

Wet Type Fish Feed Extruder

Complete Product Guide & Manual

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Floats 12 Hours+

Pellet 0.9–15mm

Boiler Steam

8 Models

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| What This Machine Is

The wet type fish feed extruder makes floating or sinking feed for fish, shrimp, eel and bullfrog, and also produces dog and cat pet food. Main raw materials include corn, soybean meal, rice bran and fish meal, with pellet diameter from 0.9 to 15 mm. It is built for medium-to-large feed mills and farms. The LLV series has eight models (LLV60–LLV200), from 0.18 to 5.0 t/h at 15–132 kW.

| Why It Gets Specified

Six reasons. Adjustable pellet size: change the die to change the size. High floatability: quality floating pellets hold on the water surface for over 12 hours without dissolving — less feed wasted. High cooking level: a conditioner fed continuously with hot steam by the boiler cooks the material thoroughly for better nutrition and absorption. Durability: core parts are vacuum-quenched with high machining precision and long service life. Sanitizing safety: high-temperature, high-pressure extrusion kills salmonella and other bacteria, making feed easy to digest. Easy operation: human-centered controls, simple to pick up.

| How It Works

Three stages:

- 1 Steam pre-conditioning**
Material enters the machine while an external boiler keeps feeding steam into the conditioner for high-temperature pre-cooking.
- 2 Extrusion puffing**
Fully cooked and mixed, the material enters the screw chamber where high temperature, pressure and shear cook and expand it further.
- 3 Forming and cutting**
Finally the material shapes through the extrusion die and a high-speed rotary cutter slices it into uniform pellets.

Two things to remember: conditioning is the foundation of 12-hour floating — keep the boiler steam supply steady, and stop production rather than run dry when steam fails; both floating and sinking feed grow fish

well, but floating pellets keep leftover feed from rotting on the bottom (less water pollution) and let you watch feeding intensity directly to adjust rations.

Specifications

Full spec for all eight LLV models:

Model	Capacity(t/h)	Main power(kW)	Feeding power(kW)	Screw dia. (mm)	Cutter power(kW)	Conditioning power(kW)
LLV60	0.18–0.20	15	0.4	60	0.4	0.37
LLV70	0.30–0.35	18.5	0.75	70	0.4	1.1–1.5
LLV80	0.40–0.45	22	0.75	80	1.5	1.5–2.2
LLV90	0.50–0.55	37	1.1	90	2.2	2.2–3.0
LLV120	0.7–0.8	55	1.1	120	2.2	2.2–3.0
LLV135	1.0–1.2	75	1.5	135	3.0	3.0–4.0
LLV160	1.8–2.0	90	2.2	155	3.0	4.0
LLV200	3.0–5.0	132	2.2	195	4.0	5.5

Capacity varies with feed type, moisture and die spec — reference ranges shown; a steam boiler feeding the conditioner is required, and changing the die adjusts pellet size within 0.9–15 mm.

Where It Gets Used

Medium/large aquatic feed plants; aquaculture farms (fish, shrimp, eel, bullfrog); pet food plants (dog and cat food). Raw materials: corn, soybean meal, rice bran and fish meal.

Installation and Commissioning

1. **Positioning** — level the machine and fix it down; confirm service space around the conditioner, control cabinet and screw system.
2. **Boiler and steam line** — fit a boiler rated for the machine and connect piping; conditioner steam flow must be controllable.
3. **Screw and die** — inspect the vacuum-quenched core parts; fit the die plate aperture for the target pellet size (0.9–15 mm).
4. **Electrical** — wire main motor, feeder motor and cutter motor; confirm phase sequence and rotation direction.
5. **No-load run** — jog, then run briefly; watch screw rotation, noise and whole-machine vibration.
6. **Load run** — preheat the conditioner with steam first; feed slowly and watch cooking, puffing and forming; tune feed rate, steam and cutter speed for target length and floating behavior, then ramp to rated capacity.

⚠ The discharge port is extremely hot — never stand directly in front of it; operators must wear heat-resistant gloves, and steam lines need insulation.

⚠️ Never reach into the feed port during operation; stop and lock out before clearing or die changes — wait for the screw to cool down first.

⚠️ On any abnormal running (noise, smell, smoke, jam), stop immediately for inspection; never run a damaged machine.

⚠️ The boiler is a pressure vessel — certified operators only, per procedure. Before stopping, stop feeding first and run the barrel empty so leftover material cannot cake.

Unstable steam shows up as uneven puffing — match boiler capacity to model output (the large LLV200 needs a correspondingly bigger boiler). Have the manufacturer's technician on site for the first load run.

Running and Maintenance

Core parts are vacuum-quenched for long life, but still check screw and barrel wear regularly — falling puffing level and output usually mean the clearance has grown. Check the die plate for worn apertures and blockage (clear plugs gently). Keep the high-speed rotary cutter sharp — uneven pellet length means dull blades first.

Tune conditioner steam to feed moisture and target cooking level; if floating time falls short, check the steam supply first. Purge the barrel before stopping or switching materials to prevent caking. Watch bearing temperature daily and lubricate on plan. Daily round: main motor current, whole-machine vibration and noise. Pick out sand and metal from raw material before it reaches the machine.