

规格表 Specifications

项 目	Lten	Unit	450JSell			550JSell			650JSell			750JSell			900JSell		
螺杆直径	Screw diameter	mm	70	80	90	70	80	94	80	90	105	90	100	110	90	100	110
螺杆长径比	Length/Diameter volume	L/D	24.1	21	18.6	24.1	21	18	23.6	21	18	22.6	20	18	22.6	20	18
理论注塑容积	Theoretical shot volume	cm³	1424	1860	2354	1486	1940	2679	2212	2799	3810	2990	3691	4467	2990	3691	4467
注塑量(PS)	Shot weight(PS)	g	1282	1674	2118	1337	1746	2411	1991	2519	3429	2691	3322	4020	2691	3322	4020
注塑量(PS)	Shot weight(PS)	oz	45.3	59.1	74.9	47	62	85	70.3	89	121.2	69.4	87.8	119.5	95	117	142
注塑压力	Injection pressure	Mpa	227	174	137	221	169	122	215	170	125	217	176	145	217	176	145
注塑速率	Injection rate	cm³/sec	366	479	606	377	493	681	536	678	924	604	745	902	604	745	902
注射速度	Injection speed	mm/s	95			98			107			95			95		
注塑行程	Injection stroke	mm	370			386			440			470			470		
螺杆最高转速	Max. screw speed	rpm	174			174			165			126			126		
塑化能力	Plasticizing capacity(PS)	g/s	76.3	100.3	113.6	77.3	100.3	133.7	99.9	121.2	183.3	74	92	124	74	92	124
射台拉力	Injection unit force	Ton	11.7			19.8			19.8			19.8			19.8		
射台行程	Carriage stroke	mm	530			580			600			650			700		
锁模力	Clamping force	Ton	450			550			650			750			900		
高压缸开模力	Opening force	Ton	47.5			55			64.7			64.7			84.5		
移模缸开模力	Opening force	Ton	13.47			13.47			17.59			17.59			22.27		
拉杆间距	Distance between tie-rods	mm	810x800			960x860			1040x910			1110x960			1180x1000		
开模行程	Clamping stroke	mm	1050-550			1200-650			1350-800			1400-900			1600-1000		
模板最大间距	Max.daylight	mm	1400			1550			1750			1850			2100		
容模量	Mould thickness range	mm	350-850			350-900			400-950			450-950			500-1100		
最小模具尺寸	Min. mould dimension	mm	540x530			640x580			700X600			740x640			800x680		
合模速度	Mould close speed	mm/s	1242			1242			1220			1210			1210		
开模速度	Mould open speed	mm/s	1192			1192			1361			1110			1110		
顶针力	Ejector force	Ton	13.5			13.5			13.5			21.5			21.5		
顶针行程	Ejector stroke	mm	250			250			250			300			300		
预计干周期	Dry cycle (Euromap 6)	S	3.9			4.4			4.8			5.2			5.7		
油泵	Hydraulic pump	L	286			286			396			451			451		
电动机	Electric motor	kW	37.7+23+11			37.7+23+11			46.1+37.7+11			56.5+37.7+11			56.5+37.7+11		
热电量	Electric heater	kW	24.64			25.79			32			48			48		
使用油量	Utilized oil quantity	L	800			800			1000			1200			1200		

■ 本公司保留更改产品规格的权利，恕不另行通知。
■ Reserve the right for any technical improvement without notice

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东华机械
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中小型伺服驱动两板式注塑机

Small and medium size Servo-driven Two-platen Injection Moulding Machine



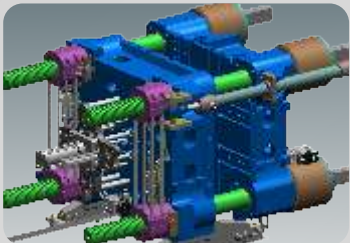
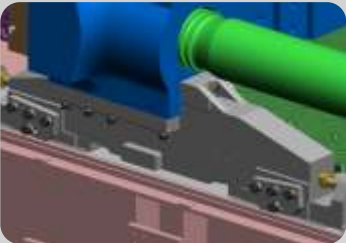
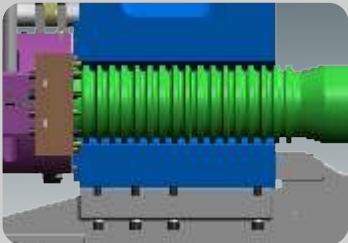
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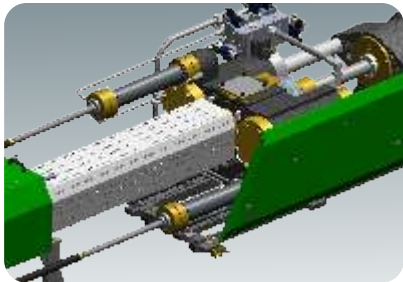
锁模单元 Clamping unit



- 先进的两板式锁模机构，结构紧凑，占地空间更小
- 安装于定模板的四个锁模油缸，保证模板在锁模动作时的均匀受力
- 锁模高压建压行程短，起压迅速，锁模力与系统压力成正比，线性好；压力传感器实时监控，锁模力重复精度高
 - 拉杆与动模板零摩擦，使用寿命更长，对角式布局的两个快速油缸大大提升开合模速度
 - 超长的动模板支撑滑脚，保证模板在使用沉重模具时的精度，提升模具的使用寿命
 - 同步式拉杆抱闸装置，抱闸油缸具备缓冲功能，抱闸精确，无冲击
- 采用人性化的无上梁挡门设计，可贴近机器操作，方便拿取制品
- The advanced two-platen clamping unit has compact structure and less occupation area
- The clamping cylinder installed on the fixed half ensures the template uniformly forced in clamping action
 - The clamping high-pressure cylinder stroke is short, and the speed of rising pressure is quick. The clamping force is proportional to the system pressure, which has good linearity. Real-time monitoring with pressure sensor, the repeatability of clamping force is very high
 - There is no friction between puller and movable half so that the service life is longer. And the diagonal layout of two hydraulic cylinders improves the speed of opening and closing mould
- When using heavy mould, the long slipper can ensure the accuracy of template so that enhance the service life of mould
- The puller adopts a synchronous brake device. And the brake cylinder with buffer function makes the action more accurate, which can't generate hydraulic shock
- The humanized design of no upper beam safety door design and can be close to the machine operation, and convenient to take products

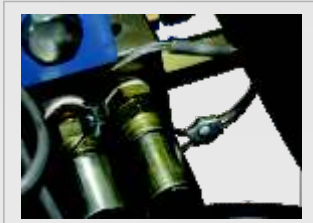
注射单元 Injection Unit

- 对角式双射移油缸布局，射台对中性更好，整体射台工作平稳
- The diagonal layout of injection cylinder makes the overall injection unit more stable



液压单元 Hydraulic unit

- 高性能伺服系统，集成式油路设计，输出效率高，动作响应迅速，有效节能，平稳、降噪
- 液压、电气双重安全保护，符合注塑机安全标准及节能要求
- It features with high-performance servo system, integrated oil circuit design, high efficiency output, fast response, energy-saving, stable and noise-reduction
- Double safety protection of hydraulic and electric is in line with the safety standards and energy-saving requirements of injection moulding machine



控制单元 Control unit

- 采用欧洲进口贝加莱专业注塑机控制系统
- European imported B&R professionally control system for injection moulding machine

