



Full Auto Hydraulic Servo Blow Molding Machine

一、Characteristics Of The Machine constituent part

electronic system	PLC computer plus man-machine interface control, touch operation screen operation.	
hydraulic system	Hydraulic main system adopts professional servo oil pump control, fast, Output precision, steady.	
scavenger system	Double filtration、Regulating air system, Keep the air path clean 、 pressure stability 、 Equipped with maintenance-free solenoid valve for more durability.	
Needle blowing system	It can be selected up, down and side needle blowing according to the actual needs of customers' actual production of molds, At the same time, it has the function of propping and sealing. .	
Opening and closing die system	The mode-locking sliding mechanism adopts ball linear guide rail , Opening and closing die full stroke positioning accuracy is high、easy、energy conservation. Large clamping force、fast、operate steadily.	
Die head system	Using blow molding machine professional die head, upper materials are precisely machined and heat treated, Rapid heating and stable temperature、even.	
Extrusion system	Drive combination	inverter motor+Hard face deceleration, can make the crew change speed.
	Plasticizing screw	draw ratio of screw 25: 1, It can process many kinds of materials , Strong plasticizing ability, high output, low energy consumption.
	temperature control	PID controller, Can be set with touch screen、Modifying temperature parameters is quick and convenient. High measurement accuracy、Precise temperature difference control、long service life.

二、Technical Parameter Of The Machine

Die head



CANGZHOU YATAI COMMERCIAL AND TRADE CO.LTD

Number of dies	1	Customized according to the product (individual shopping)
Station		
Station number	Double Station	
Opening and closing die		
size of die platen	undetermined	Related to product specifications
clamping force	50KN	
Minimum opening distance of template	200mm	
Extruder		
Screw diameter	Φ 80 mm	
draw ratio	25 : 1	
Skein motor	22KW	
frequency changer	22KW	
Reducer (Jiangsu)	Use the 146-type full-hard tooth surface plastic extruder special reducer.	
Amount of plasticization	80-100kg/H	
heating method	Mica heating ring + cast aluminum fan constant temperature	
Heat the warm zone	7-12 temperature zone	
Hydraulic system		
servo driver	Taiwan taida	
servo motor	Yunsheng motor	
Servo motor power	15KW	
pressure sensor	German Wica	
Cylinder specification	HOB high pressure 100*400mm National s oil cylinder	
Oil cooling water	Independent waterway	
Oil temperature and	Actual tank observation	



CANGZHOU YATAI COMMERCIAL AND TRADE CO.LTD

oil level control		
Pneumatic system		
working air pressure	0.3-0.6MPA	
Gas consumption	0.5m ³ /min	
pneumatic element	China's first brand	
Blow the die head	exist	
fast drain system	exist	increase production
Control system		
PLC controller	Mitsubishi, Japanese	
operation interface	touch screen	
Electrical apparatus element		
power supply	380V(three-phase four-wire system)	
breaker	Zhejiang zhengtai	
average power	About 25KW	
Heating control		
temperature controller	smart thermostat	
heating element	solid state relay	
Type of electric couple	type K	
temperature control	exist	
Leakage alarm	exist	
preheat function	exist	
Other		
Maintenance system	Intelligent maintenance	
Machine cooling water	exist	
Mold cooling water	exist	
Compressed air consumption	/	
1 set of mold core mold sleeve	Customized according to customer product needs	
Size and weight		
Size of machine	undetermined	
Weight	4T	

Specific data according to the production process requirements

Outstanding Feature Of The Machine

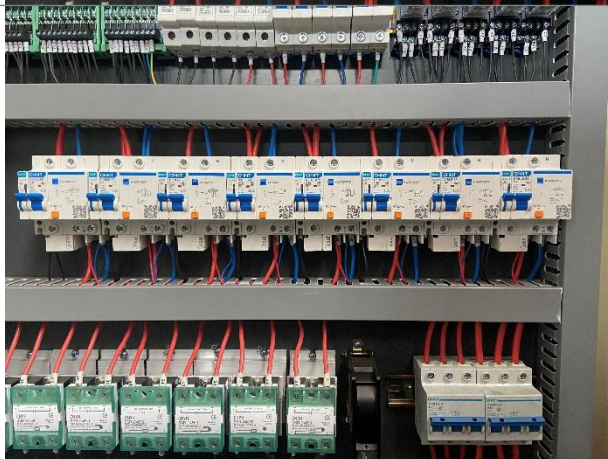
Machine picture	product introduction
	Advanced design, rational construction, Safe and reliable machine、durable, Beautiful and simple appearance, The boom type electric box is used, Easy to operate machine。
	Man-machine interface control adopted domestic famous brand <u>MCGS(昆仑通态)</u> touch screen, color display, Sensitive to touch, Fast response speed, Screen setting temperature.
	The control system adopts microcomputer control system (PLC), All process Settings、change、search、Monitoring fault diagnosis, etc. All on the touch screen, And the program response speed is fast, Millisecond level.



The layout of the electric box is reasonable, High power and low power are independent. It can effectively protect electronic components, It is easy to check the line during production.



This machine adoptXMTN-800series Loop independent self-tuning PID controller, can be set with touch screen、Modifying Temperature parameters quick and convenient。It has the advantages of high measurement accuracy, precise temperature difference control and long service life.



The leakage protector is equipped with auxiliary contact, with leakage alarm function, can quickly check the leakage temperature zone, solve the problem. Improve maintenance efficiency.



Solid state relay It is used for extruder heating element.
Has a long service life, no noise.



Hydraulic system adopts proportional pressure control, stable and reliable



Domestic well-known inverter has energy saving and high efficiency Adjustable by 0 ~ 50Hz frequency conversion.



Oil pump adopts professional servo oil pump control, pressure、rate of flow double proportional control, computer parameter setting, operate steadily.

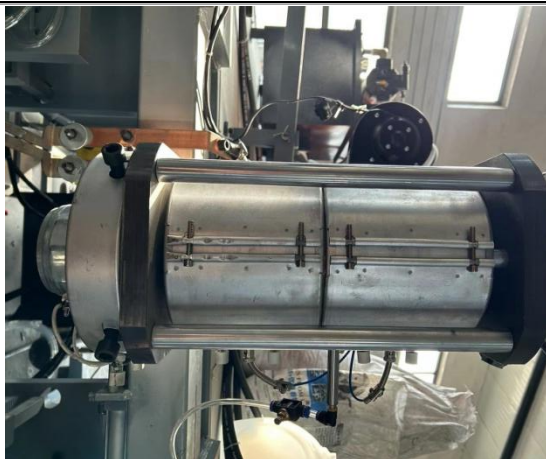


Special Guomao hard gear reducer, With brand large torque vector inverter, Smooth transmission、low noise、Reliable and durable.

The mode shifting system adopts the translation mode mechanism , high precision 、 Low resistance,high speed , And special mold reducer valve 、 No impact. Accurate positioning.



Adopt bending elbow locking system, low energy consumption、Central mode-locking, Large clamping force、Non-expanding die、Fast and smooth operation



Using Zhangjiagang Center feed die advantages: Make the product thickness more uniform, It's very easy to change colors



Barrel screw selected Zhoushan 38CrMOALA, tempering, Nitriding screw. Large length warp ratio screw, It can process many kinds of materials, Strong plasticizing ability, high output, low energy consumption. Barrel temperature is controlled by computer, Rapid heating, stable and uniform temperature.



Air pressure alarm sensor. Equipped with compressed air storage, Separation of oil, water and dust, ensure the stability and durability of the pneumatic system.