

# SMALL AND MEDIUM DIAMETER PIPE EXTRUSION

CDS's line of downstream machinery can be engineered to process extruded and co-extruded pipes of various materials and sizes at different output rates. The following are examples of post-extruder equipment for processing small, medium, and large-sized diameter pipes.



## COOLING & SIZING

### Vacuum Sizing Tanks



*Copper spray bar(s) for increased heat dissipation*

#### Standard configurations, CVS

- Tank length: 6 - 20 ft.
- Tank cross section (w x h): 8 - 32 in.
- Vacuum pumps: 1 - 4 (3 - 7.5 Hp)
- 3-axis movement (vertical=6 in.; lateral=3 in.; longitudinal=18 - 48 in.)
- **Options:** Water recirculation system, integrated cooling system, air wipe chamber, quick-change hookups, tooling manifold, water filter.

CVS 10-14 with water recirculation system

### Spray Cooling Tanks



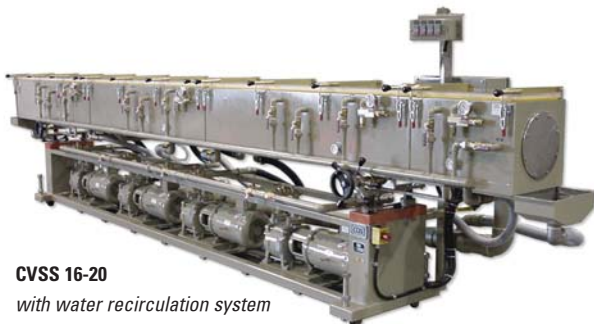
*Fixed or interchangeable spray bars with quick-change nozzles*

#### Standard configurations, CST

- Tank length: 12 - 20 ft.
- Tank cross section (w x h): 8 x 8 in. to 40 x 40 in.
- Spray bars: 2 - 8
- 3-axis movement (vertical=6 in.; lateral=3 in.; longitudinal=18 - 48 in.)
- **Options:** Water recirculation system, integrated cooling system, air wipe chamber, quick-change hook ups, tooling manifold, water filter.

CVS 10-10 with water recirculation system

### Vacuum Spray Sizing Tanks



*For more flexible cooling, CDS's Vacuum Spray Sizing tanks can cool in both flood and spray modes.*

#### Standard configurations, CVSS

- Tank length: 8 - 20 ft.
- Tank cross section (w x h): 8 - 24 in.
- Compartments: 1 - 4
- Vacuum pumps: 1 - 4 (3 - 5 Hp)
- AC motors: 5 or 7.5 Hp (selected models only)
- Spray bars: 2 - 6
- 3-axis movement (vertical=6 in.; lateral=3 in.; longitudinal=18 - 48 in.)
- **Options:** Water recirculation system, integrated cooling system, air wipe chamber, quick-change hook ups, tooling manifold, water filter.

CVSS 16-20 with water recirculation system

Note: Machine configurations and model selection will differ depending on the extrusion process, extruder throughput, line speed, pipe wall thickness, and material.

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# SMALL AND MEDIUM DIAMETER PIPE EXTRUSION



## PULLING

### Belt (CBH) and Pipe (CPH) Pullers



**Belt Puller**  
CBH 25-4



**Pipe Puller** (see next page for more details on the CPH series)  
CSPH 240-4

*Individually powered 8-track conveyor assembly equipped with rubber V-shaped cleats.*

#### Standard configurations, CBH

- Contact length: 9.5 - 60 in.
- Contact width: 2 - 24 in.
- Power: 3/4 - 7.5 Hp
- Speed range: 0 - 800 fpm
- **Options:** Servo and Vector motors, digital speed indicator, master/follower switch, safety cage enclosures, pneumatic control, mechanical footage counter, remote control, various belt materials.

## CUTTING

### Fly-knife Cutters Traveling Cut-off Saws



**Servo Fly-knife Cutter**  
CSFK 4.5 (4.7 in. maximum O.D.)



**Traveling Cut-off Saw**  
CTS 11-24 (10.7 in. maximum O.D.)

#### Standard configurations, CSFK

- Pipe capacity: 1/16 - 6 in. (O.D.)
- Diameter bushing: 2.5 - 6.76 in.
- Cutting mode: start/stop or "on demand"
- Motor: 3 - 6 Hp
- Blade speed: 50 - 2000 RPM
- **Options:** touch screen controls, dust collector, various blade shapes, blade lubrication system.

#### Standard configurations, CTS

- Pipe capacity: 3 - 10.7 in. (O.D.)
- Blade diameter: 10 - 28 in.
- Motor: 1.5 - 7 Hp AC
- **Options:** touch screen controls, dust collector, multi-angled clamp, various blade types, electronic control.

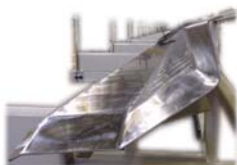
*Servo-driven models also available*

## COLLECTION

### Collection Tables



**CTPP 8-50**



#### Standard configurations, CTPP

- Pipe capacity: 0 - 12 in. (O.D.)
- Table width: 6 - 12 in.
- Table length: 12 - 50 ft.
- Table adjustment: 39 - 45 in.
- Electrics: 120 V / 1 Ph / 60 Hz

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# LARGE DIAMETER PIPE EXTRUSION

## COOLING & SIZING

### Vacuum Spray Sizing Tanks



**Vacuum Spray Sizing Tank**  
CVSS 40-20R (24 in. maximum O.D.)



#### Standard configurations, CVSS (large diameter)

- Pipe capacity: 18 - 26 in. (O.D.)
- Tank outer diameter: 32 - 48 in.
- Spray bars: 6 - 8
- 3-axis movement (vertical=6 in.; lateral=3 in.; longitudinal=18 - 48\* in.)
- **Options:** Water recirculation system, integrated cooling system, air wipe chamber, quick-change hookups, tooling manifold, water filter.

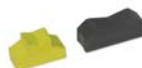
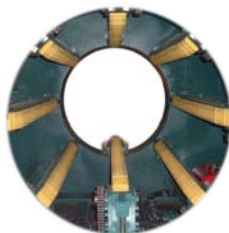
\* Hydraulic movement

## PULLING

### Pipe Pullers



**Pipe Puller**  
CPH 872-40 (40 in. maximum O.D.)



*Individually powered 8-track conveyor assembly equipped with rubber V-shaped cleats.*

#### Standard configurations, CPH (large diameter)

- Pipe capacity: 16 - 40 in. (O.D.)
- Contact length: 60 - 72 in. (O.D.)
- Contact width: 3.5 in.
- Motors and drives:\* Inverter or Vector
- **Options:** custom-profiled cleats, remote control, footage counter, master/follower switch, isolation transformer.

\* Horsepower and quantity configurable to customer specifications

## CUTTING

### Planetary Saws



**Planetary Saw**  
CRS 6-18 (20 in. maximum O.D.)

## INTEGRATED LINES



#### Available standard models:

**CRS 3-16:** 3 - 16 in. (76.2 - 406.4 mm)

**CRS 10-24:** 10 - 24 in. (254 - 609.6 mm)

Note: Machine configurations and model selection will differ depending on the extrusion process, extruder throughput, line speed, pipe wall thickness, and material.

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