Profit from the expertise of a system supplier
Complete pipe extrusion lines
Facts and figures regarding pipe extrusion

Product examples and applications

For every application, we offer systems tailored to your wishes, from a single source. No matter what kind of pipe you are making – whether smooth or corrugated, made from PVC or P0 – KraussMaffei Berstorff pipe extrusion systems keep all your options open:

- Drinking water pipes
- Cable conduits
- Coextruded pipes with different combinations of materials, e.g. PVC foamcore pipes
- PUR foam-insulated pipes

- Sewage pipes
- Gas pipes
- Highly filled pipes
- Sheathing for steel pipe
- Extra-large pipes up to 2500 mm diameter

- Irrigation pipes
- Multilayer pipes
- RTP pipes
- Extralarge PE pipe up to 2500 mm diameter

- Drainage pipes
- PE-X pipes
- PE pipe for transporting drinking water
- PE pipe for transporting drinking water

- Hot water and heating pipes
- Direct-extruded, highly filled, three-layer pipe
- PE-X pipes
- PP-R pipe with glass-fiber reinforced core layer
- C PVC pipes for chemical applications

- Multilayer pipes
- PE-X pipes
- RTP pipes
- PVC foam core pipes

- PUR foam-insulated pipes
- Direct-extruded, highly filled, three-layer pipe
- 3- and 5-layer PE-RT pipes for wall temperature control and underfloor heating
- Two-layer, corrugated PP pipe
- Multilayer PE pipe

- Hot water and heating pipes
- Sewage pipes
- Irrigation pipes
- Drainage pipes
- Hot water and heating pipes
Profit from the expertise of a system supplier
Complete pipe extrusion lines

Whether you are processing PVC or PO, KraussMaffei Berstorff has everything you need for producing plastic pipes from 5 mm to 2500 mm in diameter – including automation components for maximizing material savings.

Our product portfolio covers single-screw extruders, counter-rotating and corotating twin-screw extruders with the corresponding pipeheads, and downstream components through to fully automated pipe lines. All our components and automation systems are consistently engineered to maximize savings on materials, energy and costs, without compromising on product quality. We are your expert partner for any type of pipe extrusion line.

Your benefits:
- First-class system and process solutions from a single source
- System solutions for efficient and effective production
- Expert partner for customer-specific special solutions
Meet the machines
Take a tour of a high-performance extrusion line for pipe production

**Socket-forming machine**
For bonded, O-ring and pressure pipes in standard and high-performance versions for PVC and PP pipes

**Cutting unit**
Cross-cut saw, planetary saws and swarf-free cutters for cutting all thermoplastic pipes to length

**Haul-off**
Belt haul-offs, double caterpillar haul-offs, multiple caterpillar haul-offs
**Calibration systems**
For PVC, PO and engineering plastics, sleeve or diskpack calibrators or a fully automated QuickSwitch solution

**Spray bath with high-performance cooling**
Spray bath and vacuum tank with flexible design for perfect integration in the extrusion line

**Vacuum tank**
State-of-the-art and easy to operate with multiple options for ensuring optimum quality

**Single-screw extruder**
For PO materials, with spiral distributor pipehead
KraussMaffei Berstorff develops and provides complete conventional and fully automated extrusion lines, ranging from extruders, pipe molds, downstream and automation components, to all peripheral equipment.

**Application-specific, proven line components**
Our extruders, molds, calibration systems and downstream components are tailored to your individual requirements and have already been tested multiple times. All downstream components such as vacuum tanks, spray tanks, haul-offs, cutting units, socket forming machines and additional equipment are engineered for optimum interoperability; the automation components are designed for maximum operational safety and ease of operation and servicing. All functions for control and monitoring are fully integrated into the modular extrusion line control system. The result: With KraussMaffei Berstorff systems, you achieve the highest output with the greatest possible flexibility and maximum material savings. We also supply a range of optional addons for our complete extrusion systems:

**Fully automated additional equipment**
- Seal ring insertion robots
- Pipe hoist and pipe rotating units
- Bundlers
- Palletizers

**Winding systems**
We supply single and twin winders for polyolefin pipe up to 160 mm in diameter.

**Additional equipment**
- Mixers
- Material feeding systems, plus weighing and metering systems
- Screen changers
- Melt pumps
- Wall thickness and diameter gages
- Marking devices
- Winches as start-up aid
- Pipe bending machines
- Thread-cutting machines
- Shredding and grinding systems
The perfect team line-up for successful pipe extrusion – from the extruder to all peripherals

Twin-screw and single-screw extruders are the powerful heart of your pipe extrusion line. Thanks to their modular design with integrated control cabinet and control panel, our extruders are tailored to every application and can meet any market requirement.

36D twin-screw extruder series
Our 36D twin-screw extruders with their HPG (High Performance Geometry) screw concept are ideally suited to producing U-PVC, M-PVC and foamcore PVC pipes, as well as PVC-O pipes and pipes with a high filler content. The HPG screw design incorporates an effective preheating length with an extended output and mixing zone. The whole length of 36 L/D can be used for processing the PVC compound. This is very advantageous for processors because it allows considerable flexibility when processing many different formulations – with maximum output and a perfectly homogeneous melt every time. The HPG screw concept reduces process fluctuations to an absolute minimum for all types of PVC pipe formulation.

36D single-screw extruder series
Our 36D single-screw extruders are specially designed to produce polyolefin pipes in an extremely cost-effective way by combining very high output with premium pipe quality. The processing unit is engineered for flexibility and has high-performance screws that are matched to the raw material. All extruders are fitted with a high-performance U-shaped gear system and have a flexible drive concept (AC or DC motor) for maximum versatility.

The core of your pipe extrusion system – the KraussMaffei Berstorff extruder

Compact, space-saving coextrusion solutions
We offer customer-specific coextrusion versions of both our single-screw and twin-screw extruders for processing different substances such as recycled materials or high-filled formulations. Compact machine designs save space and technically mature solutions guarantee economical production.
Global system solutions for sustainable production solutions

36D series single-screw extruder fitted with AC motor and gearless drive unit.
Drive concepts for efficient production
KraussMaffei Berstorff single and twin-screw extruders are fitted with highly efficient air-cooled (or water-cooled) AC motors as standard. In combination with optimized gearboxes, this drive train offers outstanding levels of energy efficiency for a wide range of speeds and applications. The very high efficiency of the motors enables different polymers to be extruded efficiently even at partial load and guarantees energy savings of 5-10% when compared with standard motors. A number of models are also available with direct drive and high-torque motors, which offer additional energy-saving potential despite the higher investment costs. Maintenance and servicing costs can also be reduced by using gearless drive units. For extruders in the 41D series we offer frequency-controlled cooling fans, which combine uniform cooling from an air flow with energy efficient operation.

EcoPac insulation for saving energy
All our twin-screw extruders can be fitted with EcoPac insulating sleeves, which achieve further energy savings of 5-10% both during continuous operation and during the heating phase.

Energy can even be saved when using KraussMaffei Berstorff pipeheads. EcoPac insulating sleeves, which are also available for pipeheads, significantly reduce heating times. Heat output can also be considerably reduced in stationary operation. In combination with optimally designed flow channels, which allow the melt to flow efficiently with low pressure loss, our pipeheads make production cost-effective and efficient.
Pipe extrusion
Sustainable production

Optimal systems for maximum machine availability
Controlling costs is a top priority in pipe extrusion. Competition is fierce and the prices that can be charged for extruded pipes are sometimes not much higher than the cost of their raw materials. Keeping your material consumption as low as possible is therefore decisive in reducing costs and increasing profitability. KraussMaffei Berstorff extruder systems are unrivaled in their ability to get the most pipe out of the least material while maintaining consistent quality. Large quantities of raw materials can be saved by keeping pipe diameter and wall thickness within tight tolerances. This can be achieved only by employing a sophisticated control system capable of measuring and regulating the entire extrusion line. All components and automation systems in our pipe extrusion lines are consistently engineered to maximize savings on materials without compromising on product quality. We have developed flexible extrusion lines to increase cost-efficiency – such as the QuickSwitch System for making in-line dimensional changes without interrupting production of PO pipes. Other processes that reduce material costs include:

- Gravimetric melt throughput measurement and closed-loop control systems for dispensing materials precisely
- Ultrasonic measuring gages for defining wall thickness exactly
- Direct extrusion systems for manufacturing cost-effective, highly filled PP pipes
- 36D twin-screw extruders, which have been engineered specifically for manufacturing highly filled PVC pipes with a chalk content of up to 60 phr

Increasing productivity with innovative IPC technology
The technology developed by KraussMaffei Berstorff for internal pipe cooling (IPC) is the answer to the constantly increasing demands of pipe producers for an extrusion system that takes into account efficient production, minimum space requirements, reduced investment costs and increased output, which are the most important criteria in making a decision.

With the aid of IPC technology, you can not only cool the outside of the pipe with water in vacuum tanks and cooling baths, but also cool the inside of the pipe using air. This has a particularly positive effect on thick-walled pipes, from which heat can be removed only very inefficiently using standard cooling technology.

Design of the cooling zone (vacuum tanks and spray baths)*

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Pipe diameter/wall thickness 225 x 20.5 mm
Line speed: 0.8 m/min
Distance VT-SB 1.5 m
Distance SB-SB 1.5 m
Total cooling length: 45 m

VT 9 m  SB 6 m  SB 6 m  SB 6 m  SB 6 m  LT 6 m

* Tailored to individual production requirements

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Line speed: 0.8 m/min
Distance VT-SB 1.5 m
Distance SB-SB 1.5 m
Total cooling length: 45 m

* Tailored to individual production requirements
The IPC system can be used with all PO pipe extrusion lines from 110-2500 mm in diameter [producing SDR 26 pipe and below]. The processor benefits from considerable advantages – for example, shortening the cooling section by up to 40 percent reduces both investment costs and space requirements.

**Twice the throughput with double-strand extrusion**

Improving extruder performance will increase your profit margins. Modern high-performance extruder lines, which cost little more than earlier ones, increase your productivity without requiring more space or additional staff to operate them. Double-strand extruders are a good example. Pipe throughput is often constrained by the die pressure, the calibration system or the haul-off speed. Double-strand extrusion doubles the extruder’s throughput of small-diameter pipe. Adjusting the haul-off speed and the cutter function separately for each strand cuts material consumption to an all-time low, because differences in material flow can be allowed for and wall-thickness kept within tight tolerances. Double-strand systems are available for diameters ranging from 12 to 160 mm.

**Your benefits:**

- Robust, high-performance, drive system for single and twin-screw extruders – this makes the extruders particularly low maintenance and durable
- Consistently high output rates at low screw speeds
- Outstanding and consistent product quality
- Efficient and cost-effective production
- Outstanding price/performance ratio
Extruder-pipehead combination for producing PVC foamcore pipes.
C6 control system – flexible system for open-and closed-loop control and monitoring of an extrusion line

With its new, innovative C6 control system, KraussMaffei Berstorff offers fast, direct access at all times to the individual units of an extrusion line, the extruders which work conjointly to produce the product, and to integrated downstream equipment.

With its numerous monitoring and control functions, the C6 control system ensures optimal production preparation and transparency throughout the production process, thereby satisfying the most stringent requirements for excellent product quality and a high level of process reliability.

Multi-touch technology for intuitive operation
The C6 control system is equipped with the latest multi-touch technology and state-of-the-art hardware components. A high-resolution 24-inch full HD screen provides an optimal overview. The intuitive operation and clear screen layout facilitate fast intervention and provide a comprehensive process overview. Units and functions can easily be operated and activated via the touchscreen display. With the C6 control system, KraussMaffei Berstorff has placed a particular emphasis on maintaining continuity in the design in terms of both its operation and its functionality, which have proven successful over a great many years.

Maximum flexibility
The C6 control system offers the user an incredibly high level of flexibility. The composition of parameter pages can be chosen freely, and display and parameter texts can be tailored to individual requirements. In addition, the system components can be connected and disconnected as required.

Fast, secure access management using RFID technology
The C6 control system allows fast, secure access by means of non-contact identification using RFID readers. Remote diagnostics via the Internet and data interfaces to connect to the company network tip the balance to make the C6 control system the perfect solution for all your extrusion line’s control tasks.

Your benefits:
- Modern, innovative operating philosophy
- Fast, intuitive operation
- Highly flexible
- Maximum process reliability
- Optimal monitoring of integrated system concepts and standalone machines
- A variety of user-friendly models

Various operating configurations are available

Swivel-mounted on switching cabinet (standard version)  Mounted on switching cabinet door, tilting (option)  Boom-mounted version (option)  Mobile version (option)
OEE Plus
Boosting cost-efficiency for you

High overall equipment efficiency (OEE) is a fundamental prerequisite for your company’s success. KraussMaffei Berstorff’s product portfolio comprises tailored machines and lines along with perfectly matched services that increase the economic efficiency and the sustainability of your production. Benefit from our proven know-how of extrusion technology in any application.

For more information about OEE Plus, visit: www.kraussmaffeiberstorff.com/oeeplus
KraussMaffei Berstorff
A strong brand in a unique global group

Value-proven Extrusion Technology solutions
Around the world, KraussMaffei Berstorff stands for reliable and value-proven solutions in Extrusion Technology. These range from using individual extruders for degassing in polymerization, compounding, pipe, profile, film and sheet extrusion, physical foaming and the manufacture of technical rubber articles and intermediates for tire production up to complete extrusion lines. All machines and systems from KraussMaffei Berstorff are custom-configured, for example for the chemical, automotive, construction, packaging or pharmaceutical industry.

There for you around the world
KraussMaffei Berstorff is your partner – from the first planning meeting through development of the best possible technical and business solution up through commissioning, servicing and production of your system. We guarantee high-quality advice, solution expertise, reliable spare parts logistics and fast-reacting service during each phase. Our goal is increasing your success.

Individualized service
Benefit from KraussMaffei Berstorff’s reliable service. Our customer service team and experienced fitters, technicians and engineers are there for you as quickly as possible and even help on location to optimize your systems and processes and to minimize downtime as much as possible. Rely on our highly skilled repair and spare parts service.

You can find additional information about KraussMaffei Berstorff at: www.kraussmaffeiberstorff.com

KraussMaffei Group
Comprehensive expertise

Unique selling proposition Technology
The KraussMaffei Group is the only provider in the world to possess the essential machine technologies for plastics and rubber processing with its KraussMaffei, KraussMaffei Berstorff and Netstal brands: Injection Molding Machinery, Automation, Reaction Process Machinery and Extrusion Technology.

The group is represented internationally with more than 30 subsidiaries and over ten production plants as well as about 570 commercial and service partners. This is what makes us your highly skilled and integrated partner. Use our comprehensive and unique expertise in the industry.

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