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星源塑机



欧洲质量安全认证



# XING YUAN MACHINE

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# ABOUT US

SINCE 1998 铭求质量, 竭诚服务  
MING SEEKS QUALITY AND WHOLEHEARTED SERVICE

宁波市明广伟业机械制造有限公司创建于1998年, 位于中国浙江省宁波市, 北连杭州湾跨海大桥, 东临宁波港, 交通十分便利。公司占地面积三万多平方米;拥有大、中、小型 设备100多台;现有员工150多名。企业通过了ISO9001-2008和出口CE认证。

公司专业制造星源牌注塑成型机(50-1500吨)。产品销售遍布全国, 远销世界各地。

我们一直以客户需求, 优质高效, 不断创新为目标。优质的售后服务是我们对用户的承诺。真诚希望与广大海内外客户建立良好的合作关系并共同发展。

公司宗旨: “铭求质量, 竭诚服务”。

Ningbo Mingguang Weiye Machinery Manufacturing Co., Ltd., founded in 1998, is located in Ningbo, Zhejiang Province, China. It is connected to Hangzhou Bay sea crossing bridge in the north and Ningbo port in the East. The company covers an area of more than 30000 square meters; It has more than 100 large, medium and small equipment; There are more than 150 employees. The enterprise has passed ISO9001-2008 and export CE certification.

The company specializes in manufacturing Xingyuan brand injection molding machine (50-1500 tons). The products are sold all over the country and all over the world.

We always aim at customer demand, high quality, high efficiency and continuous innovation. High quality after-sales service is our commitment to users. We sincerely hope to establish good cooperative relations and common development with customers at home and abroad.

Company tenet: "Ming seeks quality and wholehearted service".



**1998**

公司创建于1998年

**100+**

拥有大、中、小型设备100多台

**30000+**

公司占地面积三万多平方米

**150+**

现有员工150多名

# XY系列热固性注塑机

XY SERIES THERMOSETTING INJECTION MOLDING MACHINE

此系列注塑机采用复合材料的模具隔热装置，专用热煤油内循环料筒，配有专业设计的热固性塑料的螺杆组件，适用于加工各种热固性塑料。

This series of injection molding machines adopt composite mold insulation device, special hot kerosene inner circulation cylinder, and are equipped with professionally designed screw components of thermosetting plastics, which are suitable for processing various thermosetting plastics.

## 1 超宽模板设计, 更大容模范围

SUPER WIDE TEMPLATE DESIGN, LARGER MODEL CIRCUMFERENCE

大容量宽模板设计最大限度的满足了客户对模具的选择范围。

Large-capacity wide platen designed to meet the customer selection scope

## 2 超强精度, 超长寿命

SUPER PRECISION AND LONG SERVICE LIFE

优化设计的肘杆式高速锁模结构, 关节处低压应力, 确保了机器的超强精度与超长寿命。

Optimized elbow bar type high-speed mold locking structure, low pressure at joints. The stress ensures the super precision and super life of the machine.

## 3 高端控制器

ADVANCED CONTROLLER

采用高性能全电脑专用控制器, 大视窗, 彩色显示屏, 功能齐全。

High-performance computers is used for the entire controller, big display, color display, full-featured.

## 4 制品输送便利

EASILY TRANSFER

多方位塑料制品取出, 有效利用设备空间, 适用于多种输送设备的安置。

Multi-directional plastic products out, effective use of equipment space, suitable for a variety of conveying equipment placement.



## 5 油脂系统集中润滑

OIL SYSTEM

高性能油脂集中润滑, 运动磨损急剧下降, 长期保持模具的定位精度。

High-performance lubricating oil, decline the wear sharply, keep longterm positioning accuracy of the mold

## 6 工作环境清洁化

WORKING ENVIRONMENT

移动式废油清洁托盘, 使合模区废油清洁十分简便。

Mobile waste oil clean tray, so that the waste oil clean platen area is very simple

## 7 高精度温度控制

HIGH-PRECISION TEMPERATURE CONTROL

自动适应料筒温度精度稳定控制。

Self-adaptive barrel temperature accuracy and stability control.

## 8 中子/绞牙控制

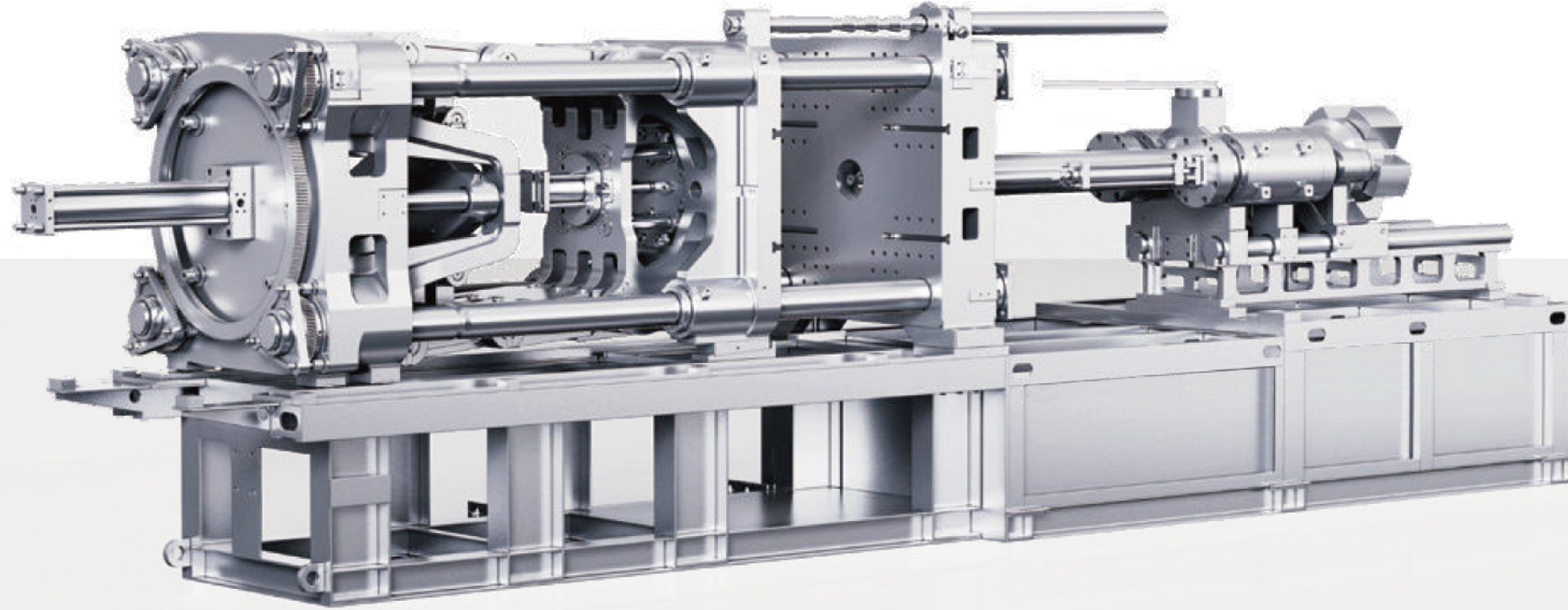
NEUTRON/CUTTER CONTROL

灵活的中子编程控制, 独立的液压泵站提供动力

Flexible neutron programming control, powered by independent hydraulic pump station.

# XY系列注塑机配置

XY SERIES INJECTION MOLDING MACHINE CONFIGURATION



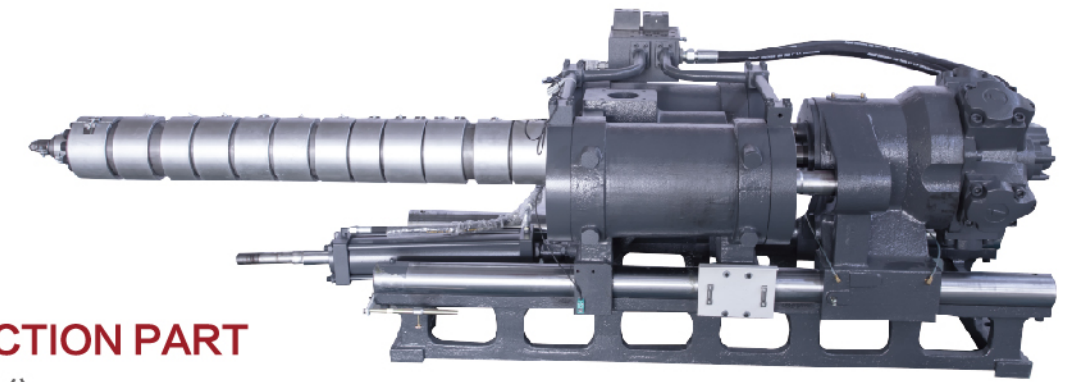
## INJECTION PART

注射部分

双导柱支承、双缸平衡注射，无级高扭矩液压马达直接驱动螺杆熔胶装置，力封闭型座进装置，优质氮化合金钢螺杆及料筒，表面双金属处理延长寿命、可供A、B、C三种直径螺杆，配合多种专用注射装置，确保各种所料的注射成型。

Double guide pillar support, double cylinder balanced injection, stepless high torque hydraulic motor direct drive screw glue melting device, force-enclosed seating device, high-quality nitrided alloy steel screw and barrel, surface bimetal treatment to extend life, available for A, B, C three diameter screws, with a variety of special injection devices to ensure the injection molding of various materials.

**模板刚性能强、运行平稳**  
Strong rigidity of the template and stable operation

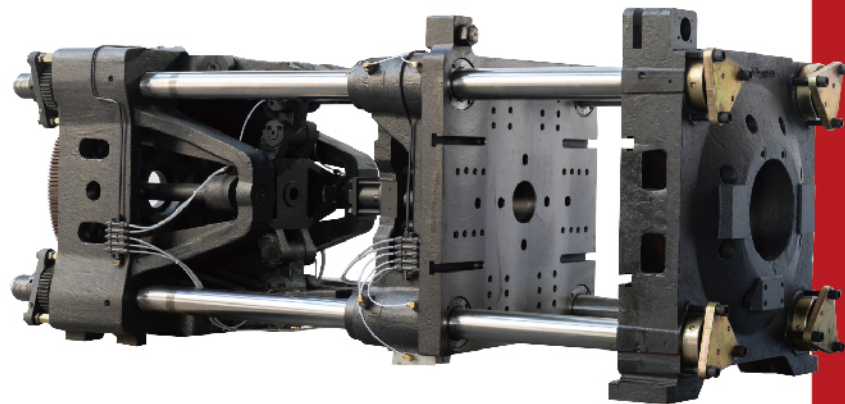


## CLAMPING PART

合模部分

斜排列五支点肘式机构，计算机参数优化设计，模板经过有限元分析设计，采用箱式支架模板连体结构，采用机械可调节式活动模板支承，确保合模部件的刚性及使用寿命。

Slant arrangement of five-pivot toggle typed mechanism, computer parameter optimized design. Based on the finite element analytic design The mold plate adopts box typed, and integrated structure of support frame and mold plate. Machine of some types are clip plate integrated and adopt mechanically adjustable and moveable plate support to ensure the rigidity and service life of the mould-clamping unit.

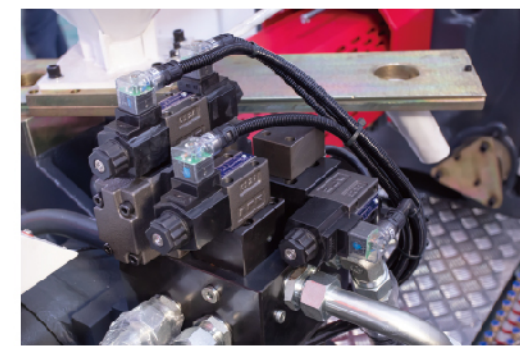


## HYDRAULIC PART

液压部分

采用进口名牌液压元件，差动高速合模装置，注射多级控制，系统采用压力流量比例控制，预留标准抽芯装置，大型机配备逻辑插装阀系统，确保机器动作达到最佳状态。

With adoption of imported famous brand hydraulic components differential high-speed mold clamping device, multilevel injection control and the system has employed pressure-flow ratio control with reservation of standard core puller. Large machines are fitted with logic cartridge valve system, which has secured the optimized status of machine actions.



## ELECTRIC UNIT

电气部件

采用进口塑机专用电脑，CPU 分工控制处理，多组模具成型资料储存功能，多点 PID 料温控制、注射、预塑、开合模动作采用高精度电子尺控制，提高控制系统响应速度及稳定性。

With adoption of imported computer special for injection molding machines, CPU controlled divided process, multigroup mould forming data storage function, multi-point PID material temperature control, injection, pre-molding and mold clamping and unclamping actions are controlled by high-precision electronic ruler to improve the response speed and stability of the control system.



# XY系列伺服节能注塑机

XY SERIES SERVO ENERGY SAVING INJECTION MOLDING MACHINE



## 伺服节能型注塑机的优点

ADVANTAGES OF THE SERVO ENERGY SAVING INJECTION MOLDING MACHINE

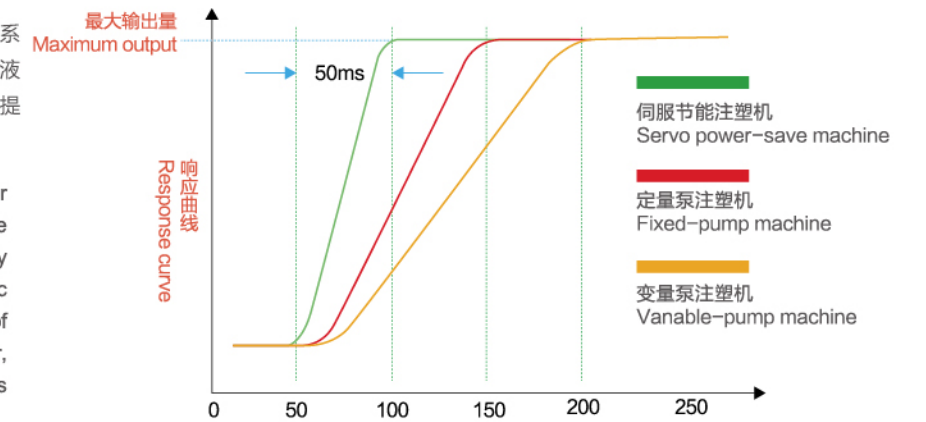
- 伺服控制，彻底消除高压节流，比异步电机+定量泵节电50%-80%，比异步电机+变量泵节电30%-50%。
- 响应迅捷，0-100%升、降速时间<0.1秒，0-100%压力变化最快可达30ms，提高生产效率。
- 控制精确，重复精度误差是0.1%，制品精密。
- 高过载能力强，伺服的力矩过载倍数≥200%。
- 状态转换灵活：速度、力矩控制灵活切换，平滑。
- 降低液压油温，减少冷却水的用量30%以上，某些场合甚至完全不需水冷。
- 减轻开、锁模冲击，延长液压油泵，机械和模具使用寿命。
- 降低噪音、改善工作环境。
- Servo control, eliminate high pressure throttle, power saving 50%-80% than asynchronous motor + quantitative pump.
- Power saving 30% -50% compared to asynchronous motor + variable pump.
- Quick response, 0-100% liter, speed of <0.1 sec, 0-100% pressure change The fastest up to 30ms, improve production efficiency.
- The precision of control is accurate, the error of repetition precision is 0.1%, and the product is precise.
- High overload capacity, servo torque overload is greater than or equal to 200%.
- State conversion is flexible: speed, torque control flexible switching, smooth.
- Reduce the temperature of hydraulic oil and reduce the amount of cooling water by more than 30%.
- Some occasions do not even need water cooling.
- Reduce the impact of open and lock mold, prolong hydraulic oil pump, mechanical and mold service life.
- Reduce noise and improve working environment.

## 伺服电机驱动系统

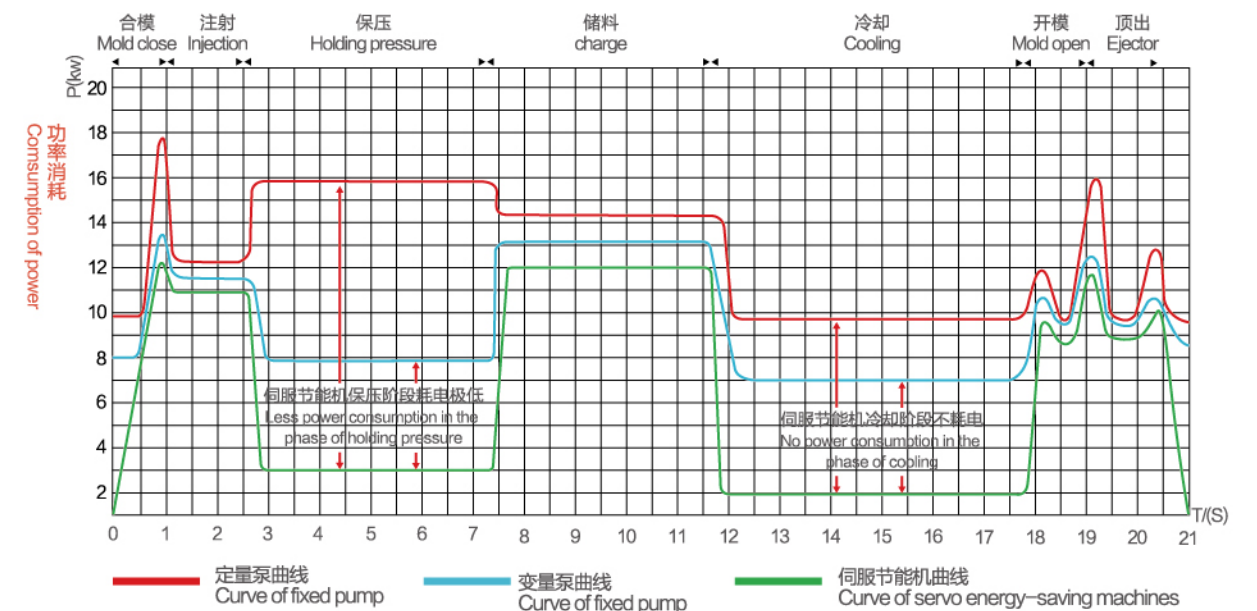
Servo motor drive system

由于采用高响应伺服电机与内啮合齿轮泵动力系统，注塑机达到最大输出量仅需0.05s，相比传统液压注塑机响应速度明显加快，有效缩短周期，提高生产效率。

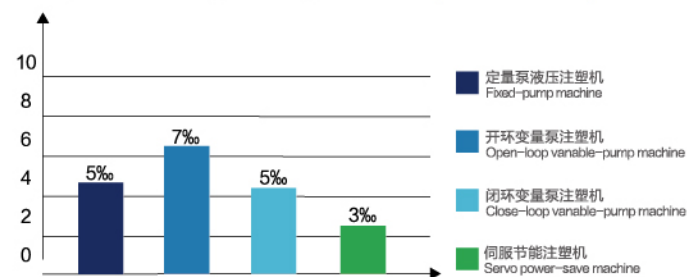
Due to the adoption of high response servo motor and internal gear pump power system, the maximum output of the injection machine is only 0.05s. Compared with the traditional hydraulic injection molding machine, the response speed of the injection molding machine is obviously faster, which effectively shortens the cycle and improves the production efficiency.



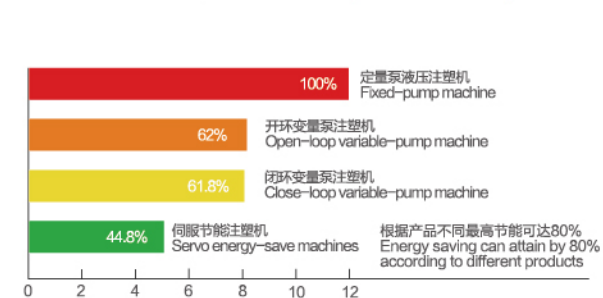
## CURVE OF ENERGY-SAVING MACHINES 伺服机曲线



## Comparison of injection precision 注射精度比较



## Power consumption/hour 耗电量/小时



从上图可以看出输出功率随负载变化而时刻调整，避免了对能量的浪费，保压阶段伺服电机降低转速，耗能极低，尤其是在冷却阶段，电机不需工作，耗电为0。根据产品成型工艺不同，伺服节能注塑机相比传统注塑机可节能用电20-80%，根据上面的数据，在空闲时间只占了总周期四分之一的情况下，其节能效果已经非常明显。让您能真正体验到节电带来的效益。

From the above picture, we can see that the output power is adjusted at any time with the load changing, avoiding the waste of energy. In the stage of holding pressure, the servo motor reduces the rotational speed and the energy consumption is very low. Especially in the cooling stage, the motor does not need to work, and the power consumption is 0. According to the different molding process, servo energy saving injection molding machine can save energy and power 20-80% compared with the traditional injection molding machine. According to the above data, when idle time occupies only 1/4 of the total cycle, the energy saving effect is very obvious. Let you really experience the benefits of electricity saving.

# XY-I 系列技术参数 | SPECIFICATION TABLE

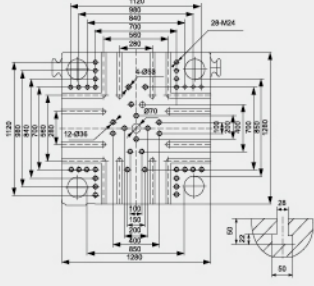
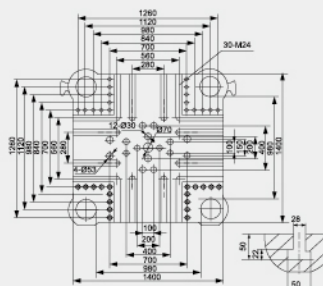
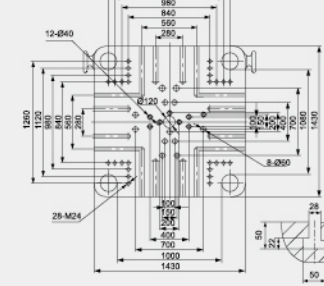
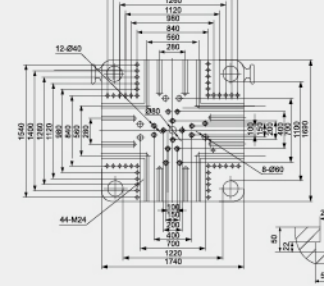
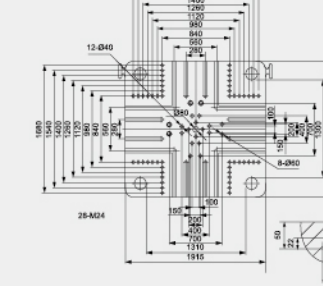
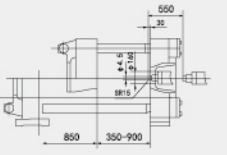
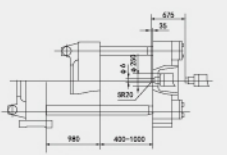
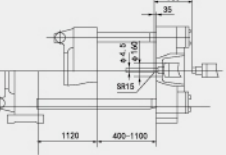
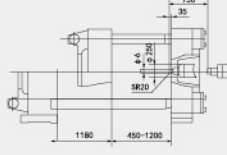
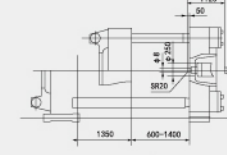
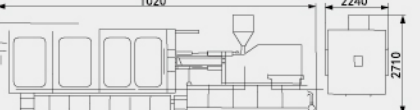
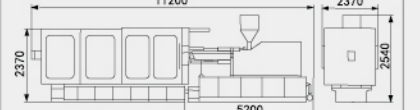
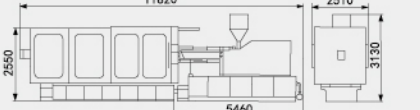
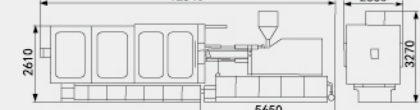
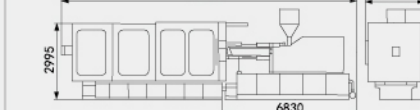
规格	SPECIFICATION	CN	XY400		XY500		XY700		XY1000	
			A	B	A	B	A	B	A	B
注射装置	INJECTION UNIT									
螺杆直径	SCREW DIAMETER	mm	26	28	28	30	32	34	32	35
螺杆长径比	SCREW L/D RATIO	L/D	20	18.6	20	18.7	20	18.8	22	20.1
理论注射容积	SHOT VOLUME(THEORETICAL)	cm <sup>3</sup>	50	58	70	80	104	118	133	158
注射重量	INJECTION WEIGHT	g	46	53	64	73	95	107	121	144
注射速率	INJECTION RATE	g/s	40	50	50	60	80	90	81	97
注射压力	INJECTION PRESSURE	Mpa	189	163	211	184	203	180	203	170
螺杆转速	SCREW SPEED	rpm	0-200		0-200		0-200		240	
合模装置	CLAMPING UNIT									
合模力	CLAMPING FORCE	KN	400		500		700		1000	
移模行程	OPEN STROKE	mm	235		250		280		320	
拉杆内间距	SPACE BETWEEN TIE-BARS	mm	260 × 240		290 × 270		320 × 300		360 × 360	
最大模厚	MAX.MOULD HEIGHT	mm	280		320		350		350	
最小模厚	MIN.MOULD HEIGHT	mm	100		120		120		150	
顶出行程	EJECTOR STROKE	mm	55		65		80		90	
顶出力	EJECTOR FORCE	KN	22		22		28		30	
其他	OTHERS									
最大油泵压力	MAX.PUMP PRESSURE	Mpa	14		14		14		16	
油泵马达功率	PUMP MOTOR POWER	KW	7.5		7.5		11		15	
电热功率	HEATING POWER	KW	3.8		4.1		6.1		7.55	
外形尺寸 (长×宽×高)	MACHINE DIMENSIONS(LxWxH)	m	2.95X0.9X1.43		3.1X0.95X1.55		3.3X1.0X1.5		3.81 × 1.19 × 1.79	
油箱容积	OILTANK CUBAGE	L	90		100		120		180	
机器重量(约)	MACHINWEIGHT(APPROXIMATE)	t	1.3		1.5		2.4		2.9	
模板正面尺寸 PLATEN DIMENSIONS										
模板侧面尺寸 Mold Space Dimension										
外型尺寸 Machine Dimension										



# XY-I 系列技术参数 | SPECIFICATION TABLE

规格	SPECIFICATION	CN	XY2700			XY3000			XY3600		XY4000		XY5200		
			A	B	C	A	B	C	A	B	A	B	A	B	C
注射装置 INJECTION UNIT															
螺杆直径	SCREW DIAMETER	mm	50	55	60	55	60	65	67	70	70	75	75	80	85
螺杆长径比	SCREW LID RATIO	L/D	24.2	22	20.2	24	22	20.3	23	22	22	20.5	23.7	22	20.7
理论注射容量	SHOT VOLUME (THEORETICAL)	cm	455	550	655	676	805	945	1181	1289	1428	1639	1727	1965	2218
注射重量	INJECTION WEIGHT	g	416	503	600	615	732	859	1076	1175	1258	1539	1560	1788	2018
注射速率	INJECTION RATE	g/s	187	227	270	223.5	266	312.2	337	368	357	406	386	442	499
注射压力	INJECTION PRESSURE	Mpa	205	169	142	200	168	143	183	168	180	156	191	168	148
螺杆转速	SCREW SPEED	rpm		210			220		195		150			175	
合模装置 CLAMPING UNIT															
合模力	CLAMPING FORCE	KN		2700			3000		3600		4000			5200	
移模行程	OPEN STROKE	mm		540			590		660		700			760	
拉杆内间距	SPACE BETWEEN TIE-BARS	mm		580 × 580			630 × 630		680 × 680		730 × 730			820 × 800	
最大模厚	MAX. MOULD HEIGHT	mm		550			630		720		780			810	
最小模厚	MIN. MOULD HEIGHT	mm		200			200		250		280			330	
顶出行程	EJECTOR STROKE	mm		450			150		160		160			240	
顶出力	EJECTOR FORCE	KN		70			70		70		126			100	
其他 OTHERS															
最大油泵压力	Max. Pump Pressure	Mpa		16			16		16		16			16	
伺服马达功率	Pump Motor Power	Kw		30			37		45		55			75	
电热功率	Heating Power	Kw		15			18.3		24.7		29.3			33	
外形尺寸 (长 × 宽 × 高)	Machine Dimensions (L × W × H)	m		5.82 × 1.60 × 2.24			6.11 × 1.81 × 2.32		7.08 × 1.99 × 2.38		7.8 × 2.1 × 2.5			7.74 × 1.89 × 2.69	
油箱容积	OIL TANK CUBAGE	L		380			390		680		750			880	
机器重量 (约)	MACHINE WEIGHT (APPROXIMATE)	t		7.6			8.3		12.8		14.6			21.0	
模板正面尺寸 PLATEN DIMENSIONS															
模板侧面尺寸 Mold Space Dimension															
外型尺寸 Machine Dimension															

# XY-I 系列技术参数 | SPECIFICATION TABLE

规格	SPECIFICATION	CN	XY6000			XY7800			XY10000			XY12000			XY15000		
			A	B	C	A	B	C	A	B	C	A	B	C	A	B	C
注射装置	INJECTION UNIT																
螺杆直径	SCREW DIAMETER	mm	90	95	100	90	95	105	90	100	110	110	115	120	110	120	130
螺杆长径比	SCREW L/D RATIO	L/D	20	19	18	23.2	22	19.9	25.5	23	20.9	23	22	21	25.7	24	22
理论注射容量	SHOT VOLUME (THEORETICAL)	cm	2554	2835	3140	2925	3258	3980	2988	3689	4464	5270	5760	6272	6269	7460	8755
注射重量	INJECTION WEIGHT	g	2315	2580	2850	2662	2965	3622	2719	3356	4062	4796	5242	5707	5705	6789	7967
注射速率	INJECTION RATE	g/s	552	612	679	587	654	798	590	729	880	793	867	944	790	940	1102
注射压力	INJECTION PRESSURE	Mpa	184	165	149	195	175	143	216	176	146	186	170	156	205	172	146
螺杆转速	SCREW SPEED	rpm		150			115			100			90			90	
合模装置	CLAMPING UNIT																
合模力	CLAMPING FORCE	KN		6000			7800			100000			12000			15000	
移模行程	OPEN STROKE	mm		870			980			1120			1180			1350	
拉杆内间距	SPACE BETWEEN TIE-BARS	mm		870 × 870			980 × 980			1125 × 1085			1180 × 1100			1360 × 1300	
最大模厚	MAX. MOULD HEIGHT	mm		900			1000			1100			1200			1400	
最小模厚	MIN. MOULD HEIGHT	mm		350			400			400			450			600	
顶出行程	EJECTOR STROKE	mm		250			295			325			325			360	
顶出力	EJECTOR FORCE	KN		150			210			210			245			260	
其他	OTHERS																
最大油泵压力	Max.Pump Pressure	Mpa		16			16			16			16			16	
伺服马达功率	Pump Motor Power	Kw		37+45			45+45			45+55			55+75			75+75	
电热功率	Heating Power	Kw		42.95			59.1			63.9			74.4			81.9	
外形尺寸 (长 × 宽 × 高)	Machine Dimensions (L × W × H)	m		10.2 × 2.24 × 2.71			11.20 × 2.37 × 2.90			11.82 × 2.51 × 3.13			12.54 × 2.66 × 3.27			14.78 × 2.84 × 4.13	
油箱容积	OILTANK CUBAGE	L		900			1250			1700			2100			2900	
机器重量 (约)	MACHINE WEIGHT (APPROXIMATE)	t		24.2			43			50			60			90	
模板正面尺寸 PLATEN DIMENSIONS																	
模板侧面尺寸 Mold Space Dimension																	
外型尺寸 Machine Dimension																	

# XY-II系列技术参数 | SPECIFICATION TABLE

规格	SPECIFICATION	CN	XY1400			XY1600-W			XY2000-W			XY2500-W		
			A	B	C	A	B	C	A	B	C	A	B	C
注射装置 INJECTION UNIT														
螺杆直径	SCREW DIAMETER	mm	38	42	45	42	45	50	45	50	55	50	55	60
螺杆长径比	SCREW L/D RATIO	L/D	22.1	20	18.6	23.5	22	19.8	24.4	22	20	24.2	22	20.1
理论注射容量	SHOT VOLUME (THEORETICAL)	cm <sup>3</sup>	193	235	270	339	389	480	358	442	534	500	605	720
注射重量	INJECTION WEIGHT	g	176	216	246	308	353	436	325	402	485	455	550	655
注射速率	INJECTION RATE	g/s	94	115	132	146	168	207	142	175	213	176	213	277
注射压力	INJECTION PRESSURE	Mpa	205	170	147	175	151	123	180	146	120	200	165	151
螺杆转速	SCREW SPEED	rpm	0-190			0-200			0-200			0-200		
合模装置 CLAMPING UNIT														
合模力	CLAMPING FORCE	KN	1400			1600			2000			2500		
移模行程	OPEN STROKE	mm	380			380			435			490		
拉杆内间距	SPACE BETWEEN TIE-BARS	mm	420×420			465X415			515X465			575X525		
最大模厚	MAX.MOULD HEIGHT	mm	470			500			560			580		
最小模厚	MIN.MOULD HEIGHT	mm	145			160			180			180		
顶出行程	EJECTOR STROKE	mm	120			120			140			160		
顶出力	EJECTOR FORCE	KN	38			46			46			77		
其他 OTHERS														
最大油泵压力	MAX.PUMP PRESSURE	Mpa	16			16			16			16		
伺服马达功率	PUMP MOTOR POWER	Kw	18.5			22			22			30		
电热功率	HEATING POWER	Kw	7.8			11			13			17		
外形尺寸 (长×宽×高)	MACHINE DIMENSIONS (L×W×H)	m	4.4x1.33x1.9			4.7*1.36*2			5.1*1.55*2.1			5.8*1.6*2.0		
机器重量(约)	MACHINE WEIGHT(APPROXIMATE)	t	4.1			4.5			5.4			7.2		

# XY-II系列技术参数 | SPECIFICATION TABLE

规格	SPECIFICATION	CN	XY3000-W			XY3800-W			XY4500-W				XY5500-W				XY6500-W			
			A	B	C	A	B	C	A	B	C	D	A	B	C	D	A	B	C	D
注射装置 INJECTION UNIT																				
螺杆直径	SCREW DIAMETER	mm	55	60	65	70	75	80	70	75	80	85	75	80	85	90	90	95	100	105
螺杆长径比	SCREW L/D RATIO	L/D	24	22	20.3	23.5	22	20.6	23.6	22	20.7	19.4	23.5	20.7	19.6	18.6	23	21	20	19
理论注射容量	SHOT VOLUME (THEORETICAL)	cm <sup>3</sup>	712	848	995	1346	1545	1750	1516	1740	1979	2235	1987	2291	2569	2862	2544	2834	3140	3412
注射重量	INJECTION WEIGHT	g	648	771	905	1225	1406	1600	1379	1583	1801	2034	1808	2085	2338	2605	2315	2579	2857	3150
注射速率	INJECTION RATE	g/s	233	277	325	364	418	476	395	453	516	582	473	607	681	758	550	610	680	750
注射压力	INJECTION PRESSURE	Mpa	240	201	171	191	167	146	226	197	173	153	222	173	154	138	184	165	149	135
螺杆转速	SCREW SPEED	rpm	0-200			0-180			0-180				0-180				149			
合模装置 CLAMPING UNIT																				
合模力	CLAMPING FORCE	KN	3000			3800			4500				5500				6500			
移模行程	OPEN STROKE	mm	560			680			770				900				905			
拉杆内间距	SPACE BETWEEN TIE-BARS	mm	625X575			730X680			780X730				880X820				925x875			
最大模厚	MAX.MOULD HEIGHT	mm	630			730			780				900				900			
最小模厚	MIN.MOULD HEIGHT	mm	220			250			250				300				330			
顶出行程	EJECTOR STROKE	mm	160			180			200				250				295			
顶出力	EJECTOR FORCE	KN	77			137			137				166				150			
其他 OTHERS																				
最大油泵压力	MAX.PUMP PRESSURE	Mpa	16			16			16				16				16			
伺服马达功率	PUMP MOTOR POWER	Kw	37			45+22			45+22				55+22				75+22			
电热功率	HEATING POWER	Kw	24			35			39				44				42.95			
外形尺寸 (长×宽×高)	MACHINE DIMENSIONS (L×W×H)	m	6.3*1.7*2.0			7.4*1.9*2.15			7.8*1.9*2.15				9.3*2.1*2.23				10.2*2.3*2.8			
机器重量(约)	MACHINE WEIGHT(APPROXIMATE)	t	9			14			16				20				25			

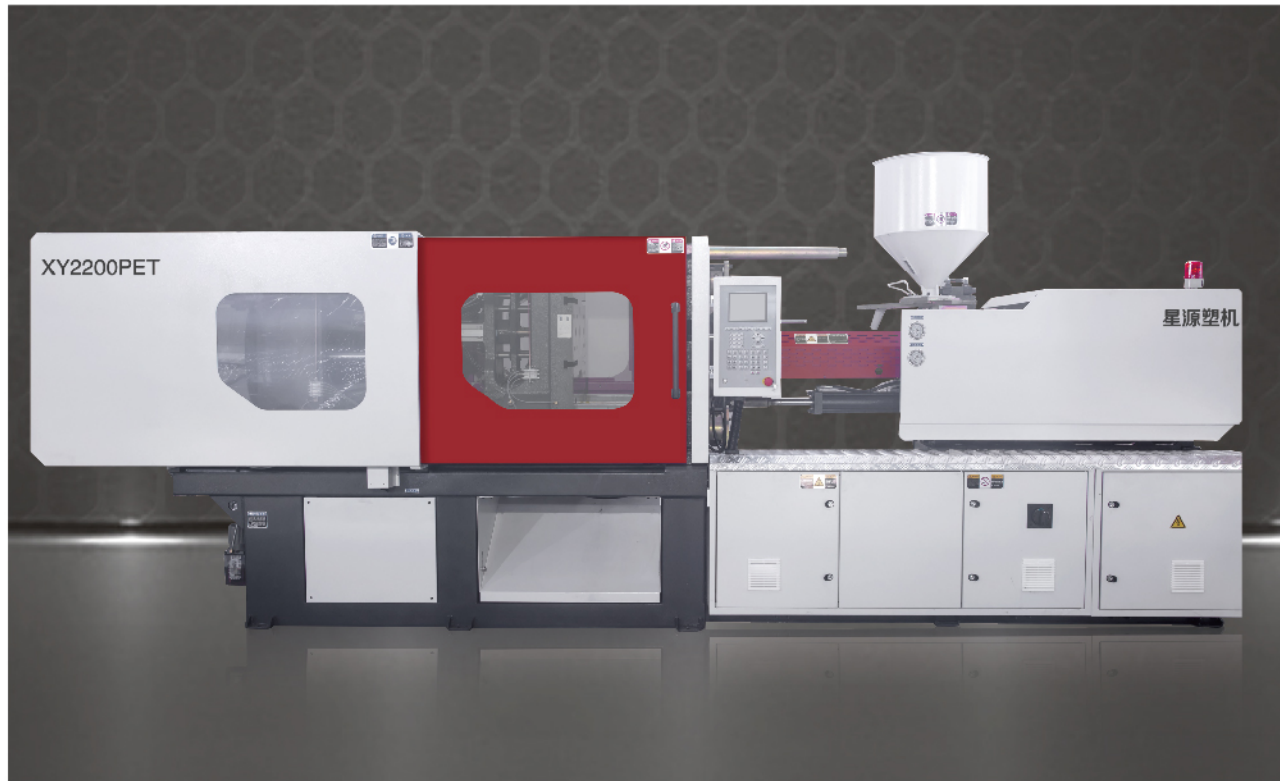
# PET 瓶胚专用注塑机

## PET PREFORM INJECTION MOLDING MACHINE

### 产品特点

PRODUCT FEATURES

- 星源 PET 瓶胚专用注塑机采用 PET 射胶机构，螺杆长径比 25:1，具有良好的塑化能力，适合成型各种 PET 产品。
- Xingyuan PET preform injection molding machine adopts specified injection unit for PET products, with screw L:D ratio 25:1, have excellent plasticizing capacity, suitable for making various kinds of PET products.



# 技术参数

## SPECIFICATION TABLE

规格	SPECIFICATION		XY1700PET	XY2200PET	XY2700PET	XY3600PET	XY4200PET	XY5200PET
注射装置 INJECTION UNIT								
螺杆直径	SCREW DIAMETER	mm	65	70	75	80	90	95
螺杆长径比	SCREW L/D RATIO	L/D	25	25	25	25	25	25
理论注射容积	SHOT VOLUME	cm <sup>3</sup>	895	1134	1479	1959	2480	3258
注射重量	INJECTION WEIGHT	g	961	1224	1597	2115	2678	3540
注射速率	INJECTION RATE	g/s	384	400	465	528	661	680
注射压力	INJECTION PRESSURE	Mpa	130	130	150	165	138	150
螺杆转速	SCREW SPEED	rpm	134	126	126	139	130	115
合模装置 CLAMPING UNIT								
合模力	CLAMPING FORCE	KN	1700	2200	2700	3600	4200	5200
移模行程	OPEN STROKE	mm	435	475	550	670	705	770
拉杆间距 (宽*高)	TIE BARS SPACE(W*H)	mm	480*480	530*530	580*580	680*680	730*730	820*800
最大模厚	MAX.MOULD HEIGHT	mm	560	560	580	680	780	810
最小模厚	MIN.MOULD HEIGHT	mm	180	200	200	250	250	330
顶出行程	EJECTOR STROKE	mm	135	140	150	165	180	240
顶出力	EJECTOR FORCE	KN	70	90	90	150	150	150
其他 OTHERS								
最大油泵压力	MAX.PUMP PRESSURE	Mpa	16	16	16	16	16	16
油泵马达功率	PUMP MOTOR POWER	KW	37	45	45	55	55	45+45
电热功率	HEATING POWRE	KW	22.3	22.7	30.7	36.7	42.7	59.1
外形尺寸 (长x宽x高)	SIZE (LxWxH)	m	5.9*1.6*2.0	6.5*1.8*2.3	7.2*1.9*2.3	8.1*2.1*2.5	8.8*2.0*2.5	10.8*2.37*2.55
机器重量(约)	MACHINE WEIGHT	t	6.2	7.2	9.2	13.5	16	22.5

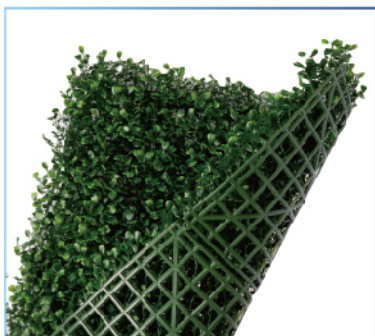
	XY1700PET	XY2200PET	XY2700PET	XY3600PET	XY4200PET
模板尺寸图 Platent Dimensions					
模板侧面尺寸 Mold Space Dimension					
安装图 Floor Plan Layout					

# 双色花草注塑机

MIXED TWO COLORS INJECTION MOLDING MACHINE FOR ARTIFICIAL GREEN PLANTS

# 技术参数

SPECIFICATION TABLE



规格	SPECIFICATION	CN	XY1400-S		XY1500-S	
			A	B	A	B
<b>注射装置 INJECTION UNIT</b>						
螺杆直径	SCREW DIAMETER	mm	28	32	28	32
螺杆长径比	SCREW L/D RATIO	L/D	22.8	20	22.8	20
理论注射容量	SHOT VOLUME (THEORETICAL)	cm <sup>3</sup>	87	114	87	114
注射重量	INJECTION WEIGHT	g	79	103	79	103
注射速率	INJECTION RATE	g/s	85	112	85	112
注射压力	INJECTION PRESSURE	Mpa	230	177	230	177
螺杆转速	SCREW SPEED	rpm	200		200	
<b>合模装置 CLAMPING UNIT</b>						
合模力	CLAMPING FORCE	KN	1400		1500	
移模行程	OPEN STROKE	mm	380		380	
拉杆内间距	SPACE BETWEEN TIE-BARS	mm	420X420		460x460	
最大模厚	MAX.MOULD HEIGHT	mm	470		450	
最小模厚	MIN.MOULD HEIGHT	mm	145		160	
顶出行程	EJECTOR STROKE	mm	120		120	
顶出力	EJECTOR FORCE	KN	38		50	
<b>其他 OTHERS</b>						
最大油泵压力	MAX.PUMP PRESSURE	Mpa	16		16	
伺服马达功率	PUMP MOTOR POWER	Kw	18.5		18.5	
电热功率	HEATING POWER	Kw	15		15	
外形尺寸 (长×宽×高)	MACHINE DIMENSIONS (L×W×H)	m	4.6x1.33x1.9		4.85*1.55*1.8	
油箱容积	OIL TANK CUBAGE	L	265		265	
机器重量(约)	MACHINE WEIGHT(APPROXIMATE)	t	4.1		4.3	

## 塑料、料筒温度设定表

The form of plastic and barrel temperature established

下表为料筒温度与塑料参数之间的各项关系，此表仅供参考，实际温度要根据长时间的使用经验来设定。

The relation between temperature of the material tube and plastic parameter in the following form is just for reference, actual temperature will be established according to long term experience accumulated.

塑料名称 PLASTIC NAME	比重 SPECIFIC GRAVITY	熔点 MELTING POINT	收缩率 SHRINKAGE RATIO	模温 MOULD TEMPERATURE		料筒温度 BARRAL TEMPERATURE					
						喷嘴 NOZZLE		中段 MIDDLE		尾段 END	
				最小值 MIN	最大值 MAN	最小值 MIN	最大值 MAN	最小值 MIN	最大值 MAN	最小值 MIN	最大值 MAN
PS	1.07	100	0.4	10	75	180	260	200	260	160	250
HIPS	1.00	100	0.4	5	75	220	270	190	260	160	250
ABS	1.05	110	0.6	50	80	190	250	180	240	170	240
LDPE	0.92	120	1.5-5	35	60	230	310	220	300	170	220
HDPE	0.95	130	2.0-5	35	60	230	310	220	300	170	220
PP	0.91	176	1-2.5	50	80	210	300	180	260	160	240
PVC	1.45	90	0.1-0.5	10	60	170	220	160	195	150	195
PMMA	1.19	100	0.5	50	90	180	230	160	240	140	220
PA6	1.13	216	0.8-1.5	50	80	210	230	210	230	200	210
PA66	1.14	265	2.25	50	80	250	280	240	280	220	280
CA	1.30	230	0.5	40	75	180	200	170	190	150	180
PC	1.20	150	0.8	80	99	250	320	260	340	280	350
POM	1.41	175	2.0	50	90	190	210	175	220	160	210
SAN	1.09	115	0.2	50	80	250	250	180	230	170	220

## 注塑机辅机 | INJECTION MOLDING MACHINE AUXILIARY



碳刷式自动填料机  
carbon brush auto-loader



感应式自动填料机  
induction auto-loader



干燥机  
hopper dryer



水冷箱式工业冷水机  
water chiller



风冷箱式工业冷水机  
air chiller



模具自动控温机  
automatic mold temperature control



塑料粉碎机  
plastic crusher



空压机  
air compression



立式混色机  
vertical color-mixer



冷却塔  
cooling tower



除湿干燥机  
dehumidification dryer



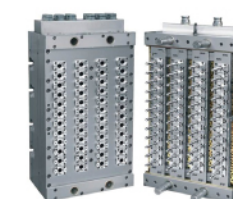
除湿干燥送料组合  
dehumidifying, drying and feeding unit



机械手 robot



上行输送机  
up-style conveyor belt



模具  
mold



磁力架  
magnet frame