



佛山市利长机电有限公司 FOSHAN LISUN MACHINERY CO., LTD.

地址：佛山市顺德区乐从镇良教工商业开发区四非中座西1号
ADD: WEST 1#, ROW 4#, LIANGJIAO INDUSTRY, LECONG TOWN. FOSHAN 528315 GUANGDONG, CHINA
电话 TEL: +86-757-28974979
传真 FAX: +86-757-28974979
邮箱 E-MAIL: SALES@FSLISUN.COM
网站 WEB: HTTP://WWW.FSLISUN.COM



利长机电官方二维码

Professional Customized Quartz Line

石英石生产线专业定制



佛山市利长机电有限公司
FOSHAN LISUN MACHINERY CO., LTD.



HONESTY
诚实



HARMONY
和谐



EFFECIENCY
高效



INNOVATION
创新



www.fslisun.com

Company profile

企业简介

佛山市利长机电有限公司成立于2016年，是一家专业定制高质量的全自动石英石压板线的机电一体化企业,坐落于美丽的广东佛山市,凭借着多年的石英石机械设计制造能力和创新经验,佛山利长可以定制石英石设备技术方案,结合公司自研的新产品工艺,和点对点售后服务,为广大客户提供高于行业标准的石英石整线工程交锁服务。

佛山利长公司核心价值观: 为客户创造最大效益。

佛山利长公司核心文化: 诚实、和谐、高效、创新。

FOSHAN LISUN MACHINERY CO., LTD., founded in 2016, is a professional customized high quality automatic quartz slab pressing line of mechatronic integration company, is located in Foshan City, GuangDong Province, China, With many years of manufacturing & innovating experience, LISUN can customize the technical solutions of quartz stone equipment, combining the company's self-developed new product technology, and point-to-point after-sales services, providing whole quartz plant turn-key service to our customers that is higher than the industry standard.

LISUN'S VALUES: TO CREATE THE BEST VALUES FOR CLIENTS.

LISUN'S CULTURE: HONESTY, HARMONY, EFFECIENCY, INNOVATION.



▼ 配料系统 Raw Material Batching System



▼ 搅拌、布料系统 Material Mixing / Distribution System



▼ 布料、压制和固化系统 Distribution / Vibrating Press / Curing System



▼ 压制、固化系统 Vibrating Press / Curing System



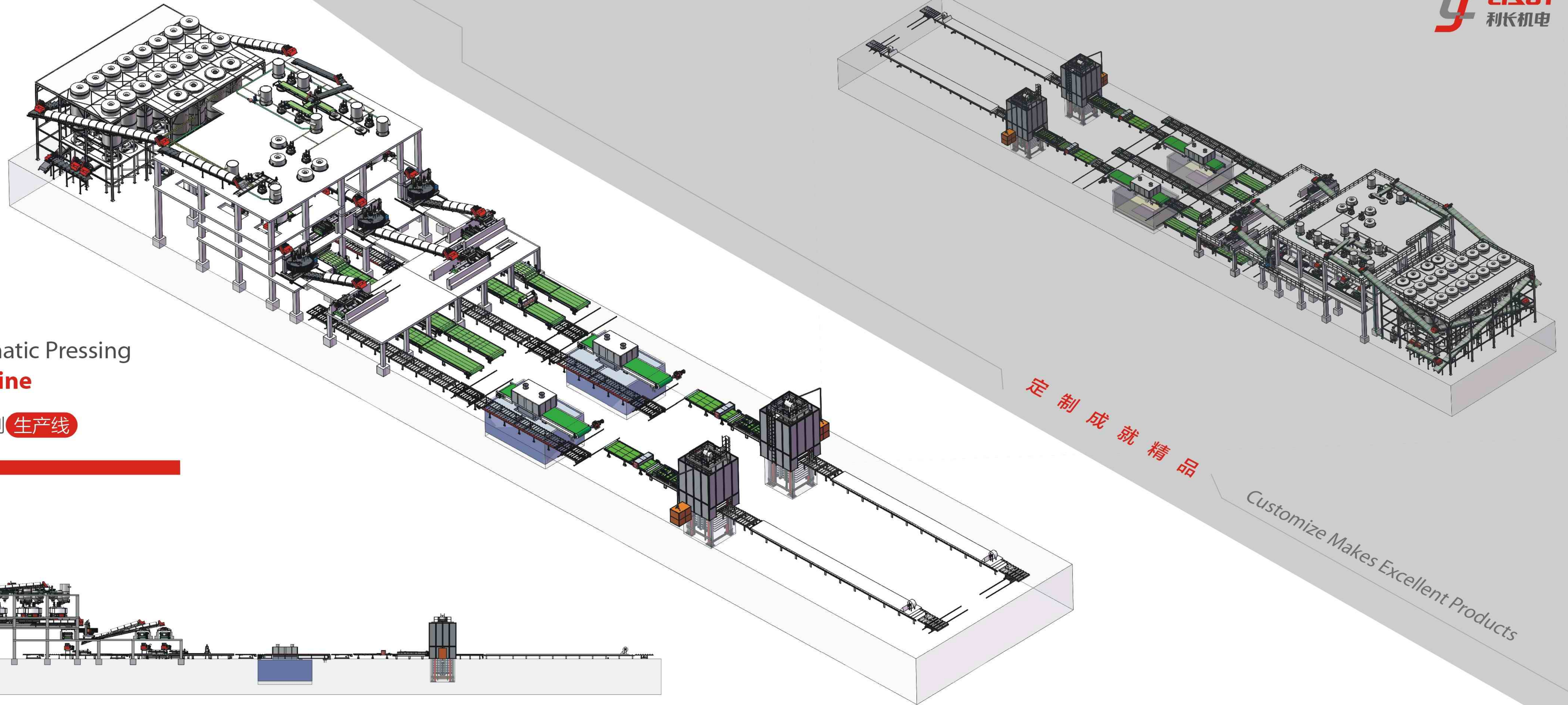
Professional In Manufacture & Design Of
**Automatic Quartz Slab
Production Line**

专业生产 and 设计自动石英石生产线

Technical Description

产量 Annual capacity	▶ 年产量20-25万平米 Annual capacity: 200,000-250,000 square meters
生产效率 Capacity	▶ 纯色板和鱼肚白8-10张板/小时, 其他颜色板材: 12-15张板/小时 8-10 slabs per hour for Pure color& Calacatta, 12-15 slabs per hour for other colors;
板材厚度 Slab Thickness	▶ 12-30mm
板材最大尺寸 Max. Pressing size	▶ 3550*2050mm
压板线整线尺寸 (米) Pressing line dimension	▶ L115米*W25米 (双线) L115*W25meters (for two lines)
压板车间行车高度 EOT height for pressing line workshop	▶ 配料和搅拌区域: 15米, 压机、固化和冷却区域8米 15meters (Batching & mixing area) 8meters (Vibration press, Vertical oven & Cooling system area)

整线装机功率 Whole pressing line install power	▶ 750KW
整线气压要求 Air compressor capacity	▶ 最大气压: 0.7MPa, 耗气量为5立方/分钟 Max pressure 7bar, air consumption: 5cbm/min;
收尘系统 (可选) Dust Collector (Optional)	▶ 工作区域: 配料区域和搅拌区域 Working Area: silo batching system and mixing platform;
除味系统 (可选) Smell Remove System(Optional)	▶ 工作区域: 搅拌区域, 布料区域和固化区域 Working Area: Mixing platform, distribution area and oven area;
空压机、干燥器、过滤器和储气罐及其连接辅件 Air compressor/dryer/filter/air tanks	▶ 需方提供 Customer provide
污水处理系统 Water Treatment Plant	▶ 需方提供 Customer provide



Quartz Automatic Pressing
Production Line

石英石全自动压制 **生产线**

定制成就精品

Customize Makes Excellent Products



自动配料系统
Automatic Raw Material Batching System

- 该系统包括骨料、粉料、树脂自动称量和输送，其中骨料通过皮带输送；粉料通过低压气压输送；树脂通过管道输送。
This system includes automatic weighing and conveying of grit, powder and resin. Among them, the grit is transported by belt, the powder is transported by injector, the resin is transported by pipeline.
- 整套系统包含有10套骨料大仓，共可以装载200吨骨料；2套粉料仓，共可以装载60吨粉料；2套树脂罐，共可以储存7吨树脂。
The whole system includes 10 sets of grit silos, which can load 200tons of grit in total; 2 sets of powder silos, a total of 60tons of powder can be loaded; 2 sets of resin tanks, which can store 7tons of resin in total.
- 配合收尘系统使用，该系统可以快速高效无尘运作，可以同时分别对6套搅拌机自动配料和送料。
With the use of DUST COLLECTION SYSTEM, the dust collection system can operate quickly and efficiently without dust, and can automatically mix and feed 6 sets of mixers at the same time.

搅拌和多色混合系统

Material Mixing/ Batching System

- 该系统由搅拌机、皮带输送机、双筒打散机、多色混料系统、水纹压料系统组成；
This system consists of mixer, belt conveyor, lump breaker, ring mixer and water veins rolling system.
- 可以满足单色料和多色料的自动搅拌、均化混合，并与自动配料系统和自动布料系统联动，从而实现配料--搅拌--布料的自动生产。
It can satisfy the automatic mixing for mono color and multi-color, homo-gerizing mix, and combine with automatic batching system & automatic distributing system, so as to realize the automatic production of batching, mixing and distributing.



Product Description

产品描述

石英石生产线专业定制 • Professional Customized Quartz Line



搅拌机 Mixer

- 该系统采用行星式机械结构，按搅拌量不同分为单盘行星式和双盘行星式搅拌，内衬贴有微晶石，便于清洗，防止物料污染；
This system adopts planetary mechanical structure, which can be divided into single disk planetary type & double disk planetary type according to different mixing volume. The inner lining is pasted with microcrystalline stone, which is easy to clean and prevent material pollution.
- 可以与自动配料系统联动，实现自动投料，自动搅拌，自动卸料。
It can be linked with automatic batching system to realize automatic distributing, automatic mixing and automatic unloading.

型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	搅拌量 Mixing Capacity	搅拌方式 Mixing Mode
LS-MIXER300	Φ 1600*H1900mm	16.5kw	100-300kgs	单盘行星式Single-disk planetary type
LS-MIXER500	Φ 1700*H1900mm	23.5kw	200-500 kgs	单盘行星式Single-disk planetary type
LS-MIXER800	Φ 1900*H2100mm	31.5kw	300-800 kgs	单盘行星式Single-disk planetary type
LS-MIXER1200	Φ 2300*H2300mm	56.5kw	500-1200 kgs	双盘行星式Double-disk planetary type
LS-MIXER1500	Φ 2400*H2500mm	76.5kw	500-1500 kgs	双盘行星式Double-disk planetary type
LS-MIXER2000	Φ 2800*H2900mm	91.5kw	800-2000 kgs	双盘行星式Double-disk planetary type

多色混料机 Ring Mixer

- 该系统用于对几种不同颜色物料均匀混合；
This system is used to mix several different color materials evenly.
- 混料盘内衬采用花岗岩材料，不会污染物料；
The inner lining is made of granite material, which will not pollute the material.
- 整机操作简单，运转高效，可以与搅拌机和双筒打散机联动，均匀投料，自动混合，自动卸料。
The whole machine has simple operation, high efficiency operation. It can be linked with mixer and lump breaker, homogenizing loading, automatic mixing & automatic unloading.



型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	搅拌量 Mixing Capacity	搅拌盘 Mixing Mode
LS-RM2200	Φ 2800*H2300mm	20.7kw	2000kgs	双盘 Double-arm
LS-RM2800	Φ 3200*H2600mm	24.7kw	2800kgs	双盘 Double-arm
LS-RM3200	Φ 4000*H2900mm	32.7kw	3500kgs	三盘 Three-arm



水纹压料机 Water Veins Rolling Machine

- 该设备通过滚筒垂直挤压物料，从而改变物料的纹理形状，形成水纹效果；
This system can change the slab veins and form the water veins effect through vertical extrusion of the mixed material by the roller.
- 通过与多色混料机联动，定量供料，定量压料，从而可以稳定高效地生产水纹效果物料。
Through the linkage with multi-color mixer, quantitative feed, quantitative press, thus can be stable and efficient production of water veins design.

型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	装料量 Loading Capacity	压料方式 Pressing Mode
LS-WTV300	L6000*W1300*H600mm	7.95kw	200kgs	双压辊 Double-roller
LS-WTV800	L6000*W1500*H800mm	10.95kw	400kgs	单压辊 Single-roller

双筒破碎机 Lump Breaker

- 该设备用于对单色料或混合料团打散；
The equipment is used to break up the mono-color material or mixed materials.
- 破碎滚筒采用花岗岩材料，不会污染物料；
The crushing roller adopts granite material, which will not pollute the material.
- 刮料装置保证在设备运行是不会堵料；
The scraping device ensures that the material will not be blocked during machine running.
- 整机清洁简单，运行高效，维护简易。
The whole machine is simple in cleaning, efficient in operation and easy in maintenance.



型号 Model	设备尺寸 Equipment Dimension	滚筒尺寸 Roller Dimension	总功率 Total Power	备注 Remark
LS-CRS55	L1600*W1200*H800mm	Φ 280*L800mm	11.55kw	含移动架 Including Trolley
LS-CRS75	L1700*W1200*H820mm	Φ 280*L1000mm	16.55kw	含移动架 Including Trolley

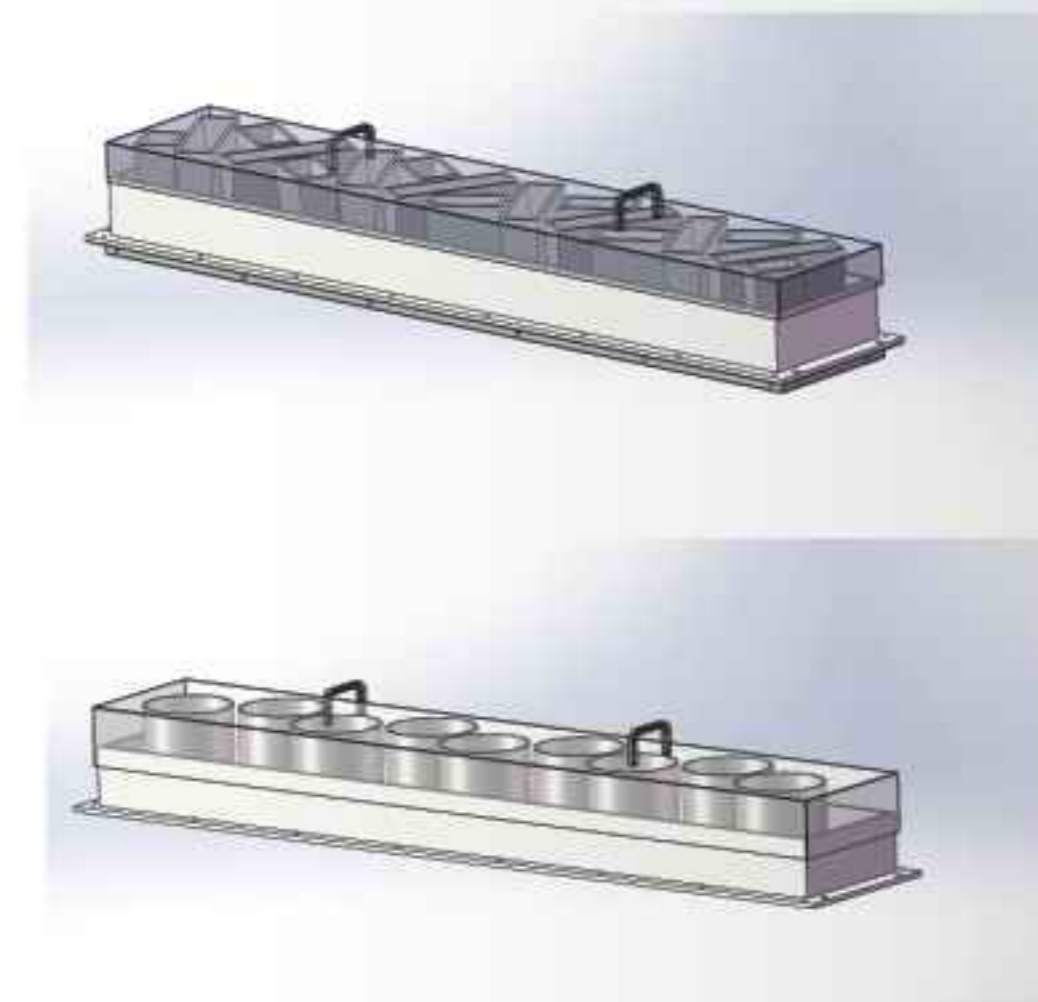
Product Description

产品描述



皮带式自动布料系统 Belt Type Automatic Distribution System

- 该系统的自称重存料装置、均化下料装置自选区域造纹理装置、移动式压料和布料装置组成。
The system is composed of auto-weighing with material storage device, a homogenizing and unloading device, a matrix veins device, & a mobile material pressing and feeding device.
- 整套系统称量精确，布料均匀，板面纹理丰富多变，布料速度快，清洁和转产简单；
The whole system has accurate weighing, uniform feeding, rich and changeable slab pattern, fast feed speed, simple cleaning and production conversion.
- 整套系统可以根据成品板材尺寸定做，为客户提供全新的差异化的板面工艺。
The whole system can be customized according to the finished slab size, providing customers with a new and differentiated slab surface process.



撒粉盒 DRY VEIN BOX

型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	布料方式 Feeding Mode	纹理装置 Veins Device	板材尺寸 Slab Size
LS-DST1650A	L8500*W2550*H2650mm	18.25kw	皮带下料 Belt Feeding	震动下粉 Vibrating Vein	3280*1680mm
LS-DST1650B	L8800*W2550*H2650mm	19.75kw	皮带下料 Belt Feeding	喷粉和喷浆 Spray Vein	3280*1680mm
LS-DST2050A	L9000*W3250*H2750mm	20.25kw	皮带下料 Belt Feeding	震动下粉 Vibrating Vein	3550*2050mm
LS-DST2050B	L9300*W3250*H2750mm	21.75kw	皮带下料 Belt Feeding	喷粉和喷浆 Spray Vein	3550*2050mm

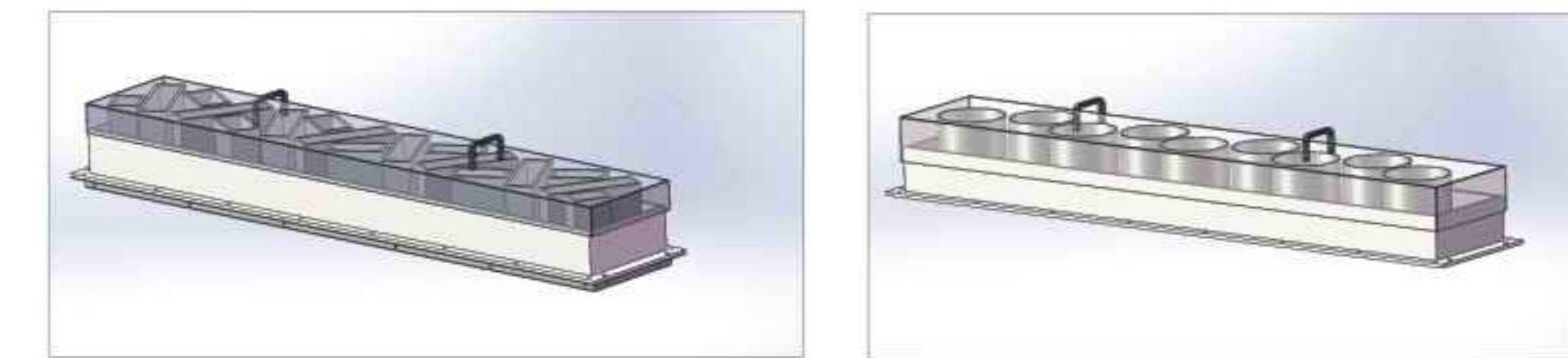
石英石生产线专业定制 • Professional Customized Quartz Line



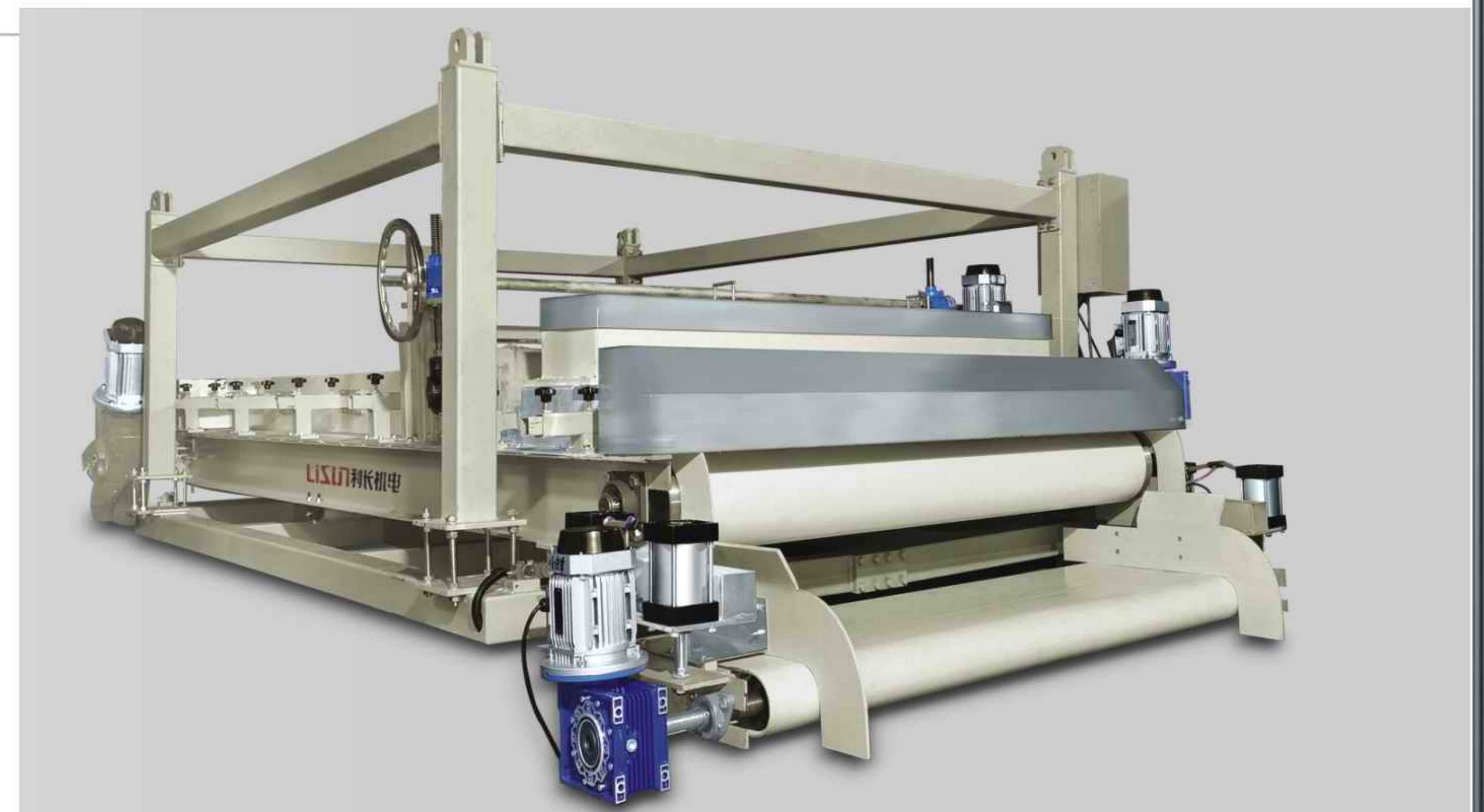
卡拉拉自动撒粉系统 Carrara Auto Spray System

- 卡拉拉自动撒粉系统，通过设定撒粉量和撒粉区域，再配合预压滚筒装置压料和自动布料，做到纹理粗细均匀的卡拉拉石材效果。
By setting the quantity of powder and the area of powder, and combining with the pre-pressing roller device and automatic distribution, this system can achieve the effect of uniform texture of Carrara stone

撒粉盒 DRY VEIN BOX



型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	撒粉方式 Spray Mode	色粉数量 Pigment Colors QTY.	板材尺寸 Slab Size
LS-KLL1650	L4500*W2200*H1500mm	12kw	色粉喷粉 Dry Vein Spray	2 Colors	3280*1680mm
LS-KLL2050	L4500*W2600*H1500mm	13.5kw	色粉喷粉 Dry Vein Spray	2 Colors	3550*2050mm



Product Description

产品描述

CNC自动喷淋系统 CNC Automatic Spray System

利长专利 • Lisun Patent

- 该系统采用利长自行开发的多轴联动控制系统，根据板材线条纹理在电脑上绘制出图纸，再导入到自研系统中，从而可以精确地对石英石补料任何区域喷粉或喷浆，从而实现与长纹卡拉拉天然石效果相似的人造石英石板面效果。
- 根据石英石板面的纹理要求，利长石英石自动喷淋系统可以实现自动喷粉工作模式或自动喷浆工作模式。
- 通过更换不同的刀头和设定不同喷粉量和喷浆量，实现石英石线条纹理粗细不一，连续线条纹理效果和间断线条纹理效果。

This system adopts the multi-axis linkage control system developed by LISUN itself, draws drawing on the computer according to the line veins of the slab, and then imports it into the self-developed system, so that it can accurately spray powder or spray liquid any area of quartz slab feeding. So as to achieve the effect of artificial quartz slab surface similar to the effect of long veins Carrara of natural stone.

According to the texture requirements of the quartz slab surface, the CNC AUTOMATIC SPRAY SYSTEM can realize the automatic powder spraying mode or the automatic liquid spraying mode.

By replacing different blade and setting different powder spraying volume and liquid spraying volume, the effect of quartz slab line texture with different thickness, continuous line texture effect and discontinuous line texture effect can be realized.



型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	喷淋方式 Spraying Method
LS-SP1	L5800*W2800*H1450mm	10kw	3轴单喷头 3 Axis cutter with single spray
LS-SP2	L6300*W2800*H1450mm	13kw	3轴双喷头 3 Axis cutter with doublespray
LS-SP4	L6500*W3100*H1450mm	17.5kw	4轴四喷头 4 Axis cutter with Four spray
LS-DSPY2	L7800*W2800*H1450mm	19kw	双4轴四喷头 Double 4 Axis cutter with Four spray

石英石生产线专业定制 • Professional Customized Quartz Line



CNC鱼肚白填料系统 CNC Gap Veins Feeding System

利长专利 • Lisun Patent

- 鱼肚白自动布料系统自动对鱼肚白底料铺料，或者人工对鱼肚白底料铺料后，需要对鱼肚白纹理料填料。
The body material of CALCUTTA SLAB is feeding by AUTOMATIC DISTRIBUTION SYSTEM OR by manpower, then filling the gap veins.
- 该系统采用利长自行开发的CNC控制系统，通过填料重量设定，配料填料格栅（利长专利）上留下的填料纹理，鱼肚白填料系统可以自动对格栅空隙区域填料。
This system adopts the CNC control system, developed by LISUN. By setting the filling material weight and reserved the gap veins area through the Calcutta frame (LISUN PATENT), this system can automatic fill material to the gap veins area.



型号 Model	设备尺寸 Equipment Dimension	总功率 Total Power	填料方式 Feeding Mode	板材尺寸 Slab Size
LS-GV1	L5400*W2800*H1900mm	7.05kw	3轴单色填料 3 Axis Feeding with single color	3280*1680mm
LS-GV2	L6100*W2800*H1900mm	7.75kw	双3轴双色填料 Double 3 Axis Feeding with two colors	3280*1680mm



压制系统 Vibration Press System

利长专利 • Lisun Patent

- 该系统由高频振动系统、液压系统、气动系统和真空系统的全自动联动控制组成；
This system consists of automatic linkage control of high frequency vibration system, hydraulic system, pneumatic system and vacuum system.
- 压板方式同时包括压板功能和纸压功能，纸压模式下不需要按压板厚度更换挡板。
The pressing mode have both mould pressing function & paper pressing function; The paper pressing function suitable for variety of slab thickness where the punch die no require to change.
- 震荡机构（压头）为铸件，同时采用高频振动电机（3600rpm/60hz），双罗茨防方式真空系统；可以实现高效高速稳定压板；
The vibration mechanism (Press Punch) is a casting, high frequency vibration motor (3600rpm/60HZ) and a vacuum system with double root pump are used to realize high efficiency, high-speed and stable pressing slab.
- 整套系统为全自动压制，含电机过载保护和强制停机保护，以保证整机的运行稳定性；
The whole system is fully automatic pressing, including motor overload protection and forced stop protection to ensure the stability of the whole machine.

型号 Model	设备尺寸 Equipment Dimension	电机功率 Motor Power	总功率 Total Power	加压方式 Pressure Mode	板材尺寸 Slab Size
LS-PRS1600	L11600*W2850*H1800mm	10kw*10nos.=100kw	216.5kw	气囊Air spring pressure	3280*1680mm
LS-PRS2000	L12200*W3330*H1800mm	7.2kw*20nos.=142kw	236.5kw	气囊+液压Air spring pressure + Hydraulic pressure	3550*2050mm



固化系统 Vertical Hardening Oven

- 该系统由固化炉主体、导热油循环加热系统、液压升降系统和推拉板夹纸推板装置组成；
This system is composed of the main body of hardening oven, the circulation heating system of the heat conducting oil, the hydraulic lifting system & the paper clamping and pushing device of the push-pull slab.
- 其中导热油循环加热系统可以根据板材工艺单独设定上下层板不同油温；导热油路特殊设计，炉体外层用保温棉隔热，保证了板材均匀加热，快速进出板。
The circulation heating system of the heat conducting oil can set different oil temperature of the upper and lower layers separately according to the slab process. The oil circuit of the heat conduction plate is specially designed, and the outer layer of the hardening oven is insulated with thermal insulation cotton to ensure that the slabs are heated evenly & inlet and outlet the slab quickly.
- 固化系统可以和压制系统联动，可以根据压机速度来定制固化层数。
This system can be linked with the pressing system, and the number of hardening oven layers can be customized according to the speed of the vibration press

型号 Model	设备尺寸 Equipment Dimension	加热箱功率 Heater Power	总功率 Total Power	加热板层数 Plate Layer	升降板定位方式 Plate Position Mode	板材尺寸 Slab Size
LS-OVEN01	L14500*W3300*H5000mm	72kw*2=144kw	165kw	10	编码器Encoder	3280*1680 mm
LS-OVEN02	L14500*W3300*H7500 mm	112 kw*2=224kw	243kw	16	编码器Encoder	3280*1680 mm
LS-OVEN03	L15200*W3900*H5000 mm	84 kw*2=168kw	191 kw	10	编码器Encoder	3550*2050 mm
LS-OVEN04	L15200*W3900*H7500 mm	124 kw*2=248kw	269 kw	16	编码器Encoder	3550*2050 mm

Product Description

产品描述

石英石生产线专业定制 • Professional Customized Quartz Line

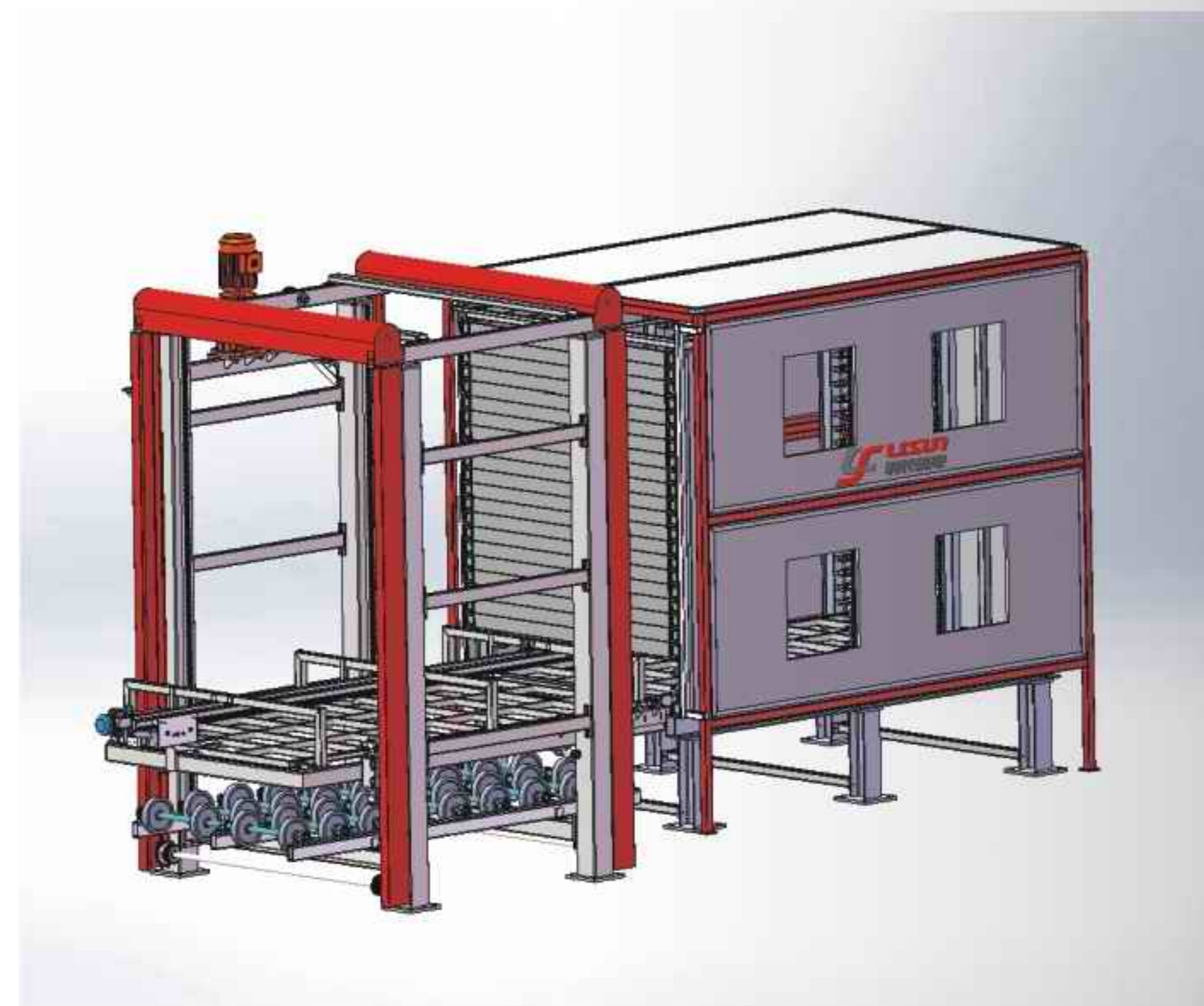


冷却系统 Cooling System

该系统采用立式链条升降风冷方式或隧道式风冷方式。
This system adopts vertical chain lifting with air cooling method OR tunnel air cooling method.

采用上下层送风和排风装置，配合固化炉进出板速度联动控制，从而实现消除板材变形内应力和快速出板。

Using the upper and lower layer air supply and exhaust devices, combined with the speed linkage control of the inlet and outlet slab of the hardening oven. So as to achieve the elimination of plate deformation internal stress and rapid out of the slab.



型号 Model	设备尺寸 Equipment Dimension	装机功率 Total Power	设备结构 Structure Of Equipment	板材尺寸 Slab Size
LS-CL01	L25000*W2250*H1100mm	15kw	隧道式Tunnel Type	3280*1680mm
LS-CL02	L8300*W3250*H4500mm	21kw	立式(24层) Vertical Type (24 layes)	3280*1680mm
LS-CL03	L27000*W2550*H1100mm	22kw	隧道式Tunnel Type	3550*2050mm
LS-CL04	L9100*W3850*H4500mm	30kw	立式(24层) Vertical Type (24 layes)	3550*2050mm

辅助设备 Auxiliary Equipment



▶ 样板压机 Lab Press



▶ 样板抛光机 Sample Polish Machine



▶ 色粉混合机 Dry Pigment Mixture (50-150kg)



▶ 实验室搅拌机 Lab Mixer



▶ 样板对剖机 Sample Split Machine



▶ 预混料机 Filler Mixture Drum



▶ 色粉混合机 Dry Pigment Mixture (500-1000kgs)



▶ 对辊机 Rolling Machine



▶ 样板倒角磨边机 Sample Chamfering & Edge Polishing Machine

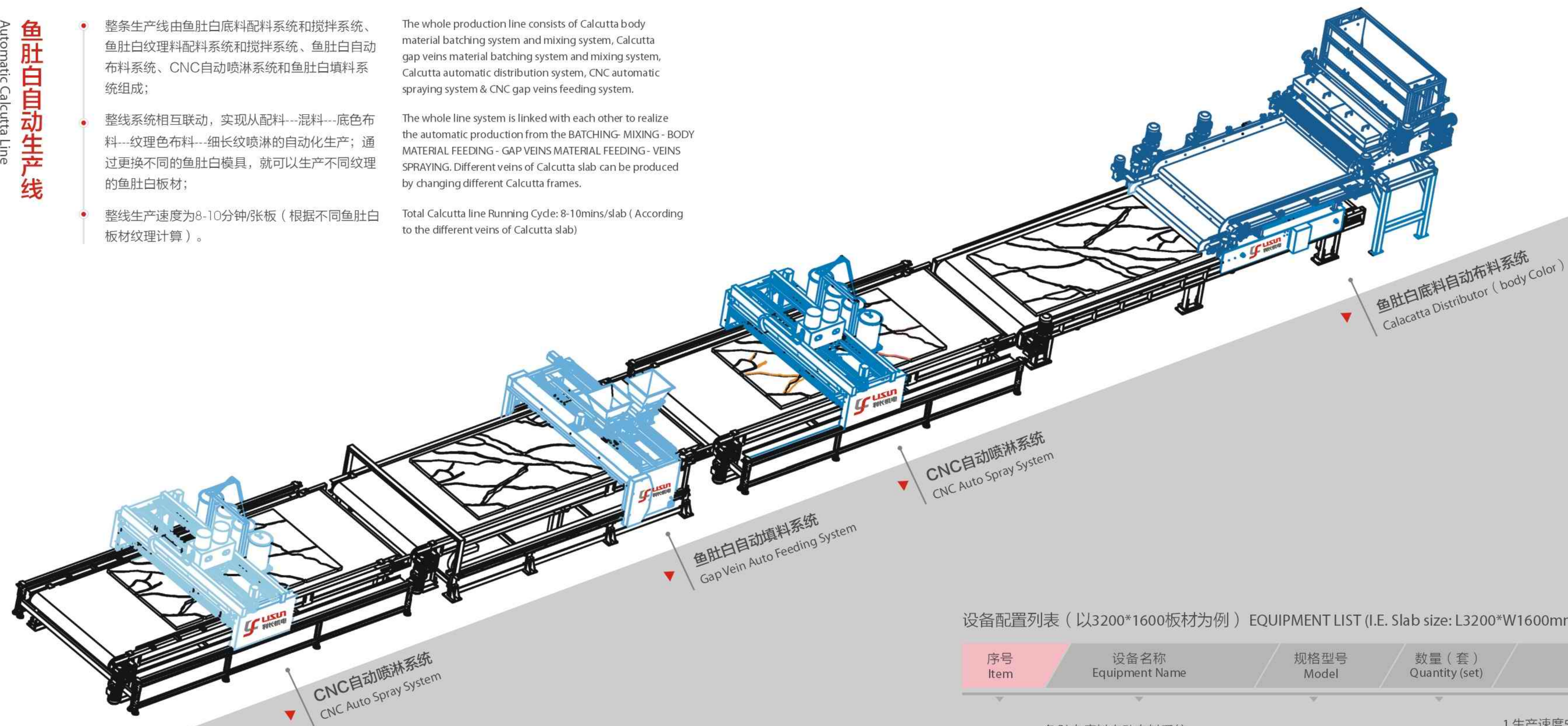
鱼肚白自动生产线
Automatic Calcutta Line

- 整条生产线由鱼肚白底料配料系统和搅拌系统、鱼肚白纹理料配料系统和搅拌系统、鱼肚白自动布料系统、CNC自动喷淋系统和鱼肚白填料系统组成;
- 整线系统相互联动, 实现从配料---混料---底色布料---纹理色布料---细长纹喷淋的自动化生产; 通过更换不同的鱼肚白模具, 就可以生产不同纹理的鱼肚白板材;
- 整线生产速度为8-10分钟/张板 (根据不同鱼肚白板材纹理计算)。

The whole production line consists of Calcutta body material batching system and mixing system, Calcutta gap veins material batching system and mixing system, Calcutta automatic distribution system, CNC automatic spraying system & CNC gap veins feeding system.

The whole line system is linked with each other to realize the automatic production from the BATCHING- MIXING - BODY MATERIAL FEEDING - GAP VEINS MATERIAL FEEDING - VEINS SPRAYING. Different veins of Calcutta slab can be produced by changing different Calcutta frames.

Total Calcutta line Running Cycle: 8-10mins/slab (According to the different veins of Calcutta slab)



设备配置列表 (以3200*1600板材为例) EQUIPMENT LIST (I.E. Slab size: L3200*W1600mm)

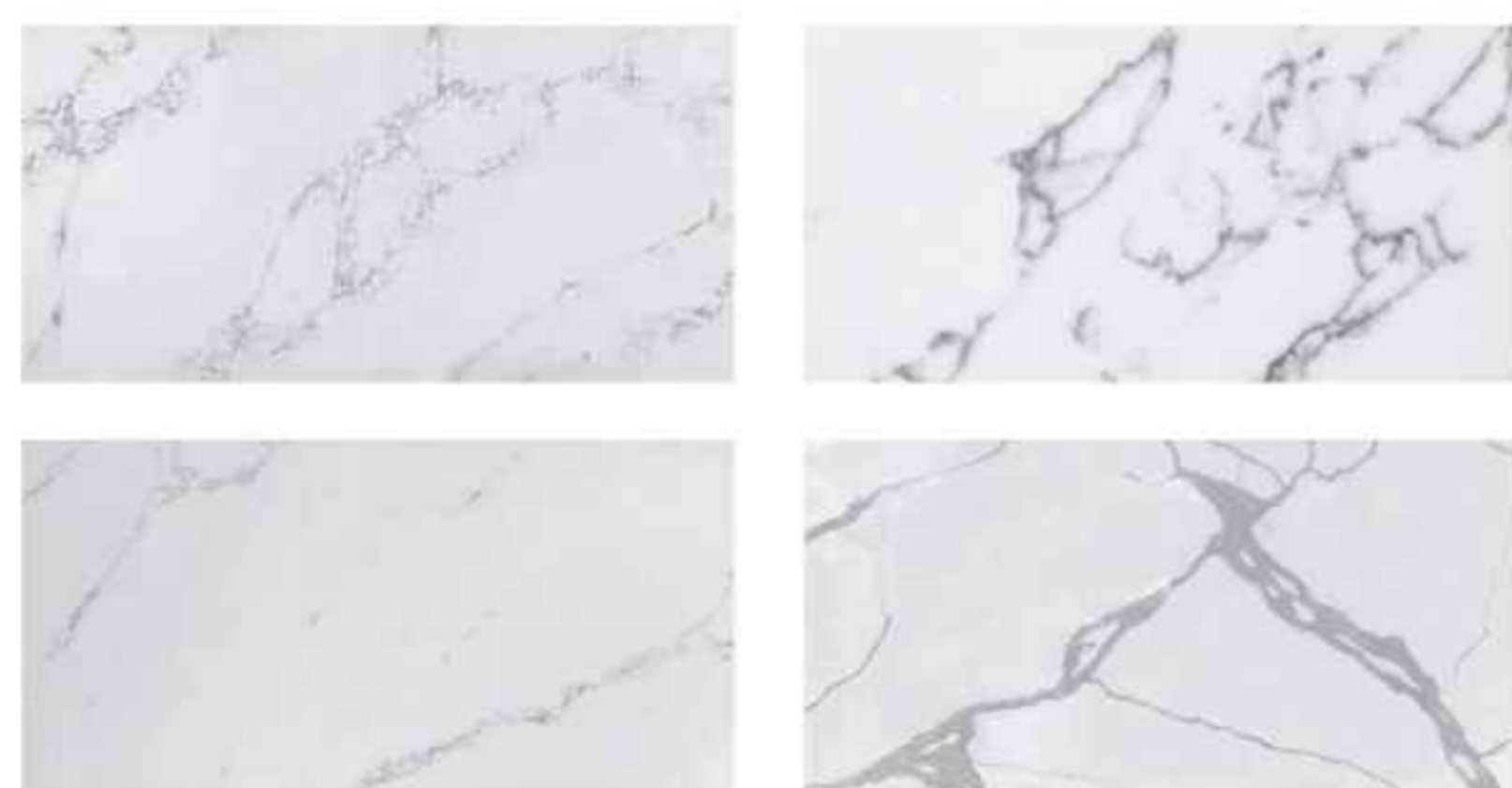
序号 Item	设备名称 Equipment Name	规格型号 Model	数量 (套) Quantity (set)	功能 Function
1	鱼肚白底料自动布料系统 Calcutta Distributor (Body Material)	LS-CLA1650	1	1.生产速度5分钟/张板 2.含卡拉撒粉模块 1. Working Speed: 5mins/slab 2. Including Cararra veins device
2	CNC自动喷淋系统 CNC Automatic Spray System	LS-SP4/1650	2	1. 双色喷浆和双色喷粉功能 2.含4把不同刀头 1. Including dry and liquid veins function; 2. Including four different type of cutter
3	鱼肚白填料系统 CNC Calcutta Gap Veins Feeding System	LS-GV2/650	1	1.生产速度8-10分钟/张板 2. 双色自动填料 1. Working Speed: 8-10mins/ slab, 2. Automatic filling with two colors

选配系统 (Option System)

- 底料自动配料和搅拌系统 / Automatic Batching And Mixing System For Body Material
- 纹理料自动配料和搅拌系统 / Automatic Batching And Mixing System For Gap Veins Material

石英石产品

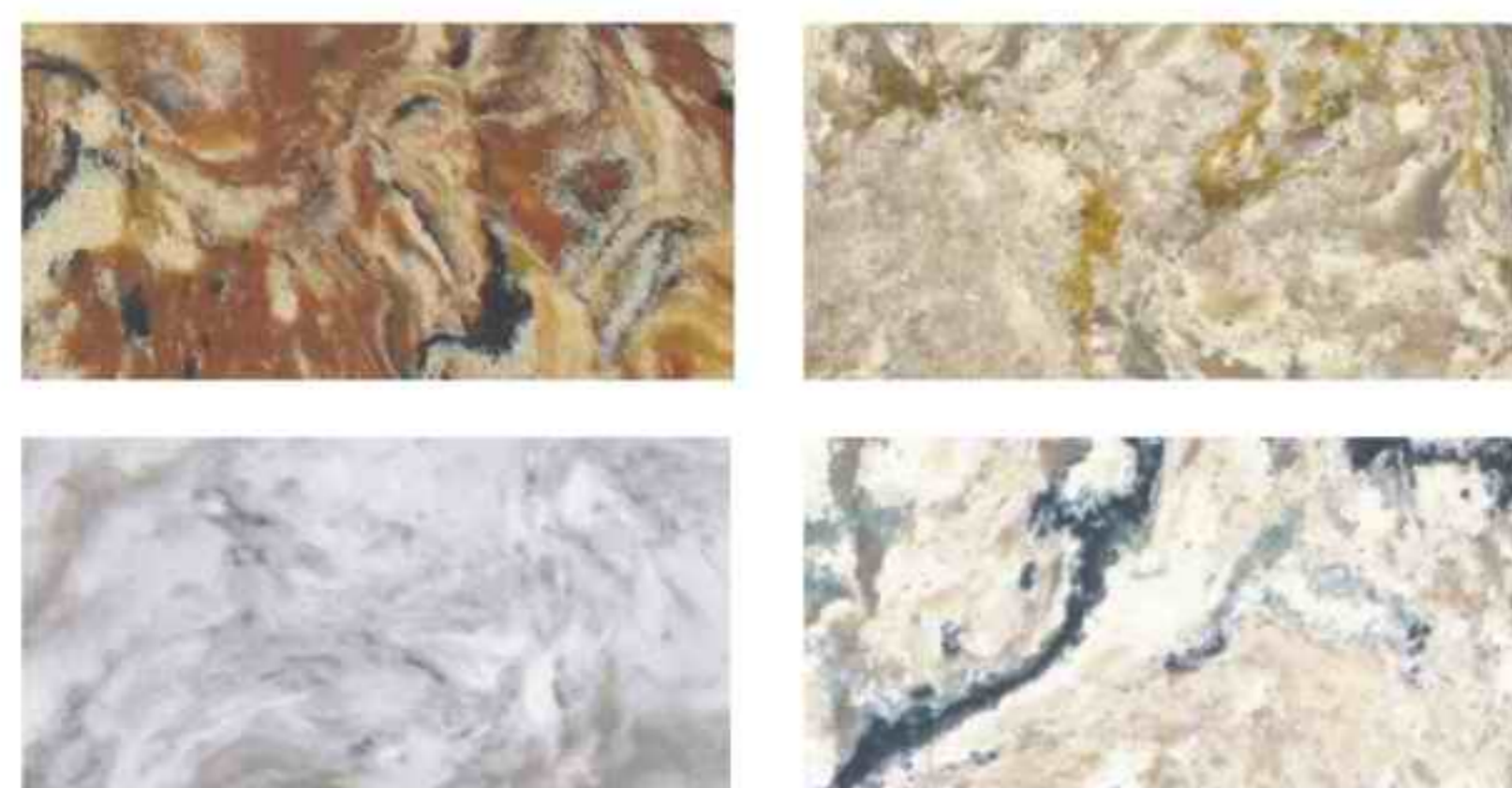
Quartz Product



卡拉拉系列
Cararra Series



卡拉卡塔系列
Calacatta Series



水纹系列
Water Vein Series



多色系列
Multi-color Series



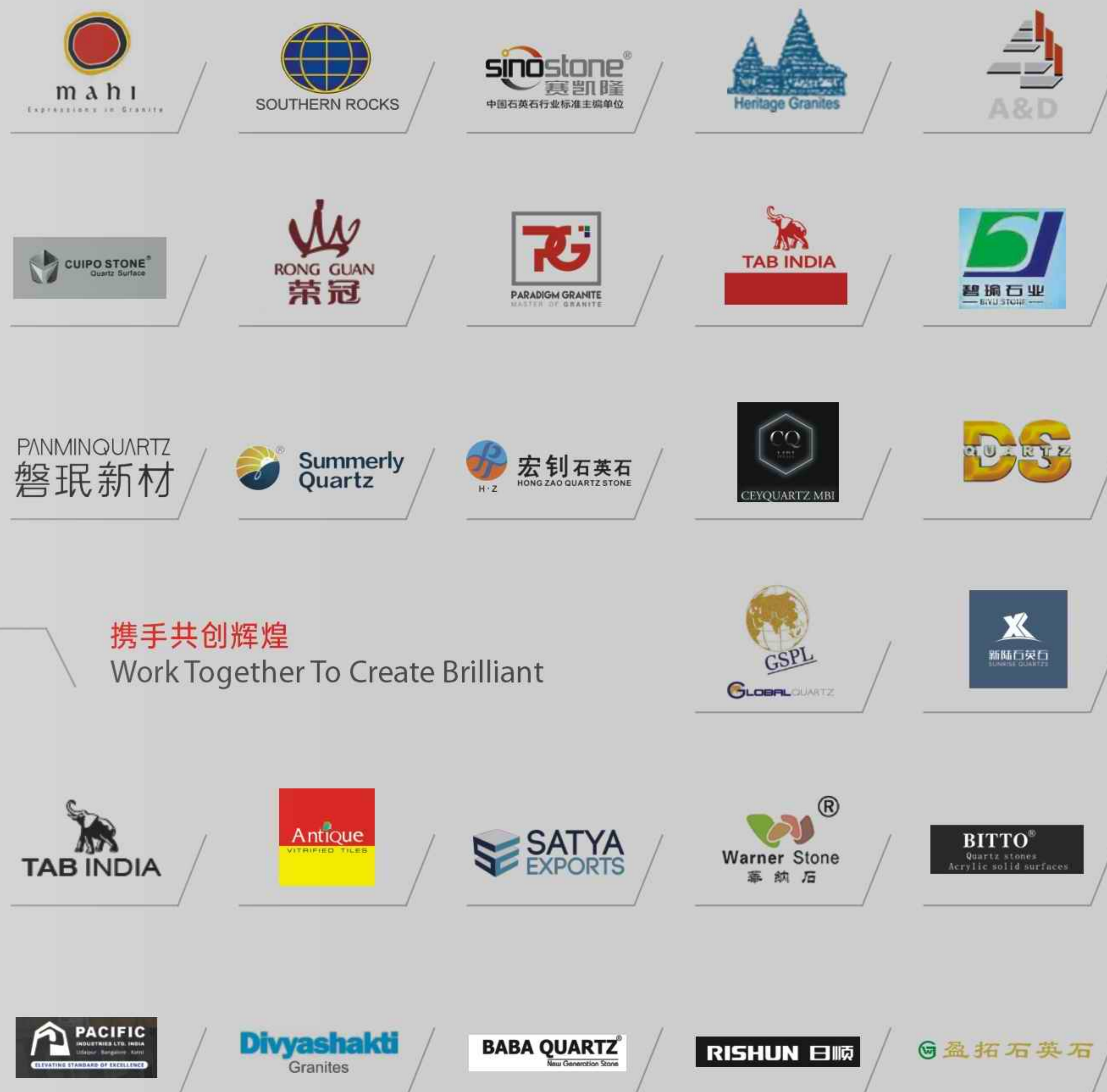
单色系列
Plain Color Series



大颗粒系列
Big Granules Series

合作伙伴 (部分名录)

Cooperative Partner



携手共创辉煌
Work Together To Create Brilliant

以上排名不分先后, 仅供参考!
The above rankings are in no particular order and are for reference only!
我们向本册使用了他们商标的客户表示深深的谢意!
We deeply thank our esteemed customers for the use of their logo!