

MSZ135

INJECTION BLOW MOLDING MACHINE

注吹中空成型机



技术特点 Technical Features

- ☒ 三角横梁结构刚性高稳定性好

☒ 卧式线轨射台，差动注射，速度快、精度高、寿命长

☒ 双伺服系统，较单伺服系统再节能5%~10%

☒ 开合模升降完全同步，空运转周期仅2.4秒

☒ 全自动智能电控系统，操作更安全更方便

☒ Triangular beam make the structure strong and more stable performance

☒ Horizontal linear guide injection rail with line drive,high speed, high precision and long service life

☒ Compared to single servo system,dual servo system save 5%~10% energy.

☒ Mold-opening&closing synchronize with rotation, dry cycle time is only 2.4s

☒ More safe and convenient operation with fully automatic intelligent electronic control system

选配 Optional

- ☒ 电预塑，可实现同步预塑

☒ 伺服脱模翻转，节能洁净

☒ 伺服回转，回转定位精度高

☒ Electric preplastication,can be synchronization in plasticising

☒ Servo stripping system,saving more energy and oil-free condition

☒ Servo rotation device,improve rotary positioning accuracy

模具腔数

Mould Cavitation

腔数	No. of Cavities	8	10	12	14	16	18	20	24
口径	Neck Diameter (mm)	45	40	40	40	35	35	30	25
瓶身直径	Body Diameter (mm)	80	70	60	55	50	45	40	35
最大高度	Max. Height (mm)	220	200	180	160	140	100	80	70
最大容积	Max. Volume (ml)	1000	500	400	300	200	100	60	40

* 仅供参考，实际腔数依客户提供的瓶型而定。Only for reference, based on bottle shape.

主要技术参数

Main Technical Parameters

注射机构	Injection system	Unit	MSZ135	
螺杆直径	Screw diameter	mm	70	75
螺杆长径比	Screw	L/D	23:1	23:1
最大注射容积	Shot volume	cm³	1077	1236
最大注射量	Injection weight (HDPE)	g	1020	1170
螺杆转速	max.Screw speed	rpm	10-235	
机筒加热功率	Heating capacity	KW	15	
合模系统	Clamping system			
注塑锁模力	Clamping force of injection	KN	1344	
吹塑锁模力	Clamping force of blowing	KN	235	
最大模板尺寸	Max.Platen size (L×W)	mm	1400×500	
最小模具厚度	min.Mold thickness (H)	mm	280	
模具加热功率	Heating capacity of mould	KW	10	
脱模系统	Stripping system			
脱模行程	Stripping stroke	mm	260	
空运转时间	Dry cycle	sec	4.5	
驱动系统	Driving system			
驱动电机	Motor power	KW	30+30	
系统压力	Hydraulic pressure	Mpa	14	
制品尺寸范围	Product range			
制品容积	Suitable bottle range	ml	5-800	
制品高度	Max.Bottle height	mm	≤220	
制品直径	Max.Dia. of bottle	mm	≤100	
其他	Others			
压缩空气压力	Min.Air pressure	Mpa	1	
压缩空气排量	Discharge rate of compressed air	m³/min	≥1.2	
冷却水流量	Water flowage	m³/h	6	
额定总功率（含模具加热）	Total rated power with mold heating	KW	85	
设备尺寸	Dimension (L×W×H)	m	6×2.5×2.6	
设备净重	Net weight	Ton	15	