.7mm	40:1 44:1 48:1 52:1	4/5.5/7.5KW	Hydraulic	5-20KG
TSE-35B	35.6mm	40:1 44:1 48:1 52:1	18.5/22KW	Hydraulic	60-100KG
TSE-50B	51mm	40:1 44:1 48:1 52:1	45/55KW	Hydraulic	150KG
TSE-65B	62.4mm	40:1 44:1 48:1 52:1	75/90KW	Hydraulic	250-350KG
TSE-75B	**71.5mm**	**40:1 44:1 48:1 52:1**	**132KW**	**Hydraulic**	**500-650KG**

Shaded frame covers the 600-800 kg/h band for ABS PC and similar engineering alloys.

Downstream and drying

Water ring pelletizing with a centrifugal dryer is the usual arrangement. Pellets leave below 0.3 percent moisture, which matters because PC hydrolyses readily. For transparent or light diffusion grades, the die and water system are cleaned separately to avoid cross contamination.

Where the quality risk sits

Yellowing usually traces back to melt temperature spikes, not to the resin.

Gels come from insufficient filtration or from dead spots in the die head.

Poor impact values usually mean the compatibiliser was not dispersed early enough.

Splay at the moulder is nearly always residual moisture, so verify the dryer before blaming the compound.

Programs we support

PC ABS for automotive interior and electronics housings, flame retardant ABS, PC light diffusion grades, HIPS and PBT compounds, and mineral or glass filled engineering alloys. Output is 600 to 800 kg/h on the 71.5 mm frame.

Send the alloy ratio, the additive package and the impact target, and we will propose the screw configuration and venting depth together.

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