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

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 hook ups, tooling manifold, water filter.

Copper spray bar(s) for increased heat dissipation

CVS 10-14 with water recirculation system

Spray Cooling Tanks

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.

Fixed or interchangeable spray bars with quick-change nozzles

CVS 10-10 with water recirculation system

Vacuum Spray Sizing Tanks

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.

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

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.
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.

Standard configurations, CPH

CUTTING
Fly-knife Cutters
Traveling Cut-off Saws

- Servo Fly-knife Cutter CSFK 4.5 (4.7 in. maximum O.D.)
- Travelling 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 length control.

Collection Tables

- CTTP 8-50

Servo-driven models also available

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

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.