Ningbo haijiang Machinery manufacturing

Company Introduction 公司简介

Situated in ningbo yinzhou investment & innovation center, covers a land of more than 50,000m^2.It was established in 1992 and now employs a staff of more than 500 people.

海江公司是一家专业生产注射塑机的高新技术企业。主要生产注射量为 45–20000 克，合模力为 400–15000KN 的几十种规格塑料注塑成型机。公司积累多年行业经验，不断创新，为确保机器品质，不同锁模力机器的部件均采用专业化管理加工。海江公司研制的 HJ 系列注塑机在吸取世界名机之精华的基础上用 CAD/CAM/CAPP 技术对产品进行优化设计，使整机噪音低、耗能低，确保了产品的设计质量。

HAIJIANG COMPANY is a hihg-tech enterprise specialized in manufacturing injection molding machines that mainly covers dozens of specifications with injection shot of 45-2,0000g and mold clamping force of 400-15,000KN. Based on the marrow of the trade gained and through years' accumulation, the company has made constant innovation to ensure the machine quality.Parts built into the machines of defferent mold locking forces are all processed under specialized management. HJF series injection molding machines are developed by Haijiang Company on the basis of a collection of the advantages assimilated from all world famous brand machines with optimized design realized by CAD/CAM/CAPP where technical problems such as noise of the entire machine and low energy dissipation are removed and thus the design quality of products is secured. The company adopts advanced equipment and technology and applies scientific management. Besides, it has introduced high-precision full automatic CNC machines fitted with imported electric and hydraulic parts, which have tremendously improved the accuracy and steadiness of the whole machine. Its present products such as HJK and KJF series and widely applied in the electronic, automobile and civil industries.

In order to participate in competition in the world market,the company has clustered a group of high quality technical and managerial personnel with innovative spirit by means of optimized combination fo personnel. The company faces the society and users by acting on the principle of pursuit for first class and sincere service. We will appreciate friends from all circles who have given their concern and support to Haijiang machines with first class products and first class after service.

宁波海江机械制造有限公司创建于 1992 年，位于宁波鄞州区，占地面积 20000 多平方米，现有员工 250 人。

公司采用先进的设备和技术，运用科学的管理，引进高精度全自动数控机床，配置进口电气、液压部件，大幅度提高了整机的精度和稳定性。目前生产的 HJK、HJF 系列注塑机已拥有多种规格，并可以接受用户 特殊订货，用于生产高精度的热塑性塑料制品，公司各类产品广泛应用于工业、电子、汽车、民用等行业。

为了参与国际市场的竞争，公司通过人员优化组合，凝聚了一批拥有开拓精神的高素质技术管理人才，公司本着“追求一流、竭诚服务”的宗旨，面向社会和广大用户。我们将用一流的产品，一流的售后服务，合理的价格来感谢所有关心和支持海江塑机的各界朋友。

Pursue High Quality
Untiring Service 追求一流、竭诚服务

Scientific and effective management

以责任为生产标准

High quality products from a scientific and efficient management, the sea river import and insist for a long time I0S9001 international quality management system and the "6 s" management mode, from the processing, assembly and commissioning, every link conscientious and meticulous, strict control.

Through the systematic and carefullization, use programming, standardization, digital and information means, organization management each unit accurate, efficient, collaborative and continuous operation. And implement management responsibility, will the production task the distribution shape, crystallize, each producer is conscientious. Thus we improve the production efficiency and reduce the production cost, shorten production cycle, for customers to save the cost of buying machine, so as to create more value for customers.

优质的产品离不开了科学高效的管理，海江导入并长期坚持 I0S9001 国际质量管理体系和现场“6S”管理模式，从加工、组装到调试，每个环节都一丝不苟，严格控制。

通过系统化和细致化、运用程序化、标准化、数据化和信息化的手段，组织管理各单元精确、高效、协同和持续运行。并落实管理责任，将生产任务的分配具体化、明确化，每一个生产者都尽职尽责。由此我们提高了生产效率，降低了生产成本，缩短了生产周期，为客户节省了购机成本，从而为客户创造更多价值。

海 嘉

Equipment is an important part of the productive forces and one of the basic elements is engaged in production of important our tools and method, also is our survival and development of the important material wealth. We clearly know, from the production equipment to processing equipment, whether the enterprise assets on the share, or the content of the management, and we reflect the market competition ability, it plays a huge role.

设备是生产力的重要组成部分和基本要素之一，是我们从事生产经营的重要工具和手段，也是我们生存与发展的重要物质财富。我们清楚地知道，从生产设备到加工设备，无论是企业资产的占有率上，还是管理工作的内容上，以及我们市场竞争能力的体现上，它都发挥着巨大作用。

PROCESSING ABILITY
WELL-EQUIPPED, ENSURING TOP QUALITY !

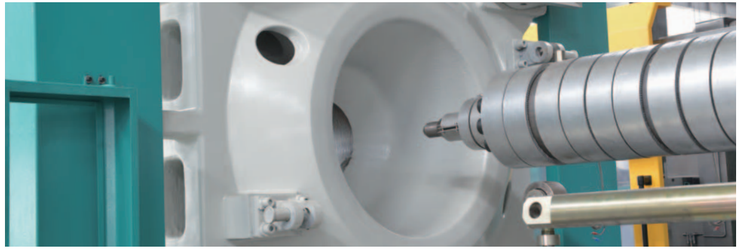
装备精良，确保一流品质!

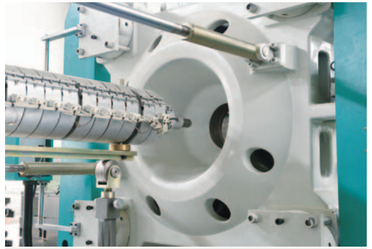
Big type locking institutions
大机型锁模机构

- The song level stress: protect and improve precision mould
- Mould centre parallel force: solve big problems of the small mould flash
- Reducing the loss of pressure, reduce oil pump load, more energy saving
- Thoroughly overcome phrasing molmerged institutions in force caused by is not parallel template that additional deformation clamping force
- The same institution length move mould stroke increased by more than 20%
- Thimble schedule doesn't limit by song cubits
- Easy installation and maintenance

- 外曲水平受力：保护模具、提高精度
- 模具中心平行受力：解决大机台小模具的飞边问题
- 减少压力损失，降低油泵负载，更节能
- 彻底克服内曲式合模机构因受力不平行引起的模板变形所增加额外锁模力
- 相同的机构长度移模行程提高 20%以上
- 顶针行程不受曲肘限制
- 方便安装与维修

Arm Linkage Clamping
曲臂连杆机构锁模





- 注塑压力高，注射速度快。
- 轻体坚固的双缸平衡式结构，快速运动导向系统，支撑整个注射装置。
- 陶瓷加热圈，除可降低能耗外还可以降低周边环境温度。
- 滑块式料斗滑动结构，确保料斗或干燥料斗滑动自如，轻快灵活。
- 射台后板，采用三串联轴承结构，精密准确，受力良好。
- 注射系统全面配合了安全装置，彻底保证操作者安全生产。
- 锁模与注射部件可由自由搭配，注射注射量空前灵活。
- 螺杆头和止逆环采用日本进口热作工具钢，经真空淬火处理，具有抗高温、耐磨耗，防腐蚀之特性。

Injection Units
注射系统

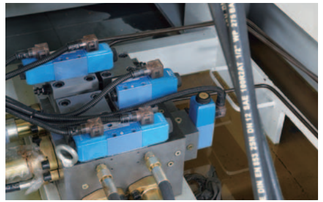
- High injection pressure High injection speed
- Lightweight rugged twin balanced structure, rapid movement guidance system, support the injection device.
- Ceramic heating coil, and double–layer shields, in addition to reducing energy consumption, can also reduce the temperature of the surrounding environment.
- Sliding hopper sliding structure to ensure that drying hopper hopper or sides freely, light and flexible.
- Radio station after the board, with three series bearing structure, precise and accurate, stress is good.
- Injection system fully in line with the safety devices to ensure operator safety and completely.
- Clamping and injection components may be free with injected an unprecedented amount of flexibility in injection.
- Screw head and the non–return value imported from Japan hot tool steel, hardened by vacuum, with high temperature resistance, abrasion resistance, anti–corrosion properties.

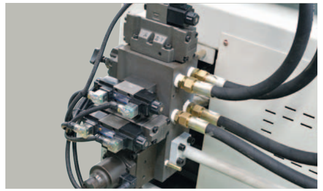
HYDRAULIC
液压系统

- The main hydraulic components, seals, high pressure hose used the international brands.
- Circuit board a reasonable distribution,fast response of the system, dynamic performance.
- Hydraulic components of european and american brands with differential circuit design ensure locking fast, stable, low noise,shorten the molding cycle,improve production efficiency.
- Spiral-type cooler thermal efficiency,pressure loss,to ensure stable operation of the hydraulic system, to improve the repetition rate precision and qualified products.
- High torque hydraulic motor meet a variety of plastics raw materials requirements of plastic.
- By pass oil filter, effectively prevent the pollution and degradation of hydraulic oil,so that the oil pump, valve and other hydraulic components run more stable, longer life of hydraulic confidential.
- Equipped with a high-performance servo control system for variable speed power,wich make the corresponding output frequency for different pressure flow in the molding process injection molding machine,and make the precise closed loop control for pressure flow, to achieve automatically adjust the best match of energy requirements from servo electric machine to injection machine.To achieve the precise speed and pressure control.(Clamping, injection plastic, ejector the whole closed-loop servo control greatly improve speed of response,repeatability is within 1% accuracy:the pressure error is less than 1kg when continued to test packing stage for 10sec).
- Quantitative pump output system stability, fast response, high power.

Fast respone, Stable output
快速响应、稳定输出

- 主要液压元件、密封件、高压软管采用国际知名品牌。
- 油路板分布合理，系统反应速度快，动态性能好。
- 欧美名牌液压元件配以差动式油路设计，保证锁模快捷，平稳，低噪音，缩短产品成型周期，提高生产效率。
- 螺旋导流式冷却器散热效率高，压力损失小，保证液压系统稳定运行，提高重复精密度和产品的合格率。
- 大扭矩液压马达，满足各种原料的塑料的塑化要求。
- 傍路式高精密度过滤器，有效的防止液压油的污染和劣化，从而使油泵，油阀等液压元件运行更平稳，液压密件的寿命更长。
- 配备了高性能的伺服变速动力控制系统，注塑机在成型过程中对不同的压力流量作出相应的频率输出，并对压力流量进行精确的闭环控制，实现伺服电机对注塑机能量需求的最佳匹配和自动调整。实现了精密的速度与压力控制（锁模，射胶，顶出全闭环回路伺服控制极大提高响应速度，重复性精密度在1%以内；保压力作持续测试10秒，压力误差不超过1kg）。
- 定量泵输出系统稳定，响应速度快，力量强。





High performance injection mechanism, the whole shoot table bracket, special material sliding bracket, friction is low, the operation is stable
Unique material tube group design, guarantee the raw material of fully mixing effect
A variety of professional plasticizing system optional

高性能的射出机构，整体射台托架，特殊材料的滑动架，摩擦低、运行稳定
独特的料管组设计，保证原料的充分混炼效果
多种专业塑化系统备选

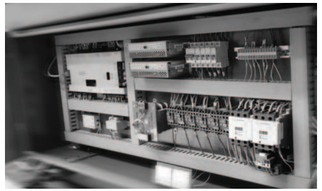
Precision injection unit
精密注射单元

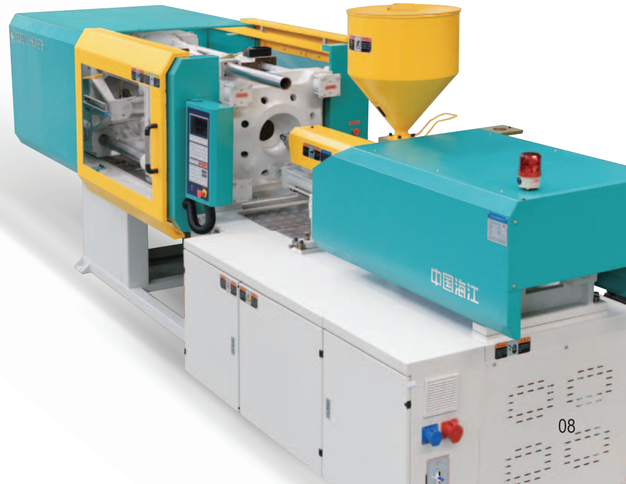
High-end special injection molding machine controller, the friendly man-machine interface, into human nature design concept, real-time monitoring of the production process. system reaction speed, the implementation of the machine of high precision, convenient operation of the man-machine interactive platform. Many additional functions for choice, meets your specific needs.

高端专用注塑机控制器，友好的人机交互界面，融入人性化设计理念，实时监测生产过程。系统反应速度快，机器的执行精度高，操作便捷的人机交互平台。多种附加功能供选择，满足您的个性化需求。

Intelligent control unit
智能控制单元

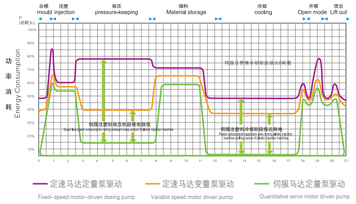
Electronic units
电器系统





HJS SERVO ENERGY-SAVING INJECTION MOLDING MACHINES

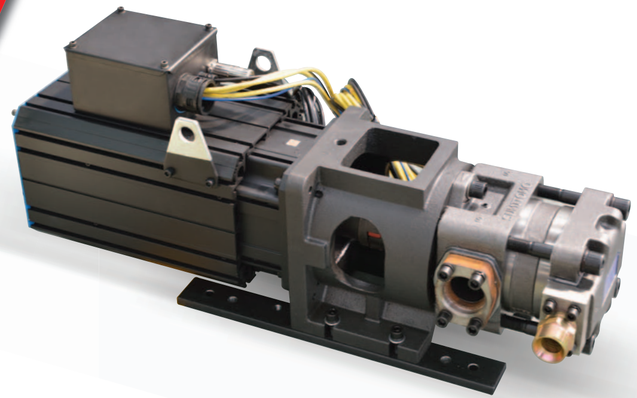
HJS 系列伺服节能注塑机



energy saving the king 节能王

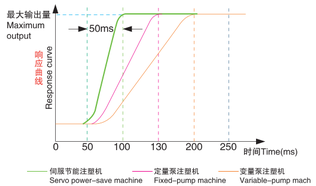
HJS series machines having advantages of other HJ series are loading with high performance servo motor. Its delivered power vaies with loading power without any excess energy waste. During pressure maintenaning period, servo motor consumes little energy waste. During pressure maintenaning period, servo motor consumes little energy for lowering speed of motor while no work in cooling time. Compared with average injection machines, servo motor machines can have 50%-80% electricity-saving. Good ecnomic returns with servo motor.

该系列机型传承了众多系列的优秀性能，配备了高性能的 伺服变速动力控制系统。输出功率随负载变化而变化，不存在多余能量的浪费。保压阶段伺服电机降低转速，耗能极低，而且在冷却阶段电机不工作。根据产品不同，伺服节能注塑机相比传统注塑机可节省用电 50%–80%，经济效益显著。



Fast response, high repeatability

响应速度快，重复精度高



- Pressure responses fast, quick start up to 0.05s
- Compared to traditional injection molding machine the control system to respond to 2-3 times faster
- High response speed, shorten cycle times, improve production efficiency
- Products repeat accuracy can be increased to more than 5 per thousand, fully able to meet the requirements of ultra-precision injection molding

- 压力响应力快， 快速启动高达0.05s
- 相较传统控制方式的注塑机， 系统响应速度加快至2–3倍
- 响应速度高，有效缩短周期，提高生产效率
- 制品重复精度能提高到千分之5以上，完全能适应超精密注塑要求

High-Capability Control System

高性能控制系统

- servo motor oil can input by command with low heat, pressure, oil temperature significant savings in cooling water
- the consumption of servo–point system is very low, and at low load and no load packing and cooling stages almost no power.

- **大幅节能：**
在同等条件下，相比传统定量泵注塑机节能 50%–80%。
极佳成型稳定性：
伺服驱动系统，压力、流量采用闭环控制，相比较传统注射机，成型重复精度明显提高。
- **相应速度快：**
伺服驱动相应迅速，快速启动时间比传统注射剂提高 50%。
超性能环保：
整机运行低噪音，低速运行功能宁静。
- **油温恒定：**
伺服电机按比例输出液压油，避免多余热量产生，液压温甚至不需冷却实现大幅节水。

- 伺服电机按指令输入油液，产生热量低，压力油温度低，大幅节省冷却用水
- 伺服系统，在低载荷和无载荷的保压及冷却阶段用电量极低， 在冷却阶段几乎不耗电

Energy efficient

高效节能

The river would help you to promote the comprehensive enterprise competitiveness

海江助您提升企业综合竞争力

The high quality of the servo control technology perfect applied, energy saving and efficiency improvement to acme, saving every penny for you

高品质伺服控制技术的完美应用，节能增效发挥到极致，为您节约每一分钱

Big parameter design, increase machine compatibility, achieve little machine USES, to save your buying machine and production costs

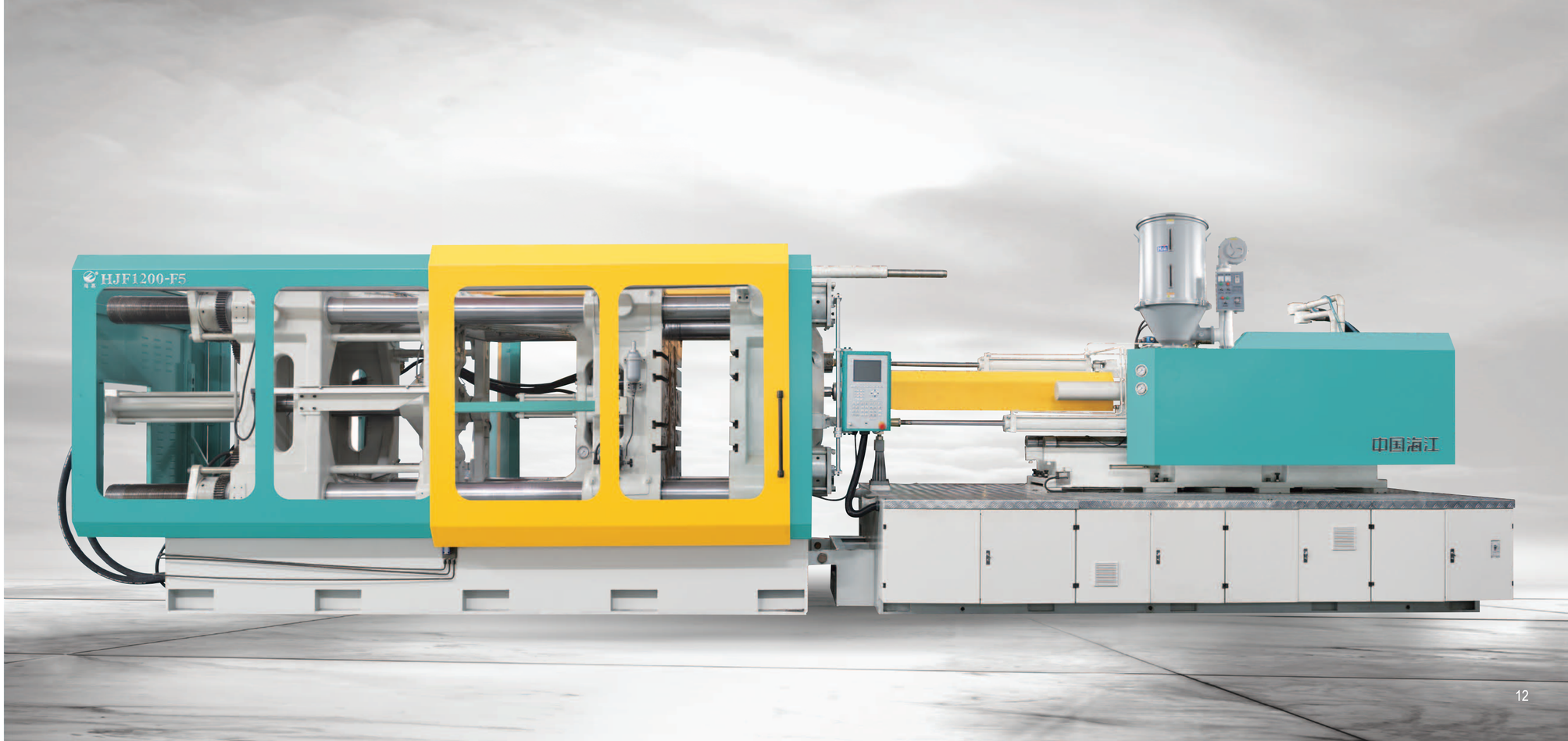
大参数设计，增加机器兼容性，实现小机大用，为您节约购机与生产成本

Precision production management system of the production of the plastic injection machine, low breakdown, let you continue pillow production

精密生产管理体系下生产的注塑机，降低故障率，让您持续无忧生产

European design concept, the international famous brand hydraulic parts, electrical components, than traditional machine a faster and more efficient

欧洲设计理念，国际名牌液压配件、电器元件，比传统机运行速度更快，效率更高



Haijiang a new leader in plastics injection molding machines!

Haijiang servicemen are skilled, our professional staff will to achieve your praise with good services, will achieve your touching with dedication, will achieve your trusts on Haijiang machines with excellent technology.

海江的维修人员均技术精湛，我们专业的人员会以良好的服务赢得你的赞誉，以热诚忘我的精神赢得您的感动，更会以精湛的技术赢得您对海江塑机的信任。

Pre-Sales Service 售 前

Apart from best quality and price advantage, Haijiang has advantages on pre-sales service. Haijiang uses its network for IT supports and customers can get supports through it.

除去过硬的品质以及价格上的优势，海江更有在售前服务上的优势。海江利用自身的网络平台进行信息技术支援，用户可以通过海江信息平台得到公司信息和技术支持。

In-Sales Service 售 中

Haijiang takes “Smile while Serving for Customers” as our in-sales service concept, well knowing every department of the company, making customers feel happy and confident while cooperating with Haijiang, keeping the “0 error” service, and maintaining Haijiang good reputation.

海江秉承“微笑第一、服务三问”的售中服务理念，深入公司部门各网点，使得用户在和海江合作的同时感受到快乐和自信，产品交易保持着“零误差”这种细致体贴的服务，使得海江在同行中保持着良好的口碑。

After-Sales Service 售 后

Haijiang have good after-sales services centers home and abroad, serve for every customer. Haijiang is responsible for every machine we sold.

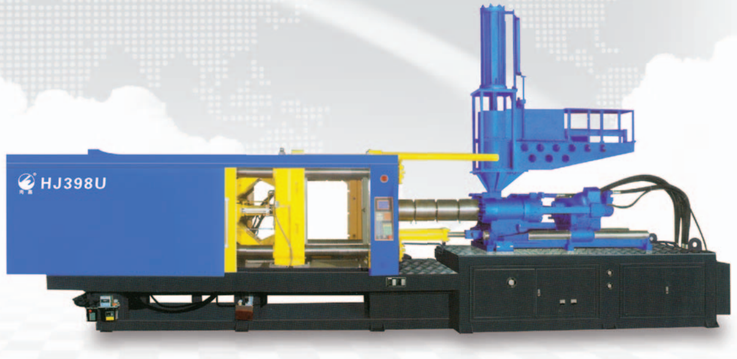
海江运用自身良好而快捷的服务已覆盖全国的技术服务中心，对购买海江产品的客户进行及时有效地售后服务，海江承诺对海江产品的质量无法确认责任归属时，由海江公司承担相应责任。

The river is for the user to provide application and process technology and reliable partners, including full support, and they will all your injection problem to provide comprehensive solutions, all the HJ machine, can detailed meet your special request.

海江是为用户提供应用和工艺技术的可靠合作伙伴，包含全面的支持，他们会对您所有的注塑问题提供全面的解决方案，所有的 HJ 机，能详尽的满足您的特殊要求。

Our Service

全程追踪，真诚服务



BMC Wet Type Plastion Molding Machine

BMC 塑料注塑机

BMC 即团状模塑料，在欧洲称 DMC，国内常称作不饱和聚脂状模塑料，或简称聚脂料团。为各各加热硬化性成形材料中最高级品，具如下的特点：

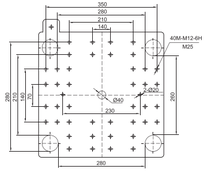
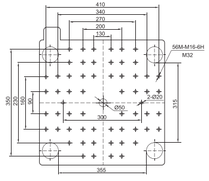
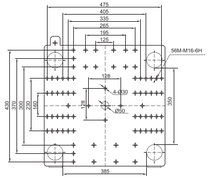
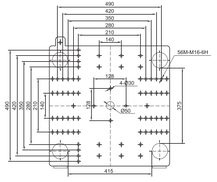
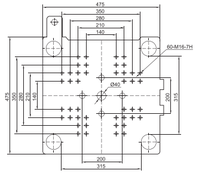
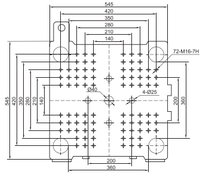
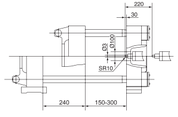
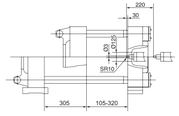
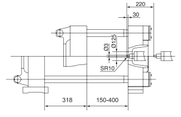
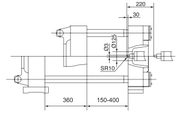
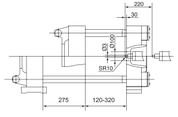
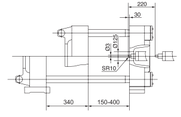
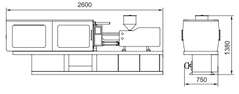
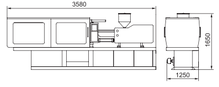
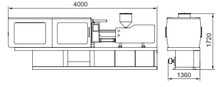
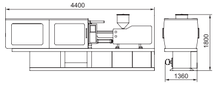
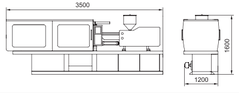
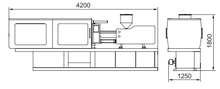
1、电气绝缘性：最适用于耐高压、介电性，高绝缘、耐电弧性的电气产品。
2、适用于各种工程之标本及隔板等地方。
3、耐燃性能：可达到美国 UL–94VO 级。
4、耐热性能：热变形温度极高 (200℃ –260℃) 无热水劣化情况发生。
5、机械强度：内含增强玻璃纤，其机械力学性能均优于一般热塑性工程塑料。
6、颜色性：任何颜色均可调制，不用再烤漆，颜色鲜艳逼真，几近完美。
7、加工性：尺寸收缩稳定，精密度高，表面光滑美观，可采用注塑成型机，模压成型机，多工们转盘注塑成型等设备来加工。

BMC Wet Type Plastion Molding Machine
BMC is block molding conpound,It is also called DMC dough molding Compound or polyester for short is China.It is the hinghest classmaterals in various thermoset molded materials and has the featrures as follows.
1.Electrical insulation:It's suitable for electrical products with high voltage resistance,dielectric property,high insulation and are resistance.
2.High corrosion resistance:It’s suitable forplaces such as specimen andbaffle plate of various projects.
3.Flame resistance performance:coming up to American UL-94Vo level
4.Heat resistance performance:No heat crack happens under very high thermal deformation temperaturc(22℃ -260℃).
5.High machinery strength:products are strengthened by glass fiber to greatly improve its machinery strength,compsred to the other thermoset engineering plastcs.
6.Color performance:Any color can be adjusted and produced,no baking finish is used again.It has fresh and real color closing to perfection.
7.Processing performance:It has stable size shrinkage,high preci-sionsmooth and beautiful surface.It can be processed by plastic injection molding machine,mold compression molding machine and multi-station Pla-stic injection molding machine.

SPECIFICATIONS 产品规格

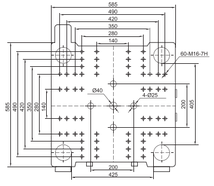
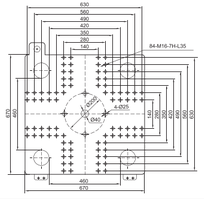
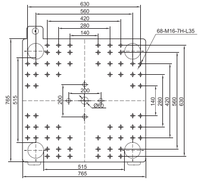
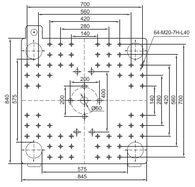
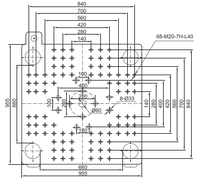
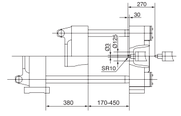
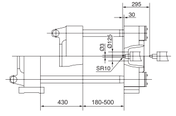
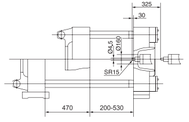
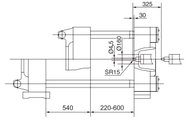
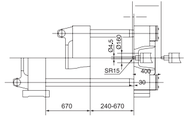
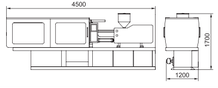
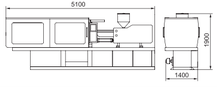
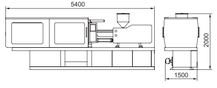
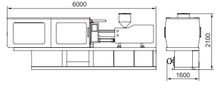
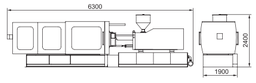
规格	SPECIFICATION		HJ–120U		HJ–140U		HJ–180U		HJ–240U		HJ–280U		HJ–328U		HJ–398U	
			A	B	A	B	A	B	A	B	A	B	A	B	A	B
注射装置	INJECTION UNIT															
螺杆直径	Screw Diameter	mm	40	45	45	50	50	55	55	60	60	65	65	70	70	75
理论容量	Shot Size (Theoretical)	cm^3	175	220	320	380	420	480	730	780	870	990	1180	1406	1400	1700
注射重量	Injection Weight(PS)	g/(克)	190	250	360	420	460	525	800	850	950	1050	1350	1550	1500	1870
注射压力	Injection Pressure	MPa	186	167	195	140	159	140	180	150	183	157	183	157	174	155
注射速率	Injection Rate	g/s	80	95	105	135	128	158	148	179	240	270	275	328	438	499
塑化能力	Plasticizing Capacity	g/s	13	16	12	13.5	20	24	31	37	31	34	37	43	42	47
锁模装置	CLAMPING UNIT															
合模力	Clamp tonnage	KN	120		1400		1800		2400		2800		3280		3980	
移模行程	Opening stroke	mm	340		380		430		470		540		670		720	
模厚	mold height	mm	100~350		120~400		130~450		150~480		170~550		190~620		230~760	
拉杆内距	Space Between Tie Bars	mm	360×360		420×420		470×470		520×520		580×580		660×660		720×720	
顶出行程	Ejector Stroke	mm	100		120		130		135		145		160		170	
顶出力	Ejector Tonnage	KN	33		33		45		70		75		62		62	
其　它	OTHERS															
最大油泵压力	Max. Pump Pressure	MPa	16		16		16		16		16		16		16	
油泵马达	Pump Motor Power	KW	11		13		15		18.5		22		37		37	
电热功率	Heater Power	KW	6		6		6		6		6		6		9	
外形尺寸 (长x宽x高)	Machine Dimension(LxWxH)	m	4.2×1.25×1.8		4.5×1.2×1.7		5.1×1.2×1.7		5.4×1.5×2		6×1.6×2.1		6.3×1.9×2.4		7×1.9×2.4	
重　量	Machine Weight	t	3.3		3.8		5		6.5		8.1		13		15	
料斗容积	Hopper Capacity	L	210		230		240		340		570		620		950	
油箱容积	Oil Tank Capacity	MM	250		290		310		330		420		450		480	

产品技术参数更改，恕不另行通知 / Due to comtinual improvement, specificationms are subject to change without notification

	规格	SPECIFICATION		HJK50		HJF100		HJK120		HJK128			HJF80		HJF118		
				A	B	A	B	A	B	A	B	C	A	B	A	B	C
注射装置 Injection Unit	螺杆直径	Screw Diameter	mm	28	32	35	38	40	42	40	42	45	32	36	35	38	40
	螺杆长径比	Screw L/D Ratio	L/D	20	17.5	20.1	18.5	20.5	19.8	20.7	19.7	18.4	21.5	19.8	23.9	22	20.9
	理论容量	Shot Size (Theoretical)	cm^3	63	82	135	158	175	190	220	248	278	101	123	154	181	201
	注射重量	Injection Weight(PS)	g	57	73	123	144	160	175	200	225	253	91.9	111	141	165	183
	注射速率	Injection Rate	g/s	55	66	76	90	95	100	102	110	125	70	82	80	95	105
	注射压力	Injection Pressure	Mpa	168	129	237	201	201	186	221	204	180	188	148.5	219	186	167
	螺杆转速	Screw Speed	rpm	0~175		0~220		0~220		0~220			0~220		0~220		
锁模装置 Clamping Unit	锁模力	Clamp Tonnage	kN	500		1000		1200		1280			800		1180		
	移模行程	Toggle Stroke	mm	240		305		318		360			275		340		
	拉杆内距	Space Between Tie Bars	mm	280 x 260		355 x 315		385 x 350		415 x 375			315 x 315		370 x 370		
	最大模厚	Max. Mold Height	mm	300		320		400		400			320		400		
	最小模厚	Min. Mold Height	mm	140		150		150		150			120		150		
	顶出行程	Ejector Stroke	mm	55		70		80		120			80		100		
	顶出力	Ejector Tonnage	kN	18		27		30		40			27		33		
其它 Others	最大油泵压力	Max. Pump Pressure	Mpa	16		16		16		16			16		16		
	油泵马达	Pump Motor Power	kW	5.5		9		11		11			9		11		
	电热功率	Heater Power	kW	3.1		5.3		5.5		6.3			5.3		6.5		
	外形尺寸	Machine Dimension(LxWxH)	m	2.6 x 0.75 x 1.38		3.58 x 1.25 x 1.65		4.0 x 1.36 x 1.72		4.4 x 1.36 x 1.8			3.5 x 1.2 x 1.6		4.2 x1.25 x 1.8		
	重　量	Machine Weight	t	1.5		2.7		3.6		3.8			3		3.5		
	油箱容积	Oil Tank Capacity	L	190		210		210		220			210		210		
	模板正面尺寸	Platen Dimensions Face															
	模板侧面尺寸	Mold space Dimensions															
	外型尺寸	Machine Dimensions															

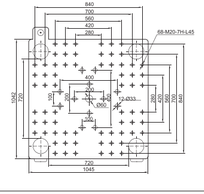
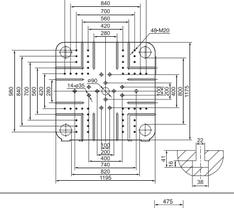
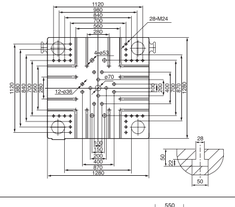
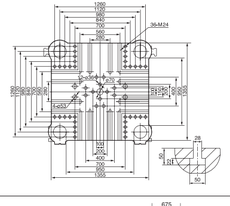
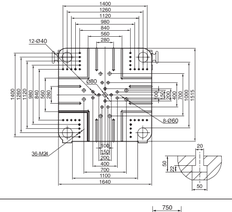
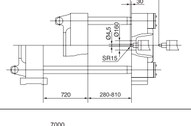
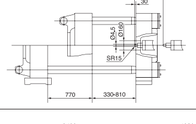
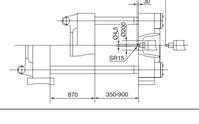
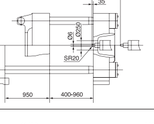
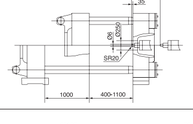
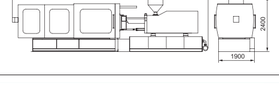
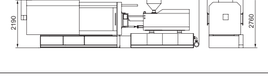
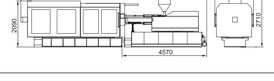
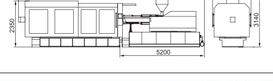
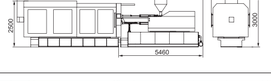
产品技术参数更改，恕不另行通知 / Due to comtinual improvement, specificationms are subject to change without notification

SPECIFICATIONS 产品规格

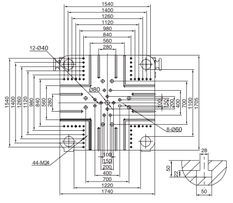
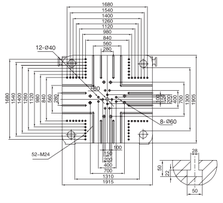
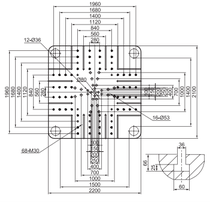
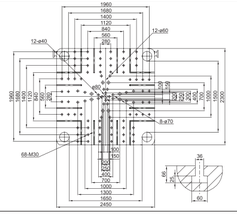
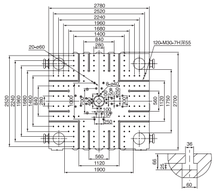
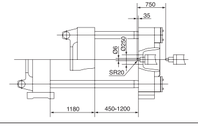
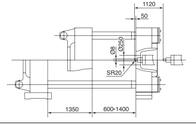
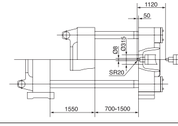
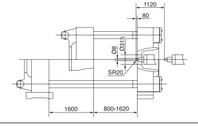
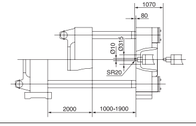
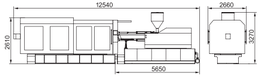
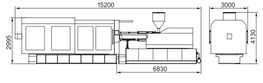
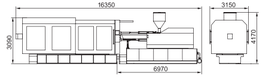
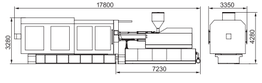
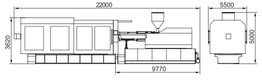
规格	SPECIFICATION		HJF140			HJF168			HJF240			HJF280			HJF360			
			A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	D
注射装置 Injection Unit	螺杆直径	Screw Diameter	mm	38	42	45	40	45	48	45	50	55	55	60	65	60	65	70	75
	螺杆长径比	Screw L/D Ratio	L/D	22.1	21.6	19.5	22.5	20	18.8	22.2	20	18.2	23.1	21	19.3	22.6	21.2	19.4	18.5
	理论容量	Shot Size (Theoretical)	cm^3	193	227	278	253	320	364	406	508	570	712	847	994.9	960	1128	1306	1480
	注射重量	Injection Weight(PS)	g	176	206	252	230	291	331	369	462	518	648	779.9	905	873	1026	1180	1346
	注射速率	Injection Rate	g/s	94	105	135	108	128	158	120	148	179	210	240	270	239	275	328	420
	注射压力	Injection Pressure	Mpa	205	159	140	202	159	140	216	180	160.8	205	168	143	213	183	160	146
	螺杆转速	Screw Speed	rpm	0~220			0~185			0~180			0~180			0~180			
锁模装置 Clamping Unit	锁模力	Clamp Tonnage	kN	1400			1680			2400			2800			3600			
	移模行程	Toggle Stroke	mm	380			430			470			540			670			
	拉杆内距	Space Between Tie Bars	mm	420 x 420			460 x 460			520 x 520			580 x 580			660 x 660			
	最大模厚	Max. Mold Height	mm	450			500			530			600			670			
	最小模厚	Min. Mold Height	mm	170			180			200			220			240			
	顶出行程	Ejector Stroke	mm	120			130			135			145			160			
	顶出力	Ejector Tonnage	kN	33			45			70			75			62			
其 它 Others	最大油泵压力	Max. Pump Pressure	Mpa	16			16			16			16			16			
	油泵马达	Pump Motor Power	kW	13			15			18.5			30			37			
	电热功率	Heater Power	kW	7.2			7.5			11.65			15			17.25			
	外形尺寸	Machine Dimension(LxWxH)	m	4.5 x1.2 x 1.7			5.1 x1.4 x 1.9			5.4 x1.5 x 2			6.0 x1.6 x 2.1			6.3 x1.9 x 2.4			
	重 量	Machine Weight	t	4.2			5.5			7			8.5			12.5			
	油箱容积	Oil Tank Capacity	L	230			240			340			570			620			
模板正面尺寸	Platen Dimensions Face																	
模板侧面尺寸	Mold space Dimensions																	
外型尺寸	Machine Dimensions																	

产品技术参数更改，恕不另行通知 / Due to comtinual improvement, specificationms are subject to change without notification

SPECIFICATIONS 产品规格

规格	SPECIFICATION		HJF400			HJF530				HJF650				HJF780				HJF1000			
			A	B	C	A	B	C	D	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	70	75	80	75	80	85	90	90	95	100	105	90	95	105	110	90	100	110	115
	螺杆长径比	Screw L/D Ratio	L/D	22	20.5	19.25	22.7	21	20	18.9	20	19	18	17.1	23.2	22	19.9	19	25.5	23	20.9	20
	理论容量	Shot Size (Theoretical)	cm^3	1286	1479	1683	1727	1965	2218	2487	2544	2835	3140	3461	2861	3188	3894	4273	2920	3610	4369	4778
	注射重量	Injection Weight(PS)	g	1170	1346	1532	1560	1788	2018	2266	2315	2580	2858	3149	2603	2901	3543	3888	2670	3300	3980	4325
	注射速率	Injection Rate	g/s	382	438	499	386	442	499	560	552	612	679	748	574	640	781	858	580	717	867	948
	注射压力	Injection Pressure	Mpa	200	174	155	191	168	148	132	184	165	149	135	195	175	143	130	216	176	146	133
	螺杆转速	Screw Speed	rpm	0~160			130				150				115				100			
锁模装置 Clamping Unit	锁模力	Clamp Tonnage	kN	4000			5300				6580				7800				10000			
	移模行程	Toggle Stroke	mm	720			770				870				950				1000			
	拉杆内距	Space Between Tie Bars	mm	720 x 720			820x800				870x870				980x950				1100x1000			
	最大模厚	Max. Mold Height	mm	810			810				900				960				1100			
	最小模厚	Min. Mold Height	mm	280			330				350				400				400			
	顶出行程	Ejector Stroke	mm	170			240				250				280				325			
	顶出力	Ejector Tonnage	kN	110			150				150				210				345			
其 它 Others	最大油泵压力	Max. Pump Pressure	Mpa	16			16				16				16				16			
	油泵马达	Pump Motor Power	kW	37			45				55				37+30				37+45			
	电热功率	Heater Power	kW	20			31.4				42.95				56.7				59			
	外形尺寸	Machine Dimension(LxWxH)	m	7 x1.9 x 2.4			8.4x1.92x2.76				10.2x2.24x2.71				11.43x2.40x3.14				12.1x2.64x3.00			
	重 量	Machine Weight	t	14.5			21				28				37				53			
	油箱容积	Oil Tank Capacity	L	950			900				1100				1200				1700			
模板正面尺寸	Platen Dimensions Face																				
模板侧面尺寸	Mold space Dimensions																				
外型尺寸	Machine Dimensions																				

产品技术参数更改，恕不另行通知 / Due to comtinual improvement, specificationms are subject to change without notification

规格	SPECIFICATION		HJF1200				HJF1400				HJF1660				HJF2000				HJF3000		
			A	B	C	D	A	B	C	D	A	B	C	D	A	B	C	D	A	B	C
注射装置 Injection Unit	螺杆直径	Screw Diameter	mm	110	115	120	125	110	120	130	140	120	130	140	150	130	140	150	160	180	210	220
	螺杆长径比	Screw L/D Ratio	L/D	23	22	21	20.2	25.7	24	22	20	25.4	23.4	21.7	18.9	25.9	24	22.4	20.9	24	24	22.9
	理论容量	Shot Size (Theoretical)	cm^3	5270	5760	6272	6805	6271	7463	8759	10158	7368	8759	10159	11662	9460	11238	12900	14678	29390	40003	43904
	注射重量	Injection Weight(PS)	g	4796	5242	5707	6193	5706	6791	7970	9243	6704	7970	9244	10612	8608	10226	11739	13356	26745	36402	39953
	注射速率	Injection Rate	g/s	793	867	944	1024	815	970	1138	1320	1056	1240	1438	1650	1172	1360	1560	1776	1468	2000	2200
	注射压力	Injection Pressure	Mpa	186	170	156	144	208	175	150	129	195	165	145	126	190	163	142	125	210	155	141
	螺杆转速	Screw Speed	rpm	90				90				85				70				50		
锁模装置 Clamping Unit	锁模力	Clamp Tonnage	kN	12000				14000				16600				20000				30000		
	移模行程	Toggle Stroke	mm	1180				1350				1550				1600				2000		
	拉杆内距	Space Between Tie Bars	mm	1220x1100				1310x1300				1500x1400				1650x1500				1900x1750		
	最大模厚	Max. Mold Height	mm	1200				1400				1500				1620				1900		
	最小模厚	Min. Mold Height	mm	450				600				700				800				1000		
	顶出行程	Ejector Stroke	mm	325				360				420				420				450		
	顶出力	Ejector Tonnage	kN	245				260				420				490				565		
其它 Others	最大油泵压力	Max. Pump Pressure	Mpa	16				16				17.5				16.5				16		
	油泵马达	Pump Motor Power	kW	45+55				55+55				45+45+45				45+55+55				55+55+55+55		
	电热功率	Heater Power	kW	66.1				86				94.9				110.7				177		
	外形尺寸	Machine Dimension(LxWxH)	m	12.54x2.66x3.27				15.2x3.00x4.13				16.35x3.15x4.17				17.80x3.35x4.28				22.00x5.50x5.00		
	重　量	Machine Weight	t	60				90				125				156				220		
	油箱容积	Oil Tank Capacity	L	2100				2900				3000				3700				4500		
模板正面尺寸	Platen Dimensions Face																				
模板侧面尺寸	Mold space Dimensions																				
外型尺寸	Machine Dimensions																				

Configuration options Standard 配 置

Standard Features
标准装置

> Balanced double cylinder injection system > 双缸平衡平衡式注射系统
> Multi-stage pressure & speed injection > 多级压力、多级速度注射
> Back-pressure adjustent dvice > 背压调节装置
> Screw back > 倒索
> High-speed clamlping > 高速闭模
> Low-pressure dwelling > 低压模保
> Multiple hydraulic ejector knock-out > 多种液压顶出方式
> Mechanical, electrric and safety device > 机械、电气、安全装置
> Lubricating system > 润滑系统
> Oil pressrue full proportional control > 油压安全比例控制
> Control all computer > 全电脑控制
> Mould memory system > 模具记忆系统

Standard Accessory
标准配件

> Mechanical shockoroof pad > 机械防震脚垫
> Spare parts > 备用零件
> Toolbox > 工具箱
> Elucidation book > 说明书

Optional Features
选择装置

> Oil pump driven by frequency conversion motor > 变频电机驱动油泵
> Oil pump driven by frequency servo motor > 司法电机油泵
> Motor driven proportional valve > 电机驱动比例泵
> Screw plastification directly driven by servo motor > 伺服电机直接驱动螺杆塑化
> Manipulator > 机械手
> Thermoset plastic injection > 热固性塑料注射
> PVC injection > PVC 注射
> BMC injection > BMC 注射
> Wearble screw > 耐磨螺杆

Optional Accessory
选择配件

> Air ejector > 起顶
> Magnetic stand > 磁力架
> The mould press board opening of hydraulic > 模具压板液压
> motor drive > 旋转脱模
> Cool water machine > 冷水机
> Damp remover > 塑料除湿机
> Mould temperature cotroller > 模温控制机
> Automatic color meter regulator > 自动加色计量器
> Dry feeder > 干燥料斗
> Automatic feeder > 自动上料机器

The form of plastic and barrd temperature established
塑料、料筒温度设定

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 Barrel Temperature					
						喷嘴 Nozzle		中段 Middle		尾段 End	
				最小值 Min	最大值 Max	最小值 Min	最大值 Max	最小值 Min	最大值 Max	最小值 Min	最大值 Max
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	0.1-1.5	10	60	170	220	160	295	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	1.3	230	0.5	40	75	180	200	170	290	150	180
PC	1.2	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

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。

It is every relation between temperature of the material tube and plastic parameter to make the form, this form is only for reference actual temperature will be established according to the long time use experience.

Note 注意

- When PC(polycarbonate), PVC and other plastic mate used for engineering are planned for molding it is necessary to inform us for special designation
- Due to continual improvement, specifications are subject to change without notification
- There is more detailed documentation for your availability in addition to above specification
- The machine pictures are for your visual reference, may have trivial difference from the actua machines

– 当您有成型 PC、PVC 等工程塑料制品的计划，请让我们知道
– 正常情况下改善技术规格参数，不予以另行通知
– 除了上述表格中技术规格参数以外，尚需更详细的资料请垂询
– 产品照片仅供参考，与出售实物略有不同

Remarks 说明

- Theoretical shot volume=(screw cylinder cross section) x (screw stroke)
- The injection shot weight should be 92% of the theoretical shot volume for polystyren(ps)
- The plasticization capacity and injection rate are the values for polystyrene(PS)

– 含理论注射容量二（注塑机）料筒截面积 x 螺杆行程
– 含注射重量为 PS 理论容量的 92%
– 含塑化能力、注射速率为 PS 值