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Designed by Yizumi in August 2018

YIZUMI 伊之密

D1

D1 Series Two-platen Injection Molding Machine

(500T-2400T)

广东伊之密精密注压科技有限公司
Guangdong Yizumi Precision Injection Molding and Die Casting Technology Co., Ltd.

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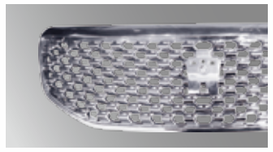
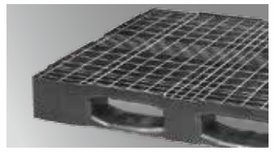
Based on importation and absorption of advanced German technology and years of experience in product application, we continue to move on and undertake the historic project of large-tonnage two-platen injection molding machine, striving to become a pioneer to fulfill such an innovative mission.

Deep-cavity parts

Household appliances



Auto parts



Logistics materials

Core Value Propositions

Fast

Synchronized lock nut mechanism, precision movable platen supports, quick hydraulic cylinders, differential fast mold opening, low-resistance hydraulic circuit design and high-response servo system enable the machine to operate more efficiently and response faster.

Stable

High-rigidity clamping unit, uniform stress distribution on tie bar threads, high-response dual proportional valve, high-speed closed-loop control, precision filter and efficient cooling system enable the machine to be more stable for injection molding.

Higher stability of mold-open position

Variation up to ±0.2mm, meeting higher requirements on automated part removal and inserting.

Shorter dry cycle

Compared with a three-platen machine with the same clamp tonnage, mold opening and closing during dry cycle is about 55% faster.

More reliable low pressure mold protection

Mold protection is so sensitive that it can sense three pieces of A4 paper, which is more effective.

Outstanding injection stability

Repeatability of part weight ⩽ 3‰ , excellent quality, saving materials and costs.

Smaller footprint

D1 series machine occupies less floor space than a three-platen machine, improving factory utilization and reducing costs of production facilities.

Smaller variation of force on tie bar

Variation⩽3% , high mold-close accuracy, hardly any flash, higher stability of injection molding.

Professional control system

Short scan time, fast response and high movement repeatability.

New-generation servo system driven by fully oil-cooled two-headed motor

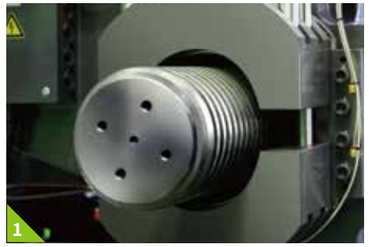
Fast response, strong power and low energy consumption.

Data above are reference criterions for factory tests.

Clamping Unit

Short dry cycle, reliable and stable

D1 series two-platen injection molding machine, based on high-rigidity clamping unit, precision guide device, synchronized lock nut mechanism, quick hydraulic cylinders, fast control system and controlled by high-response dual proportional valve, delivers higher movement efficiency and control stability.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①Impact-proof synchronized lock nut mechanism

Impact-cushioning synchronized lock nut closing is fast and more reliable.

②Independent high-pressure cylinder（optional）

Mold opening under low speed and high pressure, as well as mold change through tie bar pulling in a factory with excessively low ceiling are available.

③Highly-rigid accurate guide device

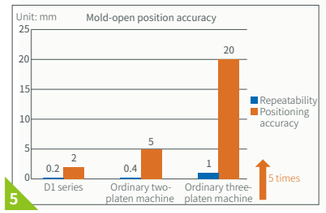
High-rigidity L-shape guide rails on machine frame, with guiding precision up to 0.05mm, facilitate fast and steady motion of platens.

④Wear & corrosion resistant tie bars with uniform stress distribution

With special technical treatment, tie bars are highly-rigid and resistant to wear and corrosion. Uniformity of stress distributed on tie bar threads is over 99% without unbalanced force, bringing durability.

⑤High repeatability of mold-open end position

Repeatability of mold-open position is up to ± 0.2mm, five times higher than that of a three-platen machine. (proven by in-house 1300T machine test result)



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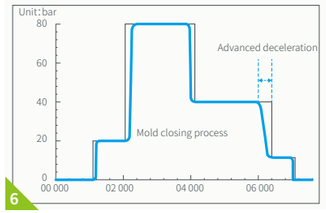
⑥Sensitive mold protection

With the use of smart prior deceleration control, even three pieces of A4 paper can be sensed. Mold protection is more reliable and sensitive.



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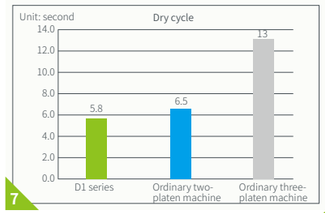
⑦Short dry cycle

Efficient mold opening and closing and short dry cycle directly improve manufacturing efficiency and capacity. (proven by in-house 1300T machine test result)



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Injection Unit

Stable injection end position and high repeatability of part weight

Linear guide rails, with the benefits of low resistance and quick acceleration, are a standard feature of D1 series two-platen injection molding machine. Incorporating other features, such as high-rigidity injection unit and ultrasonic displacement sensor for monitoring, D1 series has achieved accurate position control and high repeatability of part weight.

①High-rigidity injection unit

Casts of injection unit are made from ductile cast iron. The platens are highly rigid with little deformation. Injection is more stable.

②Excellent injection performance

Repeatability of injection end position up to ±0.2mm and repeatability of part weight ⩽ 3‰ meet the needs of increasing efficiency and lowering costs.

③Integral linear guide rails for injection

Linear guide rails are a standard feature of D1 series, bringing benefits of low resistance, quick acceleration and accurate injection.

④Ultrasonic displacement sensor

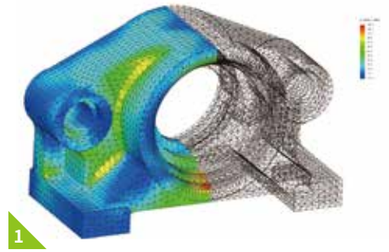
D1 series is equipped with an ultrasonic digital displacement sensor, characterized by little signal interference and high position control accuracy.

⑤Adaptive PID temperature control

With the use of durable ceramic heater bands and adaptive PID control performed by the Austrian controller, temperature control accuracy is up to ±1°C.

⑥Optional quick barrel change mechanism

Barrel is mounted with a press plate and it can be directed hoisted for installation, which lowers labor intensity and enhances maintenance efficiency.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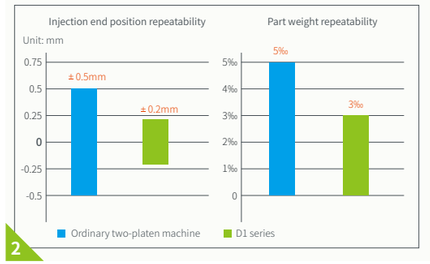

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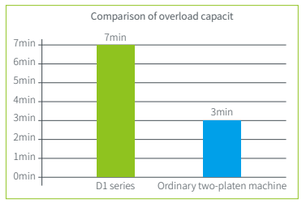
Hydraulic System

Precise filtration, efficient cooling, higher stability

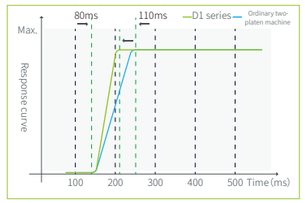
D1 series is based on a hydraulic system with stability and fast response at the core, which enables hydraulic circuit to be in optimal operating conditions. The hydraulic system is characterized by fast response, strong overload capacity and low energy consumption that is superior to China energy efficiency grade 1.

①Servo system driven by fully oil-cooled two-headed motor

The fully oil-cooled two-headed motor-driven servo system is the quintessence of highly-integrated servo pump system. It eliminates the influence of instability in machine operation due to the work environment and further reduces energy consumption of hydraulic circuit. Synchronized drive technology makes hydraulic circuit response faster and movements more efficient.



Strong overload capacity



Rapid acceleration

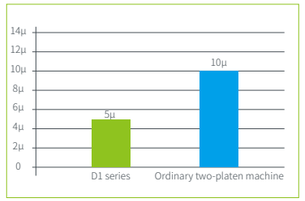
Durable and reliable

②Precise filtration and independent cooling system

Filter fineness is up to 5μm and cooling effect is 2-3 times better than ordinary two-platen injection molding machines, which ensure long service life of seals. Machine becomes more stable.

Good cooling effect

High filter fineness



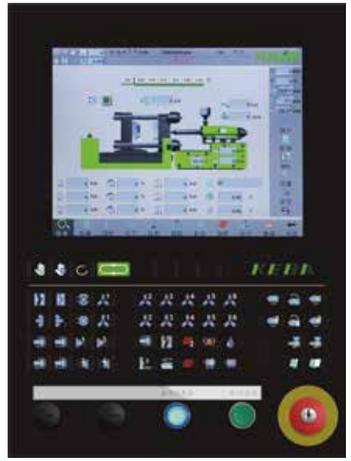
Comparison of filter fineness

③Motor protected with L-shape plates

L-shape plates are easy to install and they can be opened directly so that there is open space for more efficient maintenance of the drive system.

Control System

Accurate control, humanized design, reliable and stable



D1 series adopts Austria's KEBA control system dedicated to two-platen injection molding machine. This powerful system can accurately control the position, pressure, speed, temperature and other parameters. The whole control system is engineered based on reliability, stability, safety and user-friendly operation for better user experience.

Stable, fast and accurate control

- D1 series two-platen injection molding machine adopts Austria's KEBA control system, with double CPUs, 1ms of scan cycle and high reliability.
- Fast mold opening and closing and high repeatability thanks to the high-response dual proportional valve control technology.
- Fully-closed-loop control of injection speed, pressure and back pressure, with fast response and high accuracy.
- Self-tuning of temperature parameters of barrel and hot runner makes temperature control more accurate.

Data and safety

- Storage of process data without limit
- Memory of alarm and process parameter change
- Record of process parameter change curve
- Production process data control (PDP) and statistic process control (SPC)
- Multi-level user access to protect data
- Multiple protections of equipment and people through software and hardware

Easy to operate

- Real-time remote control（optional）
- Online conversion of languages and units
- Quick input by means of graph and virtual keyboard
- Quick settings page for easy and convenient process parameter setting

①IP54 electrical enclosure

The electrical enclosure is designed with IP54 rating, resistance to water and dust and good cooling effect, so that the electrical system is more stable in operation.

②Separate connector module for auxiliary equipment

External separate power control without opening the electrical cabinet makes operation safer and more convenient.

③Euromap-based robot interface

Euromap 12 robot interface is a standard feature, meeting customer' s need for safer connection.

Main Part List

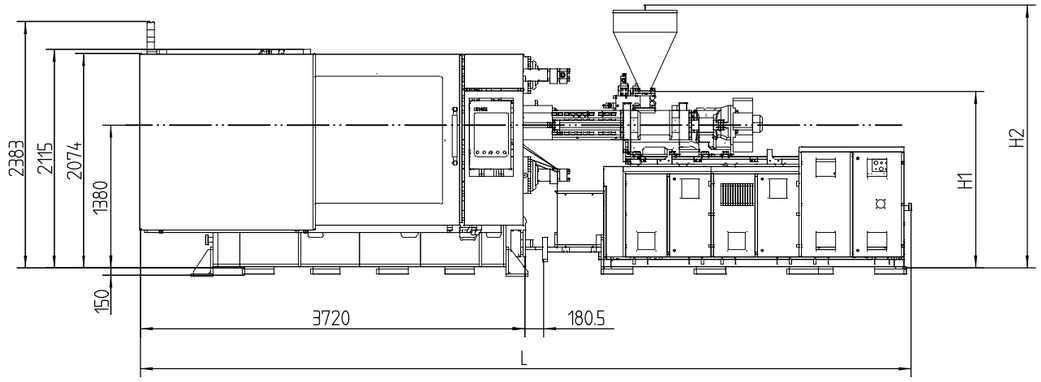
(Standard) Part Name	Brand/Specifications	Place of Brand
Control system	KEBA	Austria
Oil seal	SKF	Sweden
Guide ring	SKF	Sweden
Directional valve	Rexroth/ YUKEN/Atos	Germany/Japan/Italy
Proportional relief valve	YUKEN/ Hydraulik Power	Japan/Taiwan
High-response proportional valve	Rexroth	Germany
Shaft seal cartridge valve	Rexroth	Germany
Cartridge type electromagnetic ball valve	HYDAC	Germany
Variable piston pump	Rexroth	Germany
Pressure sensor	Danfoss	Denmark
Magnetostrictive displacement sensor	Germanjet	Germany
Gear pump	SUMITOMO/ Eckerle	Japan/Germany
Servo motor	PHASE	Italy
Barrel assembly	HAYEUR	China
Hydraulic motor	PKL	China
Tie bar	Hua Xiang	China
Tie bar locking nut	Hua Xiang	China
Clamping piston	Hua Xiang	China
Clamping cylinder cover	Zhong Tian/ QSQY	China
Platen	Zhong Tian/ QSQY	China
Servo drive	PHASE	Italy
Solid state relay	KUDOM	UK
Automatic switch	ABB	Switzerland
Air switch	FUJI	Japan
Position limit switch	SCHMERSAL/ Schneider/ Panasonic	Germany/France/Japan
Proximity switch	AUTONICS	Korea
AC contractor	FUJI	Japan

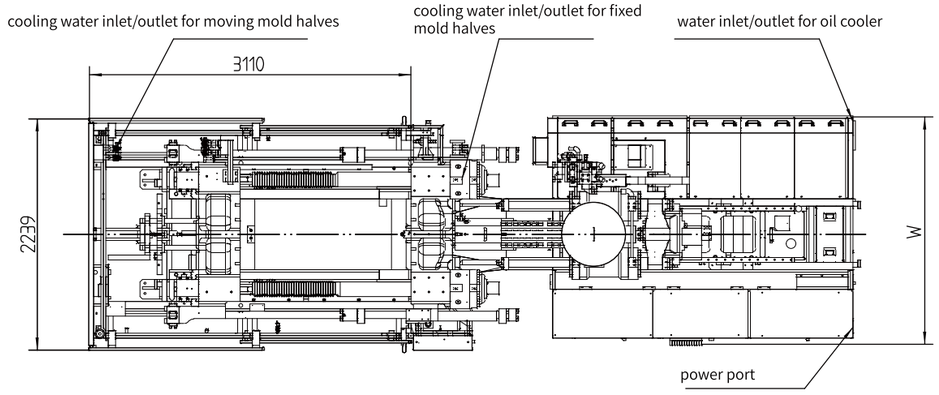
Standard & Optional Features

	Standard	Optional
● Clamping Unit		
Clamping mechanism with tie bars independent of moving platen	●	
Quantitative volumetric automatic lubrication system	●	
High-response proportional control of pressure and flow for mold open & mold close	●	
Hydraulically-driven ejection device	●	
Low-pressure mold protection	●	
Clamping force adjustment as needed	●	
Forced reset function	●	
Ejector return protection	●	
Robot mounting hole (Euromap 18)	●	
T-slot platen	●	
Four clamp platens made of high-rigidity ductile iron	●	
Hydraulic and electrical safety devices	●	
Safety foot plate in mold area (unavailable to UN900D1 and smaller models)	●	
High-accuracy magnetostrictive displacement sensor for mold open/close control	●	
Safety foot plate in front & rear door areas		○
Synchronous ejection and core pulling		○
Secondary mold closing		○
Quick mold change system platform		○
Hydraulic mold clamp		○
Magnetic platen		○
Increased mold thickness		○
Increased ejector stroke		○
Mold lifting device		○
Heat insulating plate of mold		○
Special mold mounting hole		○
Increased mold opening stroke		○
Larger ejection force		○
● Electrical system		
Closed-loop PID barrel temperature control	●	
Manual, semi-auto and fully-auto operating mode	●	
Input and output inspection interface	●	
Automatic display of alarm messages and acousto-optic alarm system	●	
Built-in software with the oscilloscope function	●	
Unlimited technical parameter storage	●	
Automatic mold height adjustment	●	
Chinese and English operating system	●	
Safety gate emergency stop function	●	
Online cycle monitoring	●	
12’’ TFT color touch screen	●	
Visualized graphic programming	●	
PDP interface	●	
Injection monitoring protection	●	
Mold-close monitoring protection	●	
Statistical process control (SPC) interface	●	
Electrical enclosure rated IP54	●	
Screw speed detecting device	●	
Time/ position/ time + position control modes for switchover to holding phase	●	
Protective plate in mold area	●	
3 sets of 380V 32A socket (2 sets for 500T-900T machines)	●	
A sets of 380V 16A socket (2 sets for 500T-900T machines)	●	
16-level password security	●	
Reserved robot interfaces based on SPI, EUROMAP 12	●	
Automatic heat preserving, automatic heating settings	●	
Servo injection		○
Electric unscrewing device		○
Hot runner interface		○
Auxiliary emergency stop button		○
Air blast in mold		○
Power supply change		○
Central (networked) monitoring system		○

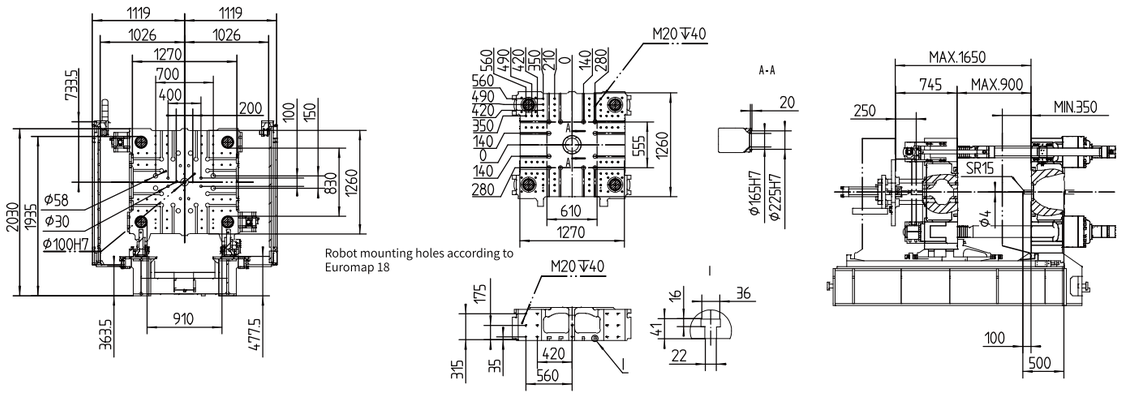
	Standard	Optional
Protective light grid of safety gates		○
Opto-electronic safety switch of front and rear safety gates		○
Protective light grid of central safety foot plate		○
● Injection unit		
Double parallel cylinder injection unit with low-speed high-torque hydraulic motor	●	
Nitrided alloy steel screw & barrel	●	
Heat preservation cover for barrel and purge guard (with electrical protection)	●	
Selectable suck-back before or after plasticizing	●	
10-stage injection speed/ pressure/ position control	●	
10-stage holding speed/ pressure/ position/ time control	●	
5-stage plasticizing speed/ pressure/ position control	●	
Linear guides for injection unit	●	
Double-carriage cylinder	●	
Cold start protection	●	
Manual central lubrication system of injection unit	●	
Suck back function	●	
Automatic purging	●	
Screw rotation measuring device	●	
Mixing screw		○
Bi-metallic screw barrel		○
Swivelling injection unit		○
Extended nozzle (50/100/150/200mm longer)		○
Special screw components		○
Energy-saving barrel heat retaining device (silicone cover)		○
Spring shut-off nozzle		○
Increased injection stroke		○
● Hydraulic system		
Low-noise energy-saving hydraulic circuit	●	
Proportional back pressure control for plasticizing	●	
Oil pre-heating system	●	
2 sets of core pull (4 sets for UN2100D1 and larger models)	●	
Differential mold-open circuit	●	
Injection and mold-close pressure protection	●	
High-pressure mold opening	●	
Automatic pressure and flow calibration	●	
Oil temperature and oil level alarm	●	
High-performance servo pump system	●	
Multiple sets of sequence (injection) valve interface		○
Variable displacement pump system		○
Closed-loop proportional variable displacement pump system		○
High-response accumulating servo injection system		○
Enlarged oil cooler		○
Multi-capacity larger pump motor		○
Multi-capacity larger plasticizing motor		○
Servo injection (closed-loop control of injection, plasticizing, holding pressure and back pressure)		○
Plasticizing during mold opening		○
Multiple sets of core pull or unscrewing devices with electrical interfaces		○
● Other		
User manual	●	
Adjustable leveling pad	●	
8-in 8-out water manifold on movable platen (with quick connectors)	●	
Nozzle spanner	●	
Mold clamp	●	
Hopper (standard on UN900D1 and smaller models)		○
Hydraulic oil (standard on UN1400D1 and smaller models)		○
Loading platform		○
Mold temperature controller		○
Automatic loader		○
Dehumidification dryer		○

UN500D1 Machine Dimensions





UN500D1 Platen Dimensions



Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN500D1-IU1885	SR10	Φ3.5	7400	1687	2455	2198	70	161.46	8	(8+8)×11	150	3~4	5~6
UN500D1-IU2695	SR15	Φ4	7500	1707	2560	2198	70	176.74	8	(8+8)×11	150	3~4	5~6
UN500D1-IU3330	SR15	Φ4	7500	1707	2600	2198	70	186.89	8	(8+8)×11	150	3~4	5~6
UN500D1-IU4800	SR15	Φ4.5	7800	1971	2630	2198	70	215.49	8	(8+8)×11	150	3~4	5~6

UN500D1 Specifications

Injection Unit												
Model	**IU1885**			**IU2695**			**IU3330**			**IU4800**		
Screw diameter （mm）	60	68	76	68	76	84	76	84	92	84	92	108
Shot volume (cm^3)	834	1071	1338	1198	1497	1829	1678	2050	2460	2217	2659	3664
Shot weight（g）	767	986	1231	1103	1377	1683	1544	1886	2263	2039	2446	3371
Injection pressure （MPa）	226	176	141	225	180	147	199	162	136	218	181	131
L/D ratio	22.6	20	20	22.3	20	20	22.1	20	20	21.9	20	20
Injection rate (cm^3/s)	322	414	517	383	478	584	430	526	632	516	619	853
Max.injection speed (mm/s)	114			105			95			93		
Screw stroke (mm)	295			330			370			400		
Max.screw speed (r/min)	250			184			147			154		
Barrel heating zone (PCS)	5			6			6			6		
Clamping Unit												
Clamping force（kN）	5000											
Opening force （kN）	390											
Platen size (mm)	1270X1260											
Space between tie bars（mm）	910X830											
Max. mold thickness（mm）	900											
Min. mold thickness（mm）	350											
Opening stroke （mm）	1300/750											
Max. daylight（mm）	1650											
Ejector force（KN）	110											
Ejector stroke（mm）	250											
Ejector number (PCS)	21											
Power Unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	55.6+7.5			65+7.5			60+7.5			66+7.5		
Total power（kW）	85.3	85.3	87.7	93.9	93.9	98.4	100.6	100.6	103.7	111.3	111.3	120.5
Heater power (kW)	22.2	22.2	24.6	26.4	26.4	30.9	33.1	33.1	36.2	37.82	37.82	47
General												
Oil tank capacity （L）	650			750			750			1000		
Machine dimensions（m）	7.4X2.3X2.5			7.5X2.3X2.6			7.5X2.3X2.6			7.8X2.3X2.6		
Machine weight (injection+clamping units, no oil)（T）	12+4			12+5			12+5.5			12+6.5		
Max. mold weight（T）	8			8			8			8		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

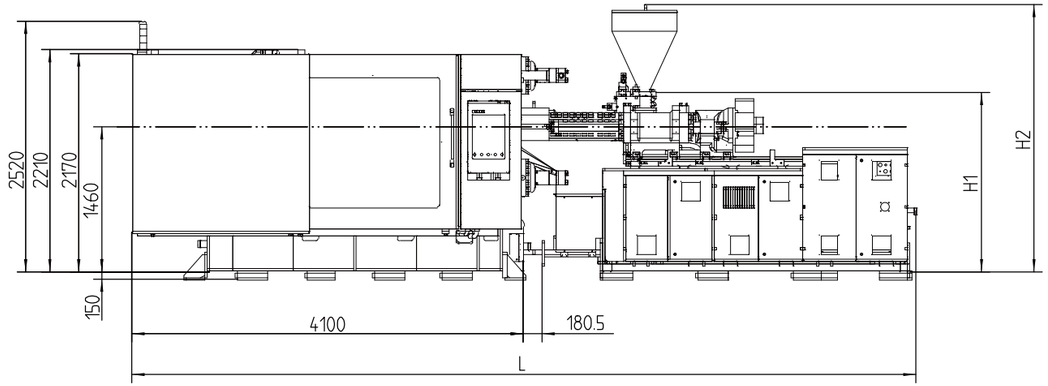
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

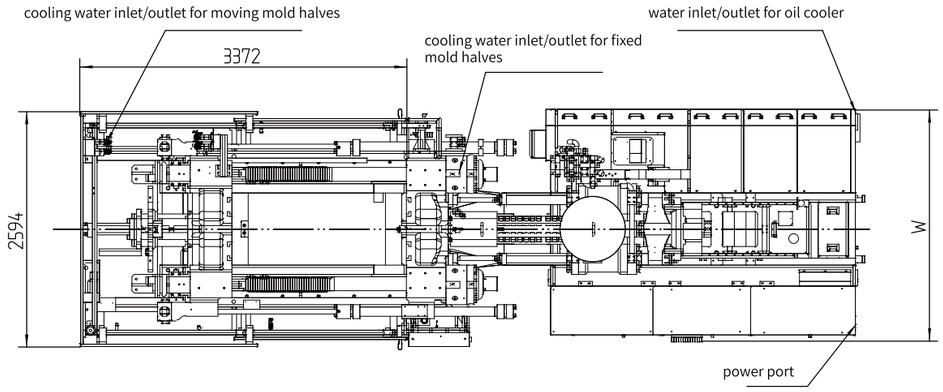
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

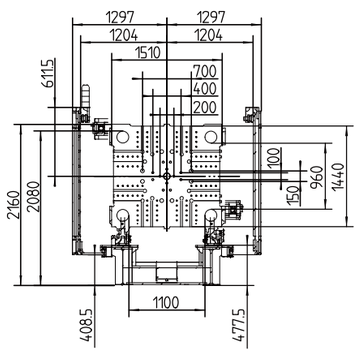
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

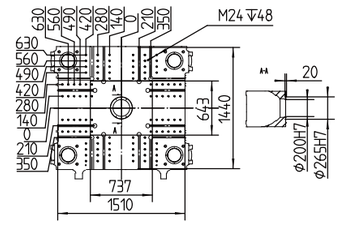
UN700D1 Machine Dimensions



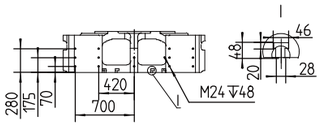


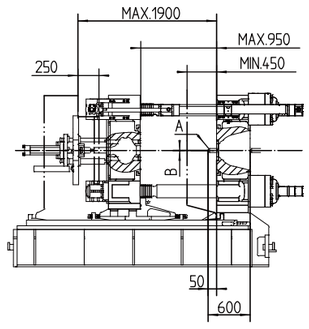
UN700D1 Platen Dimensions





Robot mounting holes according to Euromap 18





Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN700D1-IU2695	SR15	Φ4	7800	1740	2600	2198	70	176.74	8	(8+8)×11	150	3~4	5~6
UN700D1-IU3330	SR15	Φ4	7800	1740	2630	2198	70	186.89	8	(8+8)×11	150	3~4	5~6
UN700D1-IU4800	SR15	Φ4.5	9000	1818	2660	2198	70	215.49	8	(8+8)×11	150	3~4	5~6
UN700D1-IU6800	SR15	Φ4.5	9000	1991	2850	2198	95	259.84	8	(8+8)×11	150	3~4	5~6

UN700D1 Specifications

Injection Unit												
Model	**IU2695**			**IU3330**			**IU4800**			**IU6800**		
Screw diameter （mm）	68	76	84	76	84	92	84	92	108	92	100	116
Shot volume (cm^3)	1198	1497	1829	1678	2050	2460	2217	2659	3664	3191	3770	5073
Shot weight（g）	1103	1377	1683	1544	1886	2263	2039	2446	3371	2936	3468	4667
Injection pressure （MPa）	225	180	147	199	162	136	218	181	131	213	180	134
L/D ratio	22.3	20	20	22.1	20	20	21.9	20	20	21.7	20	20
Injection rate (cm^3/s)	383	478	584	430	526	632	516	619	853	615	726	980
Max.injection speed (mm/s)	105			95			93			92.5		
Screw stroke (mm)	330			370			400			480		
Max.screw speed (r/min)	184			147			154			145		
Barrel heating zone (PCS)	6			6			6			7		
Clamping Unit												
Clamping force（kN）	7000											
Opening force （kN）	500											
Platen size (mm)	1510X1440											
Space between tie bars（mm）	1100X960											
Max. mold thickness（mm）	950											
Min. mold thickness（mm）	450											
Opening stroke （mm）	1450/950											
Max. daylight（mm）	1900											
Ejector force（KN）	110											
Ejector stroke（mm）	250											
Ejector number (PCS)	21											
Power unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	60+7.5			60+7.5			66+7.5			89+7.5		
Total power（kW）	93.9	93.9	98.4	100.6	100.6	103.7	111.3	111.3	120.5	138.5	138.5	147.5
Heater power (kW)	26.4	26.4	30.9	33.1	33.1	36.2	37.82	37.82	47	42	42	51
General												
Oil tank capacity （L）	750			750			1000			1150		
Machine dimensions（m）	7.8X3X2.6			7.8X3X2.6			9X3X2.7			9X3X2.9		
Machine weight (injection+clamping units, no oil)（T）	16+5			16+5.5			16+6.5			16+8.5		
Max. mold weight（T）	11			11			11			11		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

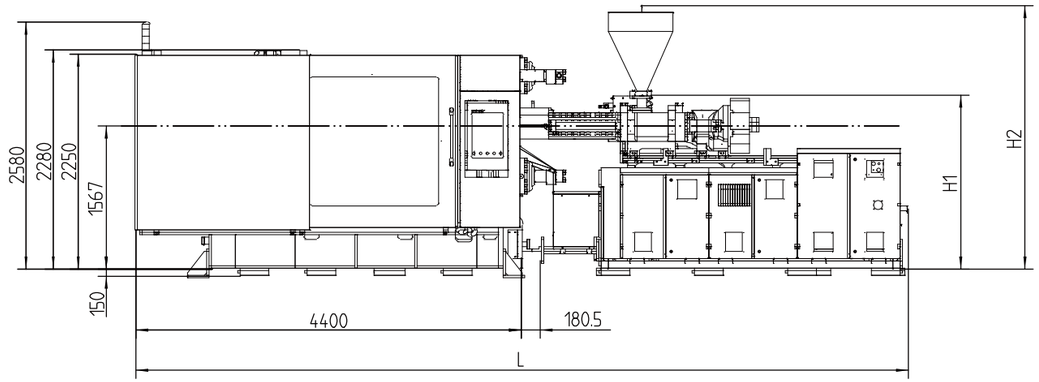
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

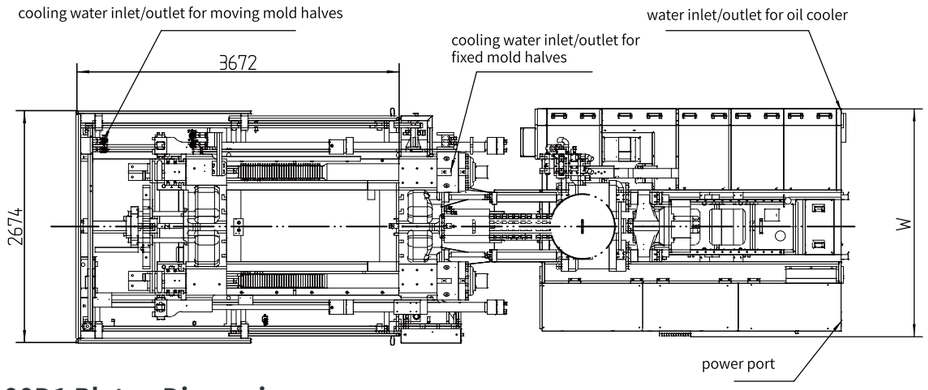
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

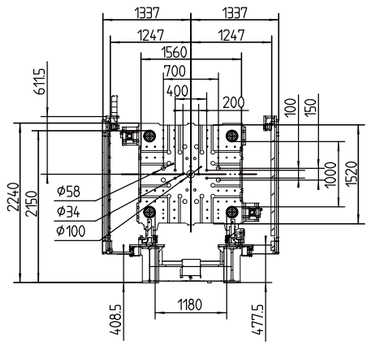
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

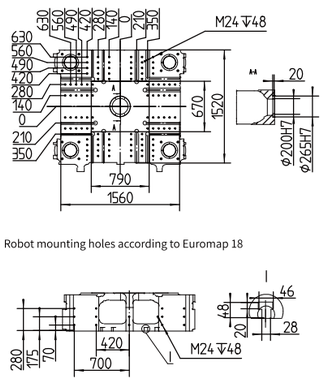
UN900D1 Machine Dimensions



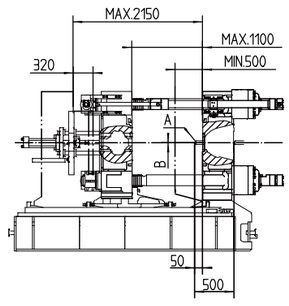


UN900D1 Platen Dimensions





Robot mounting holes according to Euromap 18



Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN900D1-IU4800	SR15	Φ4.5	9400	1939	2780	2198	70	215.49	8	(8+8)×11	150	3~4	5~6
UN900D1-IU6800	SR15	Φ4.5	9500	1946	2860	2198	95	259.84	8	(8+8)×11	150	3~4	5~6
UN900D1-IU9000	SR15	Φ4.5	10000	1974	2870	2906	95	316.71	8	(8+8)×11	150	3~4	5~6

UN900D1 Specifications

Injection Unit									
Model	**IU4800**			**IU6800**			**IU9000**		
Screw diameter （mm）	84	92	108	92	100	116	100	108	116
Shot volume (cm^3)	2217	2659	3664	3191	3770	5073	4320	5038	5813
Shot weight（g）	2039	2446	3371	2936	3468	4667	3974	4636	5348
Injection pressure （MPa）	218	181	131	213	180	134	209	179	155
L/D ratio	21.9	20	20	21.7	20	20	21.6	20	20
Injection rate (cm^3/s)	516	619	853	615	726	980	766	894	1031
Max.injection speed (mm/s)	93			92.5			97.6		
Screw stroke (mm)	400			480			550		
Max.screw speed (r/min)	154			145			128		
Barrel heating zone (PCS)	6			7			7		
Clamping Unit									
Clamping force（kN）	9000								
Opening force （kN）	640								
Platen size (mm)	1560X1520								
Space between tie bars（mm）	1180X1000								
Max. mold thickness（mm）	1100								
Min. mold thickness（mm）	500								
Opening stroke （mm）	1650/1050								
Max. daylight（mm）	2150								
Ejector force（KN）	220								
Ejector stroke（mm）	320								
Ejector number (PCS)	21								
Power unit									
System pressure （MPa）	17.5/30			17.5/30			17.5/30		
Pump motor (kW)	66+7.5			89+7.5			110+7.5		
Total power（kW）	111.3	111.3	120.5	138.5	138.5	147.5	164.02	164.02	168.82
Heater power (kW)	37.82	37.82	47	42	42	51	46.52	46.52	51.32
General									
Oil tank capacity （L）	1000			1150			1400		
Machine dimensions（m）	9.4X3.2X2.8			9.5X3.2X2.9			10X3.2X2.9		
Machine weight (injection+clamping units, no oil)（T）	22+6.5			22+8.5			22+11		
Max. mold weight（T）	13			13			13		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

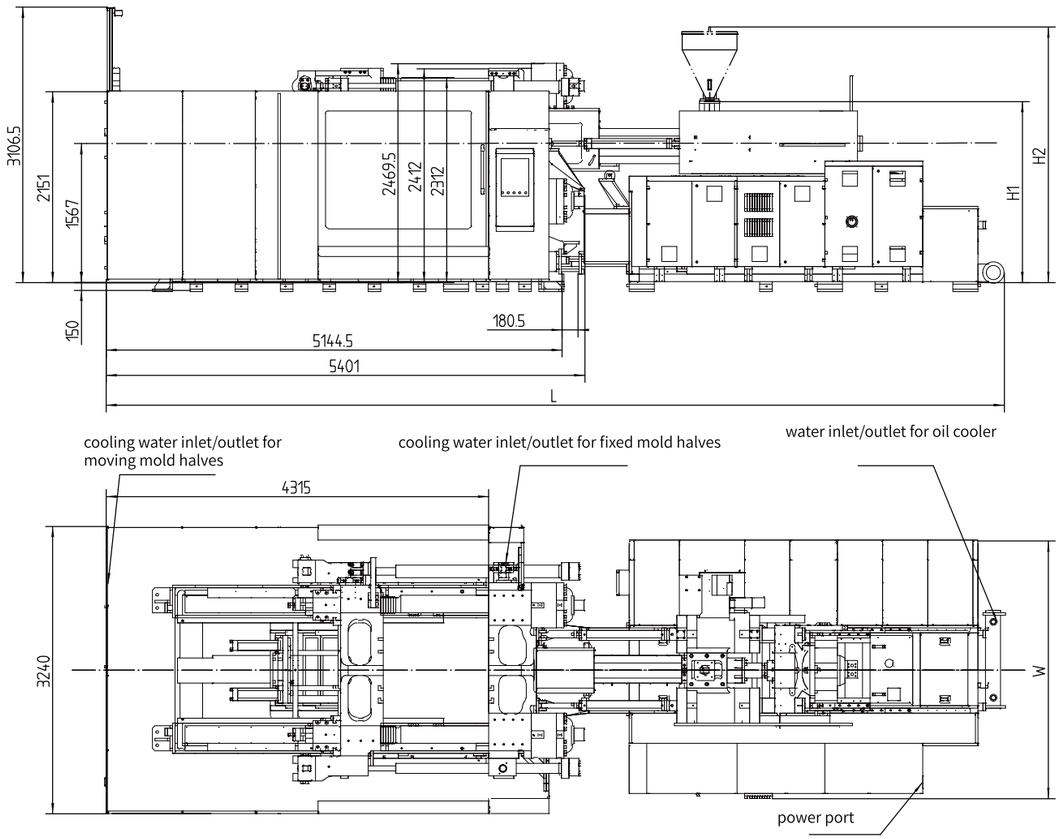
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

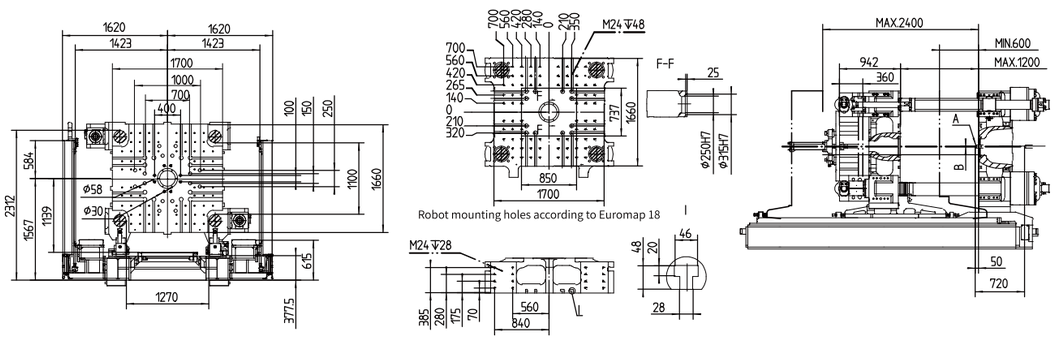
7. The green figures are standard specifications of clamping unit and injection unit.

8. Because of constant technical improvement, the machine specifications are subject to change without notice.

UN1100D1 Machine Dimensions



UN1100D1 Platen Dimensions



Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN1100D1-IU4800	SR15	Φ4.5	9700	2056	2898	2906	70	215.49	8	(8+8)×11	150	3~4	5~6
UN1100D1-IU6800	SR15	Φ4.5	9700	2076	2918	2906	95	259.84	8	(8+8)×11	150	3~4	5~6
UN1100D1-IU9000	SR15	Φ4.5	10100	2051	2883	2906	95	316.71	8	(8+8)×11	150	3~4	5~6
UN1100D1-IU12050	SR15	Φ4.5	10800	2211	2883	2906	120	370.88	8	(8+8)×11	150	3~4	5~6

UN1100D1 Specifications

Injection Unit												
Model	**IU4800**			**IU6800**			**IU9000**			**IU12050**		
Screw diameter （mm）	84	92	108	92	100	116	100	108	116	116	125	135
Shot volume (cm^3)	2217	2659	3664	3191	3770	5073	4320	5038	5813	6341	7363	8588
Shot weight （g）	2039	2446	3371	2936	3468	4667	3974	4636	5348	5833	6774	7901
Injection pressure （MPa）	218	181	131	213	180	134	209	179	155	190	164	140
L/D ratio	21.9	20	20	21.7	20	20	21.6	20	20	22.1	20	20
Injection rate (cm^3/s)	516	619	853	615	726	980	766	894	1031	913	1060	1236
Max.injection speed (mm/s)	89			92.5			97.6			86		
Screw stroke (mm)	400			480			550			600		
Max.screw speed (r/min)	154			145			128			112		
Barrel heating zone (PCS)	6			7			7			8		
Clamping Unit												
Clamping force（kN）	1100											
Opening force （kN）	760											
Platen size (mm)	1700×1660											
Space between tie bars（mm）	1270×1100											
Max. mold thickness（mm）	1200											
Min. mold thickness（mm）	600											
Opening stroke （mm）	1800/1200											
Max. daylight（mm）	2400											
Ejector force（KN）	274											
Ejector stroke（mm）	360											
Ejector number (PCS)	25											
Power Unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	66+7.5			89+7.5			110+7.5			89+37+7.5		
Total power（kW）	111.3	111.3	120.5	138.5	138.5	117.5	164.02	164.02	168.82	199.9	199.9	204
Heater power (kW)	37.82	37.82	47	42	42	51	46.52	46.52	51.32	66.37	66.37	70.63
General												
Oil tank capacity （L）	1000			1150			1400			1600		
Machine dimensions（m）	9.7×3.2×3.2			9.7×3.2×3.2			10.1×3.2×3.2			10.8×3.2×3.2		
Machine weight (injection+clamping units, no oil)（T）	28+6.5			28+8.5			28+11			28+13		
Max. mold weight（T）	16			16			16			16		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

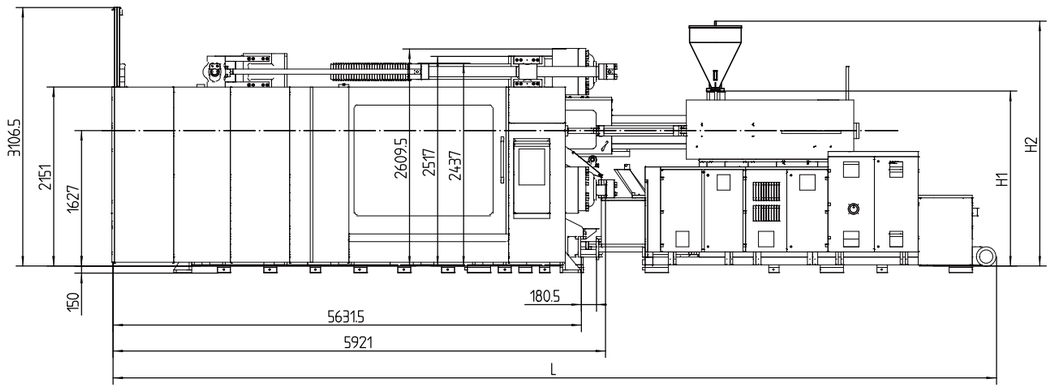
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

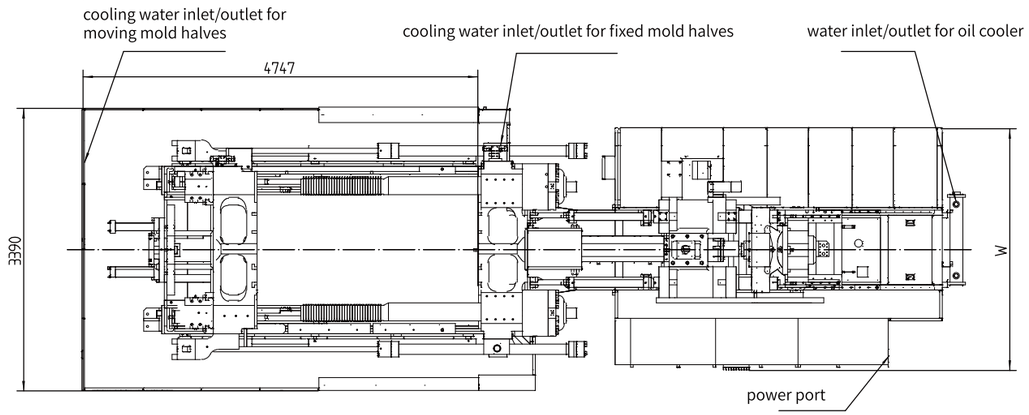
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

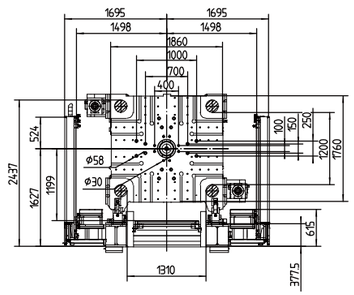
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

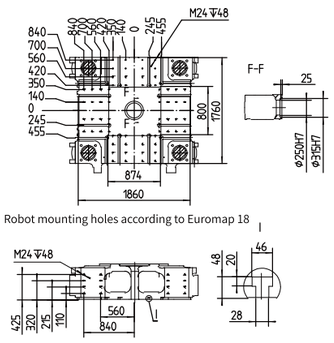
UN1200D1 Machine Dimensions

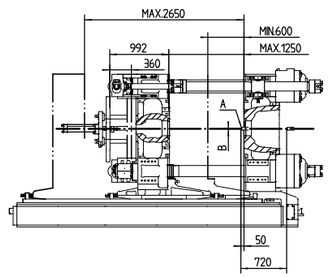




UN1200D1 Platen Dimensions







Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN1200D1-IU4800	SR15	Φ4.5	10200	2016	2958	2906	70	215.49	8	(8+8)×11	150	3~4	5~6
UN1200D1-IU6800	SR15	Φ4.5	10200	2016	2978	2906	95	259.84	8	(8+8)×11	150	3~4	5~6
UN1200D1-IU9000	SR15	Φ4.5	10600	2111	2943	2906	95	316.71	8	(8+8)×11	150	3~4	5~6
UN1200D1-IU12050	SR15	Φ4.5	11300	2271	2943	2906	120	370.88	8	(8+8)×11	150	3~4	5~6

UN1200D1 Specifications

Injection Unit												
Model	**IU4800**			**IU6800**			**IU9000**			**IU12050**		
Screw diameter （mm）	84	92	108	92	100	116	100	108	116	116	125	135
Shot volume (cm^3)	2217	2659	3664	3191	3770	5073	4320	5038	5813	6341	7363	8588
Shot weight（g）	2039	2446	3371	2936	3468	4667	3974	4636	5348	5833	6774	7901
Injection pressure （MPa）	218	181	131	213	180	134	209	179	155	190	164	140
L/D ratio	21.9	20	20	21.7	20	20	21.6	20	20	22.1	20	20
Injection rate (cm^3/s)	516	619	853	615	726	980	766	894	1031	913	1060	1236
Max.injection speed (mm/s)	89			92.5			97.6			86		
Screw stroke (mm)	400			480			550			600		
Max.screw speed (r/min)	154			145			128			112		
Barrel heating zone (PCS)	6			7			7			8		
Clamping Unit												
Clamping force（kN）	12000											
Opening force （kN）	875											
Platen size (mm)	1860×1760											
Space between tie bars（mm）	1310×1200											
Max. mold thickness（mm）	1250											
Min. mold thickness（mm）	600											
Opening stroke （mm）	2050/1400											
Max. daylight（mm）	2650											
Ejector force（KN）	274											
Ejector stroke（mm）	360											
Ejector number (PCS)	25											
Power Unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	66+7.5			89+7.5			110+7.5			89+37+7.5		
Total power（kW）	111.3	111.3	120.5	138.5	138.5	147.5	164.02	164.02	168.8	199.9	199.9	204
Heater power (kW)	37.82	37.82	47	42	42	51	46.52	46.52	51.32	66.37	66.37	70.63
General												
Oil tank capacity （L）	1000			1150			1400			1600		
Machine dimensions（m）	10.2×3.4×3.2			10.2×3.4×3.2			10.6×3.4×3.2			11.2×3.4×3.2		
Machine weight (injection+clamping units, no oil)（T）	32+6.5			32+8.5			32+11			32+13		
Max. mold weight（T）	20			20			20			20		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

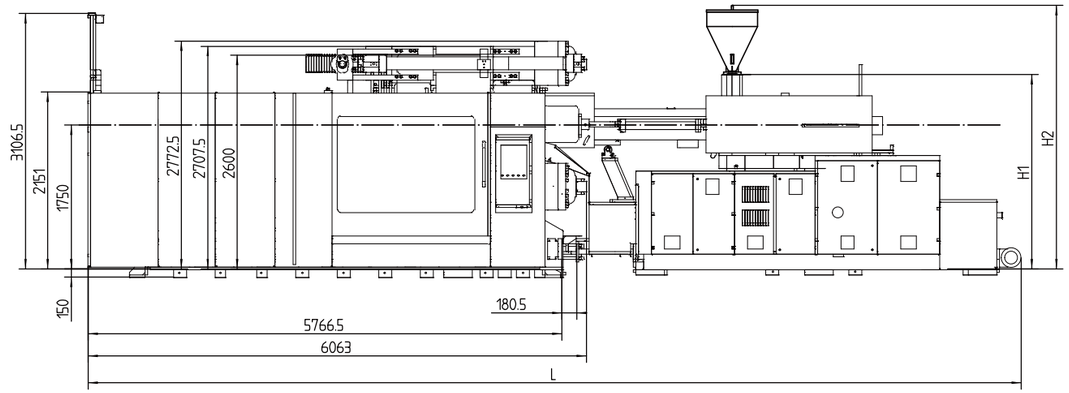
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

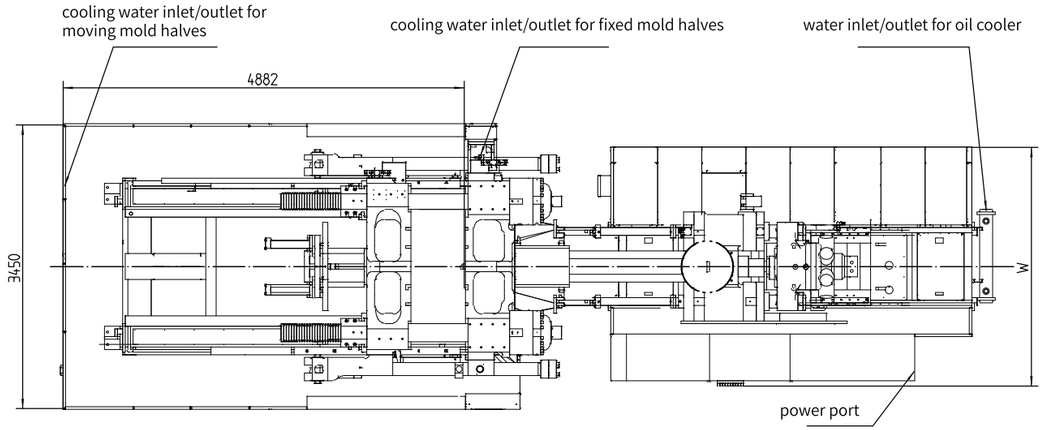
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

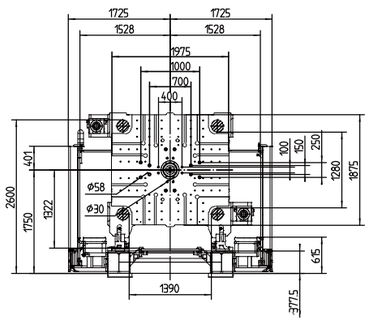
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

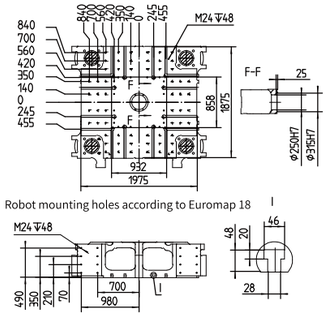
UN1300D1 Machine Dimensions

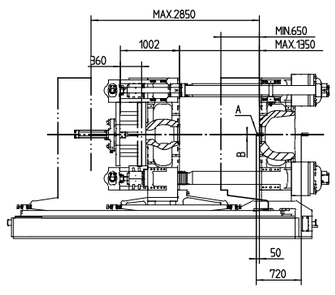




UN1300D1 Platen Dimensions







Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN1300D1-IU6800	SR15	Φ4.5	10300	2159	3101	2906	95	259.84	8	(8+8)×11	150	3~4	5~6
UN1300D1-IU9000	SR15	Φ4.5	10800	2234	3066	2906	95	316.71	8	(8+8)×11	150	3~4	5~6
UN1300D1-IU12050	SR15	Φ4.5	11400	2394	3066	2906	120	370.88	8	(8+8)×11	150	3~4	5~6
UN1300D1-IU14500	SR20	Φ8	11800	2284	3066	2906	150	470.42	8	(8+8)×11	150	3~4	5~6

UN1300D1 Specifications

Injection Unit												
Model	**IU6800**			**IU9000**			**IU12050**			**IU14500**		
Screw diameter （mm）	92	100	116	100	108	116	116	125	135	125	135	145
Shot volume (cm^3)	3191	3770	5073	4320	5038	5813	6341	7363	8588	7854	9161	10568
Shot weight （g）	2936	3468	4667	3974	4636	5348	5833	6774	7901	7226	8428	9723
Injection pressure （MPa）	213	180	134	209	179	155	190	164	140	181	156	135
L/D ratio	21.7	20	20	21.6	20	20	22.1	20	20	23.6	22	20
Injection rate (cm^3/s)	615	726	980	766	894	1031	913	1060	1236	1316	1536	1772
Max.injection speed (mm/s)	92.5			97.6			86			107		
Screw stroke (mm)	480			550			600			640		
Max.screw speed (r/min)	145			128			112			120		
Barrel heating zone (PCS)	7			7			8			8		
Clamping Unit												
Clamping force（kN）	13000											
Opening force （kN）	875											
Platen size (mm)	1975×1875											
Space between tie bars（mm）	1390×1280											
Max. mold thickness（mm）	1350											
Min. mold thickness（mm）	650											
Opening stroke （mm）	2200/1500											
Max. daylight（mm）	2850											
Ejector force（KN）	274											
Ejector stroke（mm）	360											
Ejector number (PCS)	25											
Power Unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	89+7.5			110+7.5			89+37+7.5			89+66+7.5		
Total power（kW）	138.5	138.5	147.5	164	164	168.8	199.9	199.9	204	250.2	250.2	250.2
Heater power (kW)	42	42	51.82	46.52	46.52	51.32	66.37	66.37	70.63	97.7		
General												
Oil tank capacity （L）	1150			1400			1600			2100		
Machine dimensions（m）	10.3×3.5×3.2			10.8×3.5×3.2			11.4×3.5×3.2			11.8×3.5×3.2		
Machine weight (injection+clamping units, no oil)（T）	36+8.5			36+11			36+13			36+16.5		
Max. mold weight（T）	23			23			23			23		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

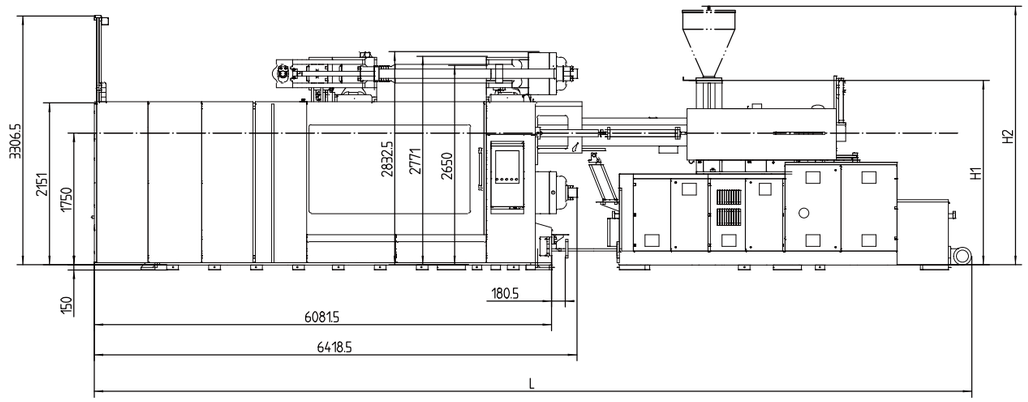
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

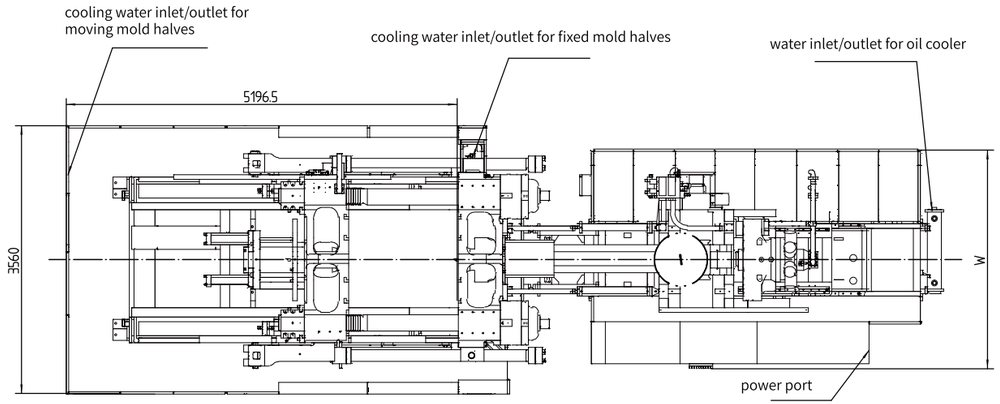
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

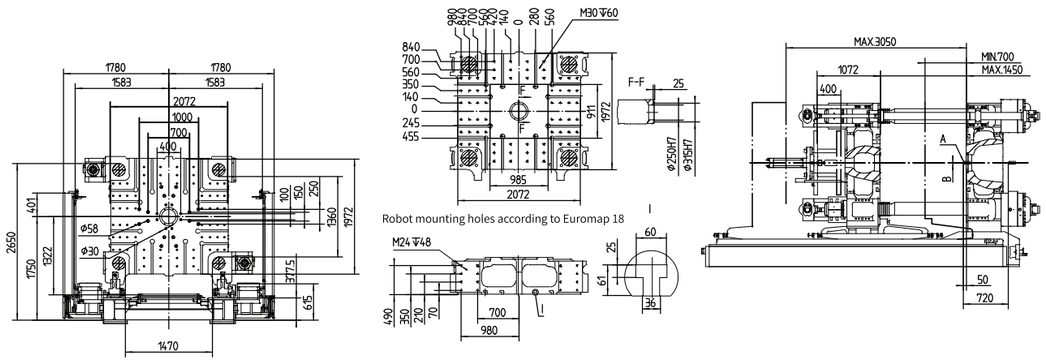
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

UN1400D1 Machine Dimensions





UN1400D1 Platen Dimensions



Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN1400D1-IU6800	SR15	Φ4.5	10600	2259	3101	2906	95	259.84	8	(8+8)×11	150	3~4	5~6
UN1400D1-IU9000	SR15	Φ4.5	11100	2234	3066	2906	95	316.71	8	(8+8)×11	150	3~4	5~6
UN1400D1-IU12050	SR15	Φ4.5	11671	2394	3066	2906	120	370.88	8	(8+8)×11	150	3~4	5~6
UN1400D1-IU14500	SR20	Φ8	12100	2554	3541	3145	150	470.42	8	(8+8)×11	150	3~4	5~6

UN1400D1 Specifications

Injection Unit												
Model	**IU6800**			**IU9000**			**IU12050**			**IU14500**		
Screw diameter (mm)	92	100	116	100	108	116	116	125	135	125	135	145
Shot volume (cm^3)	3191	3770	5073	4320	5038	5813	6341	7363	8588	7977	9304	10733
Shot weight (g)	2936	3468	4667	3974	4636	5348	5833	6774	7901	7339	8560	9875
Injection pressure (MPa)	213	180	134	209	179	155	190	164	140	181	156	135
L/D ratio	21.7	20	20	21.6	20	20	22.1	20	20	23.6	22	20
Injection rate (cm^3/s)	615	726	980	766	894	1031	913	1060	1236	1316	1536	1772
Max.injection speed (mm/s)	92.5			97.6			86			107		
Screw stroke (mm)	480			550			600			650		
Max.screw speed (r/min)	145			128			112			120		
Barrel heating zone (PCS)	7			7			8			8		
Clamping Unit												
Clamping force (kN)	14000											
Opening force (kN)	950											
Platen size (mm)	2072×1972											
Space between tie bars (mm)	1470×1360											
Max. mold thickness (mm)	1450											
Min. mold thickness (mm)	700											
Opening stroke (mm)	2350/1600											
Max. daylight (mm)	3050											
Ejector force (KN)	300											
Ejector stroke (mm)	400											
Ejector number (PCS)	25											
Power Unit												
System pressure (MPa)	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	89+7.5			110+7.5			89+37+7.5			89+66+7.5		
Total power (kW)	138.5	138.5	147.5	164.02	164.02	168.82	199.9	199.9	204	250.2		
Heater power (kW)	42	42	51.82	46.52	46.52	51.32	66.37	66.37	70.63	87.7		
General												
Oil tank capacity (L)	1150			1400			1600			2100		
Machine dimensions (m)	10.6×3.6×3.4			11.1×3.6×3.4			11.7×3.6×3.4			12.1×3.6×3.4		
Machine weight (injection+clamping units, no oil) (T)	39+8.5			39+11			39+13			39+16.5		
Max. mold weight (T)	27			27			27			27		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

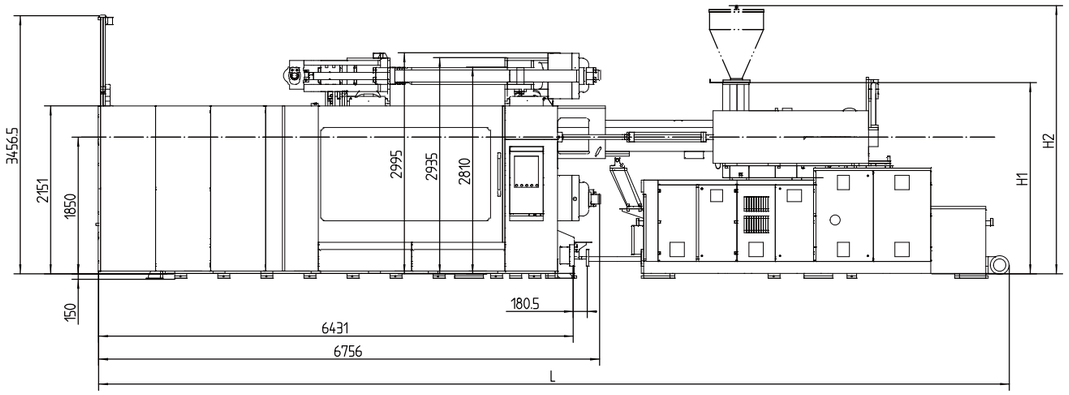
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

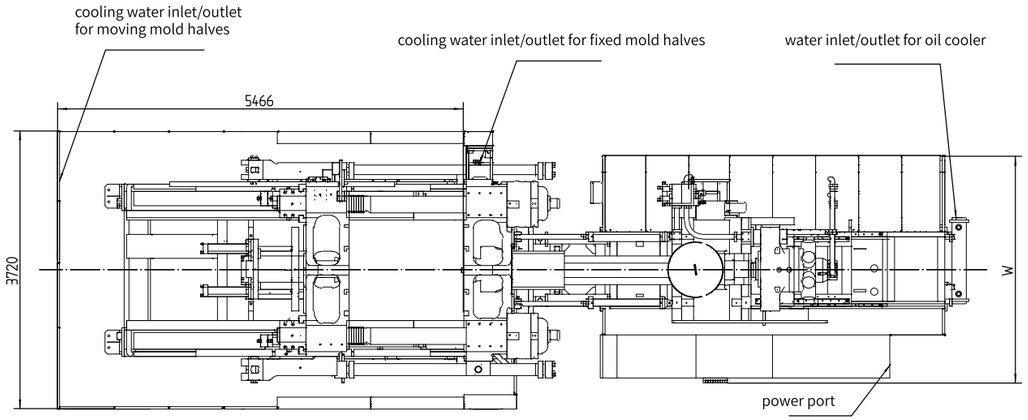
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

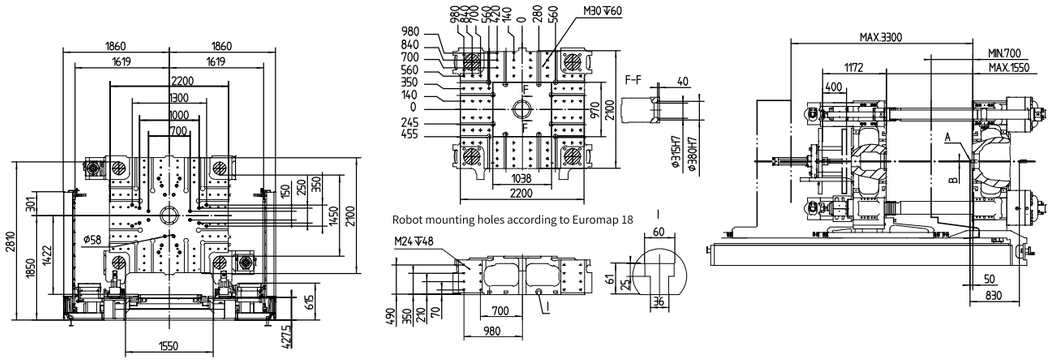
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

UN1600D1 Machine Dimensions





UN1600D1 Platen Dimensions



Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	VMold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN1600D1-IU9000	SR15	Φ4.5	11400	2334	3166	2906	95	316.71	10.5	(8+8)×11	200	3~4	5~6
UN1600D1-IU12050	SR15	Φ4.5	12100	2494	3166	2906	120	370.88	10.5	(8+8)×11	200	3~4	5~6
UN1600D1-IU14500	SR20	Φ8	12400	2654	3641	3145	150	470.42	10.5	(8+8)×11	200	3~4	5~6
UN1600D1-IU18500	SR20	Φ8	12500	2654	3641	3145	150	470.42	10.5	(8+8)×11	200	3~4	5~6

UN1600D1 Specifications

Injection Unit												
Model	**IU9000**			**IU12050**			**IU14500**			**IU18500**		
Screw diameter （mm）	100	108	116	116	125	135	125	135	145	135	145	165
Shot volume (cm^3)	4320	5038	5813	6341	7363	8588	7977	9304	10733	10020	11559	14968
Shot weight（g）	3974	4636	5348	5833	6774	7901	7339	8560	9875	9218	10634	13770
Injection pressure （MPa）	209	179	155	190	164	140	181	156	135	184	160	123
L/D ratio	21.6	20	20	22.1	20	20	23.6	22	20	23.6	22	20
Injection rate (cm^3/s)	766	894	1031	913	1060	1236	1316	1536	1772	1295	1494	1936
Max.injection speed (mm/s)	97.6			86			107			91		
Screw stroke (mm)	550			600			650			700		
Max.screw speed (r/min)	128			112			120			120		
Barrel heating zone (PCS)	7			8			8			8		
Clamping Unit												
Clamping force（kN）	16000											
Opening force （kN）	1100											
Platen size (mm)	2200×2100											
Space between tie bars（mm）	1550×1450											
Max. mold thickness（mm）	1550											
Min. mold thickness（mm）	700											
Opening stroke （mm）	2600/1750											
Max. daylight（mm）	3300											
Ejector force（KN）	300											
Ejector stroke（mm）	400											
Ejector number (PCS)	25											
Power Unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	110+11			89+37+11			89+66+11			89+66+11		
Total power（kW）	164	164	168.8	203.4	203.4	207.6	253.7			261		
Heater power (kW)	46.52	46.52	51.32	66.37	66.37	70.63	87.7			95		
General												
Oil tank capacity （L）	1400			1600			2100			2100		
Machine dimensions（m）	11.4×3.7×3.5			12.1×3.7×3.5			12.4×3.7×3.5			12.5×3.7×3.5		
Machine weight (injection+clamping units, no oil)（T）	44+11			44+13			44+16.5			44+18.5		
Max. mold weight（T）	34			34			34			34		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

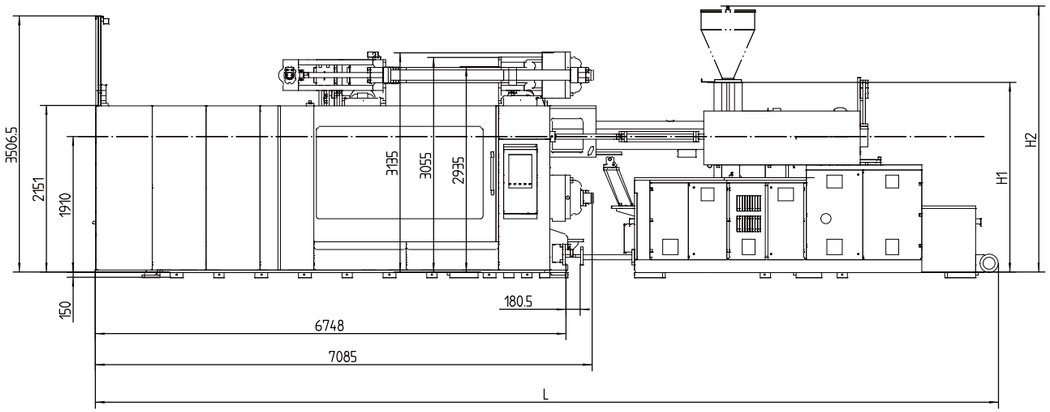
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

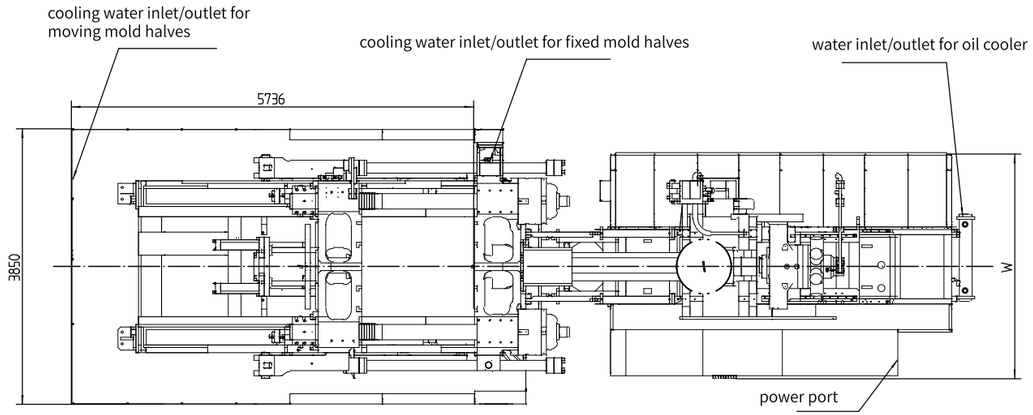
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

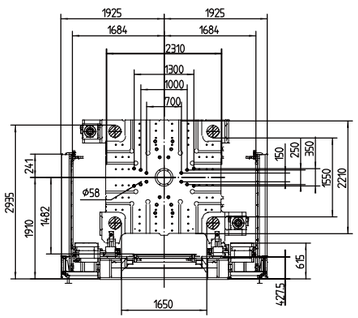
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

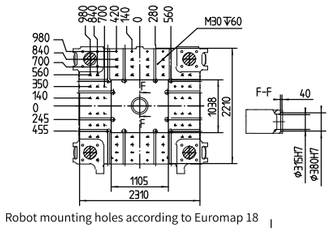
UN1850D1 Machine Dimensions

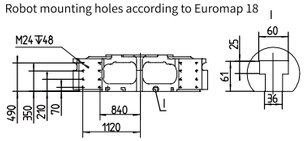


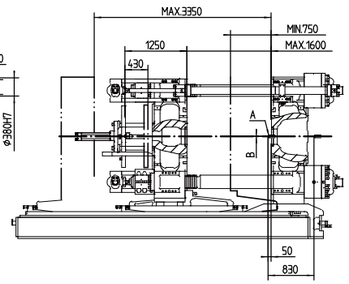


UN1850D1 Platen Dimensions









Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm²	A	t/m²	n×L/min	L/min	bar	bar
UN1850D1-IU9000	SR15	Φ4.5	11700	2394	3261	2906	95	316.71	10.5	(8+8)×11	200	3~4	5~6
UN1850D1-IU12050	SR15	Φ4.5	12400	2554	3226	2906	120	370.88	10.5	(8+8)×11	200	3~4	5~6
UN1850D1-IU14500	SR20	Φ8	12800	2714	3701	3145	150	470.42	10.5	(8+8)×11	200	3~4	5~6
UN1850D1-IU18500	SR20	Φ8	12900	2714	3701	3145	150	470.42	10.5	(8+8)×11	200	3~4	5~6

UN1850D1 Specifications

Injection Unit												
Model	**IU9000**			**IU12050**			**IU14500**			**IU18500**		
Screw diameter （mm）	100	108	116	116	125	135	125	135	145	135	145	165
Shot volume (cm^3)	4320	5038	5813	6341	7363	8588	7977	9304	10733	10020	11559	14968
Shot weight（g）	3974	4636	5348	5833	6774	7901	7339	8560	9875	9218	10634	13770
Injection pressure （MPa）	209	179	155	190	164	140	181	156	135	184	160	123
L/D ratio	21.6	20	20	22.1	20	20	23.6	22	20	23.6	22	20
Injection rate (cm^3/s)	766	894	1031	913	1060	1236	1316	1536	1772	1295	1494	1936
Max.injection speed (mm/s)	97.6			86			107			91		
Screw stroke (mm)	550			600			650			700		
Max.screw speed (r/min)	128			112			120			120		
Barrel heating zone (PCS)	7			8			8			8		
Clamping Unit												
Clamping force（kN）	18500											
Opening force （kN）	1230											
Platen size (mm)	2310×2210											
Space between tie bars（mm）	1650×1550											
Max. mold thickness（mm）	1600											
Min. mold thickness（mm）	750											
Opening stroke （mm）	2600/1750											
Max. daylight（mm）	3350											
Ejector force（KN）	460											
Ejector stroke（mm）	430											
Ejector number (PCS)	25											
Power Unit												
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30		
Pump motor (kW)	110+11			89+37+11			89+66+11			89+66+11		
Total power（kW）	164.02	164.02	168.82	203.4	203.4	207.6	253.7			261		
Heater power (kW)	46.52	46.52	51.32	66.37	66.37	70.63	87.7			95		
General												
Oil tank capacity （L）	1400			1600			2100			2100		
Machine dimensions（m）	11.7×3.9×3.6			12.4×3.9×3.6			12.8×3.9×3.6			12.9×3.9×3.6		
Machine weight (injection+clamping units, no oil)（T）	50+11			50+13			50+16.5			50+18.5		
Max. mold weight（T）	42			42			42			42		

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

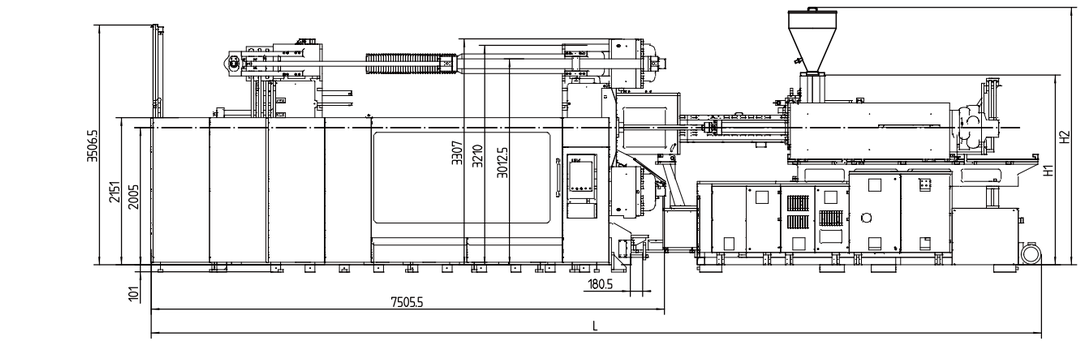
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

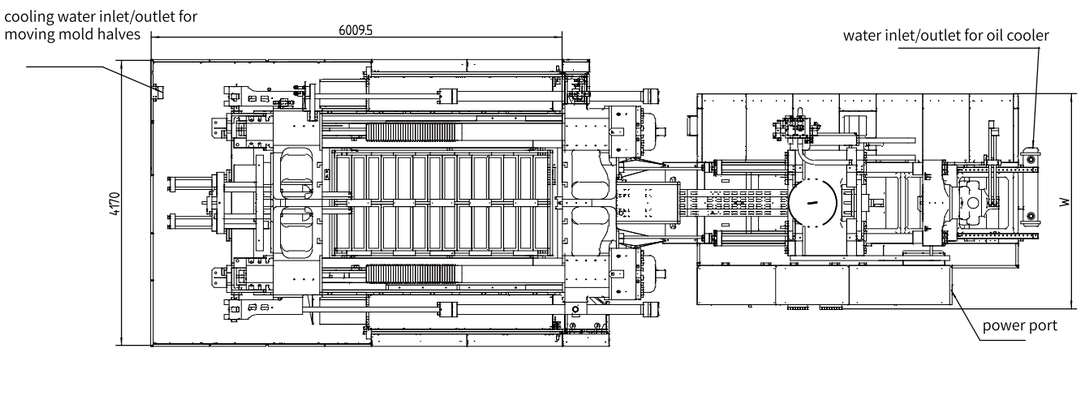
6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

7. The green figures are standard specifications of clamping unit and injection unit.

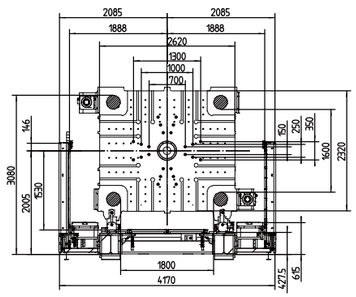
8. Because of constant technical improvement, the machine specifications are subject to change without notice.

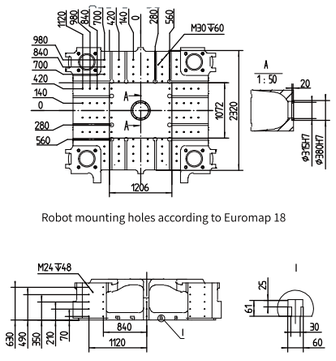
UN2100D1 Machine Dimensions

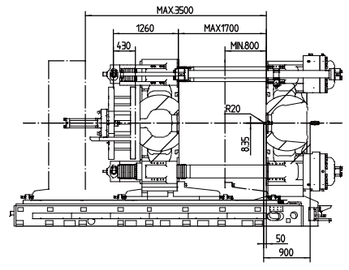




UN2100D1 Platen Dimensions







Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN2100D1-IU12050	SR15	Φ4.5	13100	2649	3321	2906	120	370.88	12.5	(8+8)×11	200	3~4	5~6
UN2100D1-IU14500	SR20	Φ8	13200	2809	3796	3145	150	470.42	12.5	(8+8)×11	200	3~4	5~6
UN2100D1-IU18500	SR20	Φ8	13200	2809	3796	3145	150	470.42	12.5	(8+8)×11	200	3~4	5~6
UN2100D1-IU37500	SR25	Φ8	14800	2864	3870	3640	185	569.67	12.5	(8+8)×11	200	3~4	5~6

UN2100D1 Specifications

Injection Unit										
Model	**IU12050**			**IU14500**			**IU18500**			**IU37500**
Screw diameter （mm）	116	125	135	125	135	145	135	145	165	185
Shot volume (cm^3)	6341	7363	8588	7977	9304	10733	10020	11559	14968	26343
Shot weight （g）	5833	6774	7901	7339	8560	9875	9218	10634	13770	24235
Injection pressure （MPa）	190	164	140	181	156	135	184	160	123	142
L/D ratio	22.1	20	20	23.6	22	20	23.6	22	20	20
Injection rate (cm^3/s)	913	1060	1236	1316	1536	1772	1295	1494	1936	1884
Max.injection speed (mm/s)	86			107			91			70
Screw stroke (mm)	600			650			700			980
Max.screw speed (r/min)	112			120			120			74
Barrel heating zone (PCS)	8			8			8			10
Clamping Unit										
Clamping force（kN）	21000									
Opening force （kN）	1380									
Platen size (mm)	2620x2320									
Space between tie bars（mm）	1800x1600									
Max. mold thickness （mm）	1700									
Min. mold thickness （mm）	800									
Opening stroke （mm）	2700/1800									
Max. daylight （mm）	3500									
Ejector force（KN）	460									
Ejector stroke （mm）	430									
Ejector number (PCS)	25									
Power Unit										
System pressure （MPa）	17.5/30			17.5/30			17.5/30			17.5/30
Pump motor (kW)	89+37+11			89+66+11			89+66+11			110+66+11
Total power（kW）	203.4	203.4	207.6	253.7			261			309.6
Heater power (kW)	66.37	66.37	70.63	87.7			95			126.1
General										
Oil tank capacity （L）	1600			2100			2100			2400
Machine dimensions（m）	13.1×4.2×3.4			13.2×4.2×3.8			13.2×4.2×3.8			14.8×4.2×3.9
Machine weight (injection+clamping units, no oil)（T）	65+13			65+16.5			65+18.5			65+23
Max. mold weight（T）	50			50			50			50

1. Opening force refers to mold opening force generated during high-pressure mold open.

2. In the case of opening stroke, data before the slash refer to mold opening stroke with minimum mold height; data after the slash refer to opening stroke with maximum mold height.

3. Mold-bearing capacity of the movable platen is 2/3 of total mold weight.

4. The shot weight is calculated by GPPS and it is 0.92 times of the theoretical shot volume.

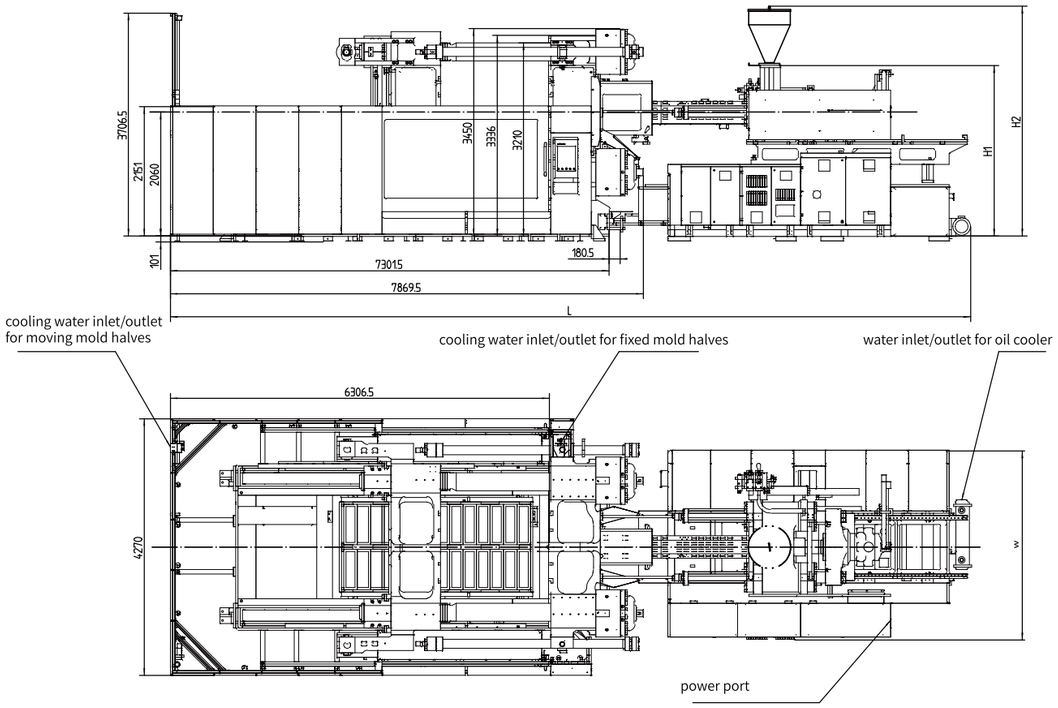
5. Three kinds of screws are available for each model and the medium one is standard on the machine.

6. The injection unit data are in international units and calculated as follows: theoretical shot volume [cm^3] × injection pressure (MPa)/100

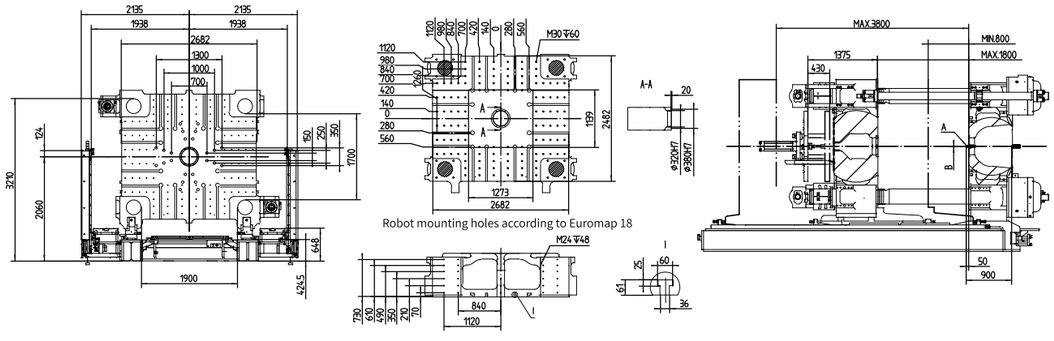
7. The green figures are standard specifications of clamping unit and injection unit.

8. Because of constant technical improvement, the machine specifications are subject to change without notice.

UN2400D1 Machine Dimensions



UN2400D1 Platen Dimensions



Model	A	B	L	H1	H2	W	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm^2	A	t/m^2	n×L/min	L/min	bar	bar
UN2400D1-IU14500	SR20	Φ8	13600	2889	3876	3145	150	470.42	12.5	(8+8)×11	200	3~4	5~6
UN2400D1-IU18500	SR20	Φ8	13600	2889	3876	3145	150	470.42	12.5	(8+8)×11	200	3~4	5~6
UN2400D1-IU37500	SR25	Φ8	14800	2944	3950	3640	185	569.67	12.5	(8+8)×11	200	3~4	5~6
UN2400D1-IU50000	SR25	Φ8	15000	3035	4140	3870	185	665.28	12.5	(8+8)×11	200	3~4	5~6

UN2400D1 Specifications

Injection Unit								
Model	**IU14500**			**IU18500**			**IU37500**	**IU50000**
Screw diameter （mm）	125	135	145	135	145	165	185	200
Shot volume (cm^3)	7977	9304	10733	10020	11559	14968	26343	35186
Shot weight（g）	7339	8560	9875	9218	10634	13770	24235	32371
Injection pressure （MPa）	181	156	135	184	160	123	142	141
L/D ratio	23.6	22	20	23.6	22	20	20	20
Injection rate (cm^3/s)	1316	1536	1772	1295	1494	1936	1884	1902
Max.injection speed (mm/s)	107			91			70	60
Screw stroke (mm)	650			700			980	1120
Max.screw speed (r/min)	120			120			74	52
Barrel heating zone (PCS)	8			8			10	10
Clamping Unit								
Clamping force（kN）	24000							
Opening force （kN）	1640							
Platen size (mm)	2682X2482							
Space between tie bars（mm）	1900X1700							
Max. mold thickness（mm）	1800							
Min. mold thickness（mm）	800							
Opening stroke （mm）	3000/2000							
Max. daylight（mm）	3800							
Ejector force（KN）	460							
Ejector stroke（mm）	430							
Ejector number (PCS)	25							
Power Unit								
System pressure （MPa）	17.5/30			17.5/30			17.5/30	17.5/30
Pump motor (kW)	89+66+11			89+66+11			110+66+11	110+66+11
Total power（kW）	253.7			261			309.6	372.5
Heater power (kW)	87.7			95			126.1	189
General								
Oil tank capacity （L）	2100			2100			2400	2400
Machine dimensions（m）	13.6×4.3×3.9			13.6×4.3×3.9			14.8×4.3×4	15×4.3×4.2
Machine weight (injection+clamping units, no oil)（T）	79+16.5			79+18.5			79+23	79+26
Max. mold weight（T）	59			59			59	59

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