

Leshan 乐善®

Y Series

Y型塑料中空挤出吹瓶机系列
Y Series Extrusion Blow Molding Machine



[关注乐善]



乐善改变吹瓶世界
LESHAN change the blowing routine

广东乐善智能装备股份有限公司

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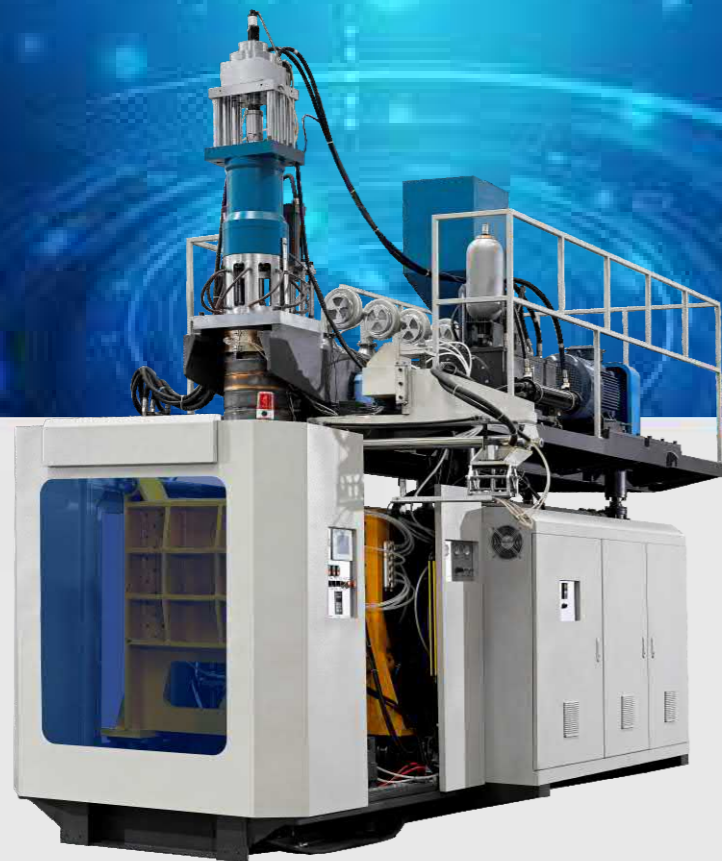
Big

大型号储料型吹瓶机

Arge Size Product Accumulate Material Blow Molding Machine

大容量·大作为

High capacity·Great action



适用于化工原料容器涂料桶汽车油箱水箱等大升量塑料中空制品。
Suitable for chemical raw material bottles, paint buckets, automotive fuel tanks, water tanks and other large-volume plastic hollow products.



整机机架采用钢件焊接，经久耐用不变形，设计稳重坚实。
The machine frame is welded with steel parts, which is durable and not deformed, and has a stable and solid design.



采用日本进口加工中心精细加工模头内部，模头可前后移动。
The inside of the die head is finely processed by a machining center imported from Japan, and the die head can be moved forward and backward.



各项功能齐全，操作简单。
The functions are complete and the operation is simple.

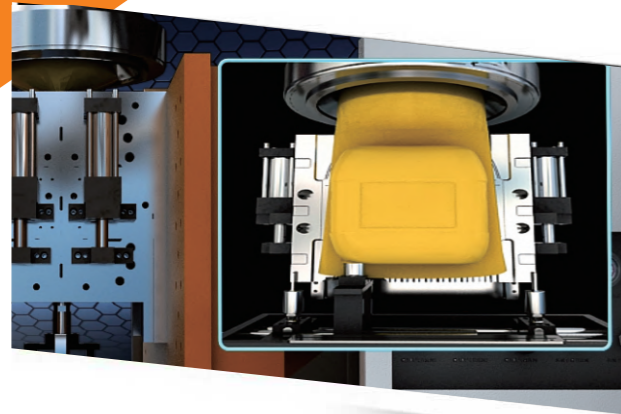


您理想的吹瓶机

Your Ideal Blow Molding Machine

我们满足您的要求
Leshan can meet your requirements





No. 1

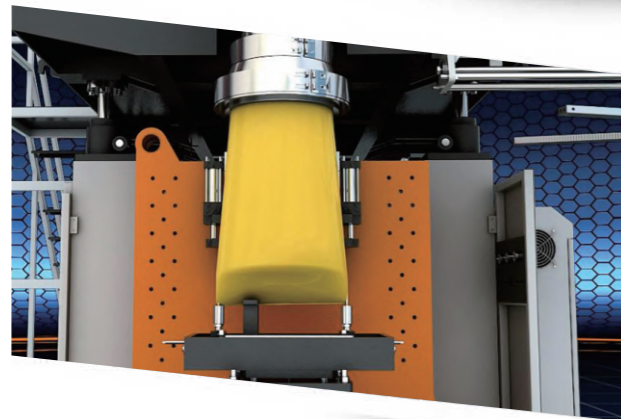
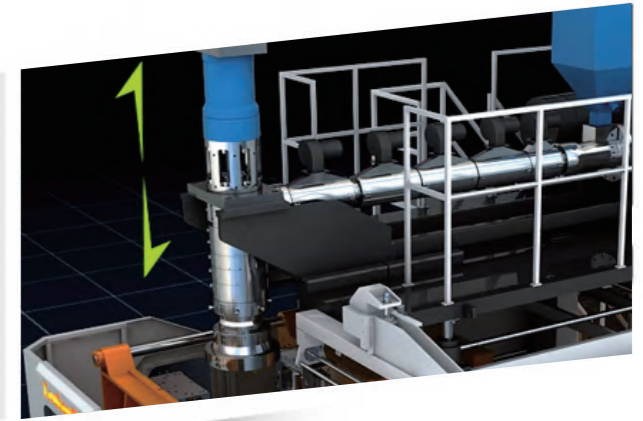
搭载上吹、下吹等功能
Equipped with up-blowing and down-blowing functions

- 插笔可根据需求可搭载上吹、下吹、斜吹等功能。
- The blow pins can be equipped with up-blown, down-blown, oblique blow and other functions as required.

No. 5

搭载电动升降平台系统
Equipped with electric lifting platform system

- 本机通过升降减速机传动原理，可调上或调下。连带模头及挤出系统的升降，可适应不同模具的高度调节，以及不同吹塑工艺的要求。
- This machine can be adjusted up or down through the transmission principle of the lifting reducer. The lifting of the associated die head and extrusion system can adapt to the height adjustment of different molds and requirements of different blow molding processes.



No. 2

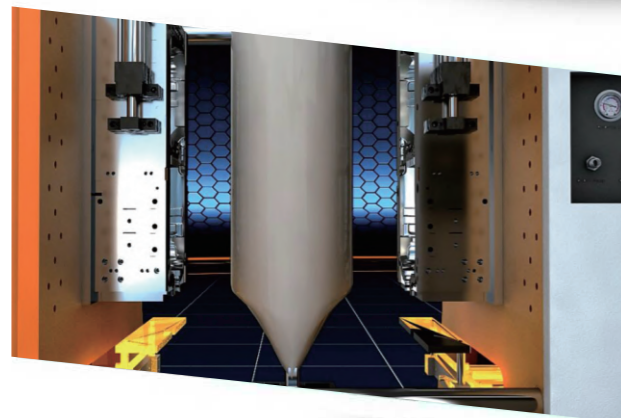
搭载模具拉宽装置
Equipped with mold widening device

- 本机装配了下拉宽装置，能将料管往两边拉伸再吹气，使瓶型更加匀称饱满。
- The machine is equipped with a widening device, which can stretch the material tube to both sides blowing, making the bottle shape more even and full.

No. 6

模板顶杆
Clamping plate mandrel

- 保证锁模板距离，合模距离平衡。
- Ensure that the distance between the clamping plate and the clamping distance is balanced.



No. 3

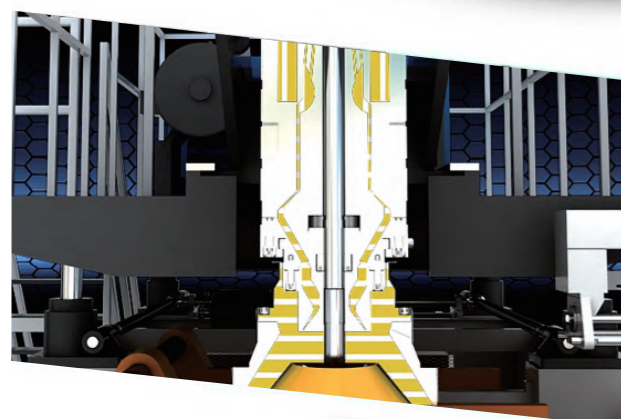
搭载预夹瓶胚装置
Equipped with pre-clip preform device

- 针对大口径料管，机器设有预夹瓶胚装置来缝合料管口，以便插笔吹气。
- For large-diameter feed tubes, the machine is equipped with a pre-clipping preform device to sew the mouth of the feed tube to blowing.

No. 7

锁模架同步齿轮装置
Mold clamping frame synchronous gear device

- 让模具开合动作能以模头为中心同步进行，运行更稳定。
- The mold opening and closing can be performed synchronously with the die head as the center, and the operation is more stable.



No. 4

储料模头
Accumulate material die head

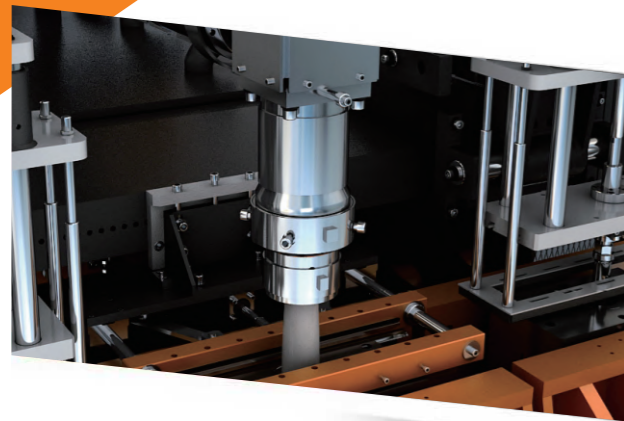
- 模头采用储料模头。
- 压胶快不反胶，出料更均匀。
- 模头可前后移动。
- The die adopts the storage die.
- The glue is pressed quickly, and the material is discharged more evenly.
- The die head can be moved back and forth.

No. 8

机械手装置
Robot hand

- 电动送瓶机械手，定位精准。
- 外观加保护罩，安全美观。
- Electric robot hand with precise positioning.
- Appearance with protective cover, safe and tidy.

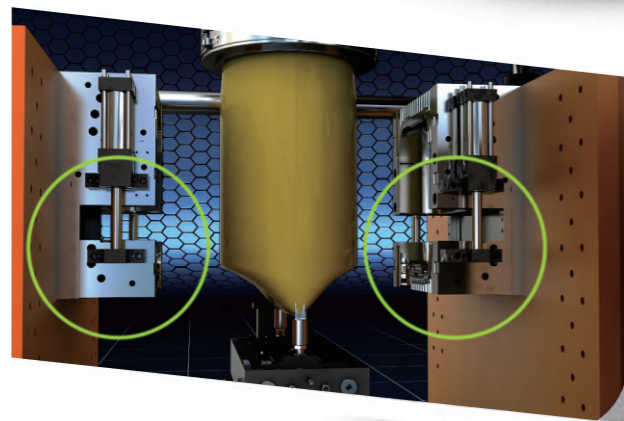




No. 9

搭载预封口切刀装置
Equipped with pre-seal cutter device

- 预封口切刀装置能保证挤出的料管长度一致，避免料管过长造成的原料浪费和无法吹塑成型。
- The pre-seal cutter device can ensure same length of extruded tube, avoiding the waste of raw materials caused by the excessively long tube and inability to blow molding.



No. 10

搭载开合盖装置
Equipped with mold stretching function

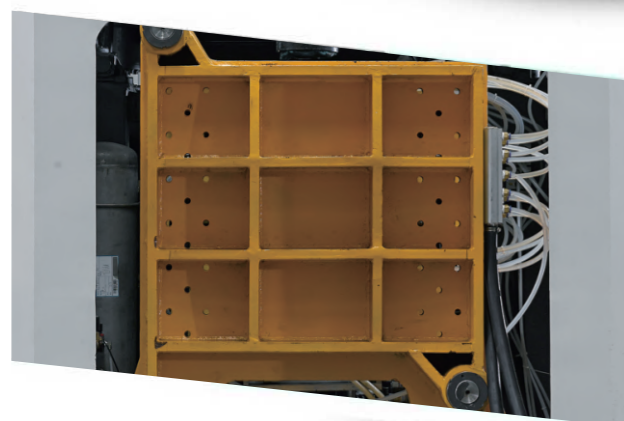
- 本机装配了下拉宽装置，能将料管往两边拉伸再吹气，使瓶型更加匀称饱满。
- The machine is equipped with a widening device, which can stretch the material tube to both sides and blowing, making the bottle shape more even and full.



No. 11

抽芯装置
Core pulling device

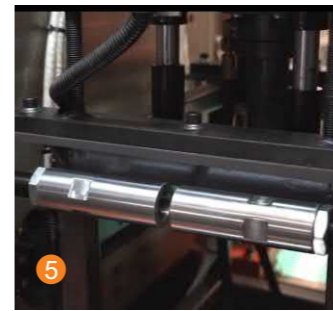
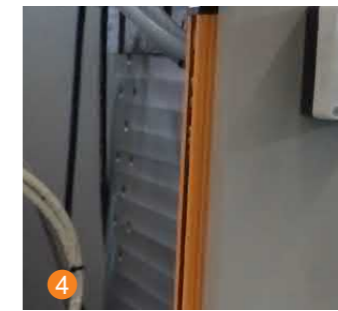
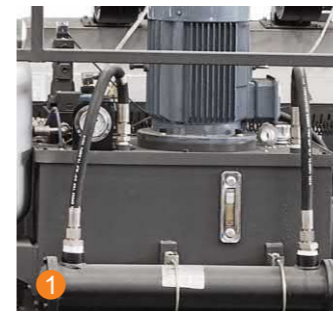
- 抽芯动作。
- Core pulling action.



No. 12

锁模架机构
Mold clamping mechanism

- 对角拉杆导轨式锁模机构。
- 锁模板安装面经设备加工确保安装基准面一致。
- Diagonal tie rod rail type mold clamping mechanism.
- The mounting surface of the clamping plate is processed by the equipment to ensure that the mounting reference surface is consistent.



1 伺服液压系统 Servo hydraulic system

- 供伺服壁厚控制用的，实现稳定节能高效的优越性能。
- For parison control system, it realizes superior performance of stable energy saving and high efficiency.

2 减速箱 Gearbox

- 采用硬齿面齿轮减速箱，噪音小。
- It adopts hard-toothed gear reducer with low noise.

3 厚薄控制系统

- Light curtain switching device
- 可实现对产品0-100点厚薄范围控制。
- It can control the thickness range of the product from 0 to 100 points.

4 光幕开关装置

- Light curtain switching device
- 感应到有物件就会让机器停止运行，避免伤人，起安全保护作用。
- The presence of an object will stop the machine from running, avoid injury and play a role in safety protection.

5 模板顶杆 Clamping plate mandrel

- 保证锁模板距离，合模距离平衡。
- Ensure that the distance between the clamping plate and the clamping distance is balanced.

6 气阀元件 Air valve element

- 安沃驰膜片式电磁换向阀，其余气动元件（如减压阀、节流阀、快排阀、三联件、压力表等）采用台湾新恭或亚德客品牌。
- Anwarch diaphragm solenoid valve, other pneumatic components (such as pressure reducing valve, throttle valve, quick exhaust valve, triplex, Pressure gauge, etc.) using Taiwan's SHAKO or AIRTAC brand.

7 料斗 Hopper

- 不锈钢料斗
- Stainless steel hopper

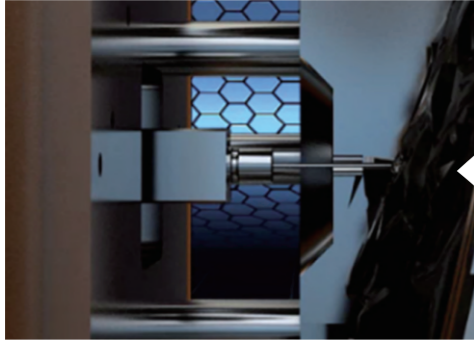
8 挤出机 Extruder

- 38CrMoAl
- 优质氮化钢材质，有足够的硬度，保障使用寿命。
- 38CrMoAl high-quality nitrided steel material has sufficient hardness to ensure service life.

9 锁模架油缸 Clamping cylinder

- 压力大，推动改变开合盖动作状态，方便脱模。
- The pressure is large, change the mold stretching by pushing, for easy demolding.

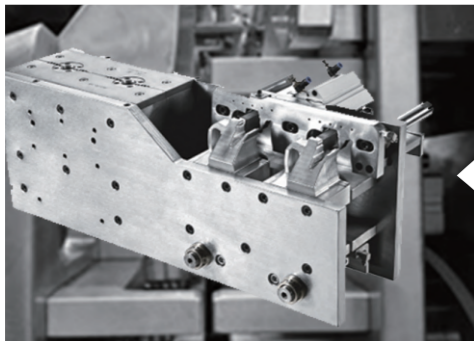
选配功能 Optional function



侧打针功能

Side injection function

- 适用于没有瓶口的产品，或有2个或以上的、位于不同方向的瓶口的产品。
- It is suitable for products without bottle mouths, or products with 2 or more bottle mouths in different directions.



打水口装置

Side injection function

- 自动把飞边和尾料功除。
- Automatically divide burrs and tails.



配置机械手

Equipped robot hand

- 可根据需要配置前置机械手或后置机械手，满足不同需求。
- The front robot hand or the rear robot hand can be equipped as required to meet different needs.



模内贴标

In-mold labeling

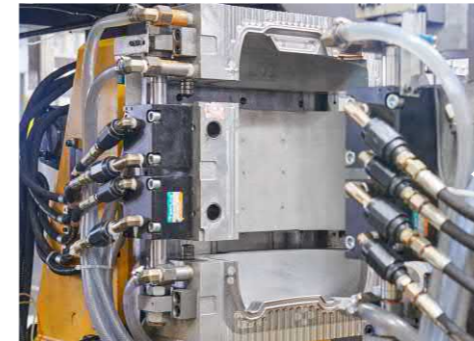
- 吹制品前把标签放入模具内，再借用制品本身的热度将标签紧贴于制品表面。
- Put the label into the mold before blowing product, and then use the heat of the product itself to attach the label to the surface of the product.



电动葫芦

Electric hoist

- 适用于吊装模具。
- Suitable for lifting molds.



上下开合盖

Up and down mold stretching

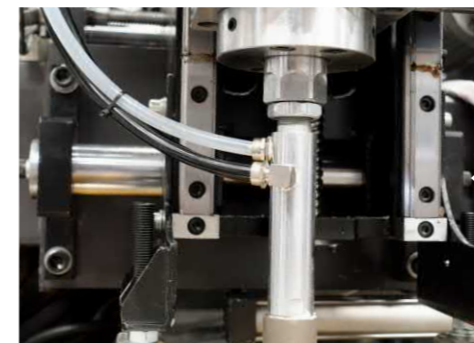
- 适用于那种手柄，平底有内凹，且凹进软多的制品。
- Open and close the lid It is suitable for the products with flat bottom with concave and soft recessed handles.



二次定径冷却装置

Secondary calibration cooling device

- 加快吹瓶时瓶样内部表面的冷动速度。
- 提高瓶样离模温度，把瓶口定径及冷却转移到二次定径位置。
- 提高生产效率，缩短瓶样成型周期。
- Accelerate the cooling speed of the inner surface of bottle when blowing.
- Increase the temperature of the bottle from the mold, and transfer bottle sizing and cooling to the secondary calibration position.
- Improve production efficiency and shorten bottle molding cycle.



气循环功能

Air circulation function

- 加快吹瓶时瓶样内部表面的冷却速度。
- 有两种气循环的控制模式可选。
- 提高生产效率，缩短瓶样成型周期。
- Speeds up the cooling of the inside surface of the bottle when blowing.
- There are two control modes for air circulation.
- Improve production efficiency and shorten bottle molding cycle.



机外锣口装置

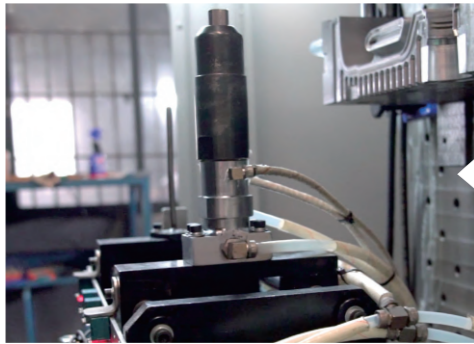
Outer spin trimmer

- 用于剔除瓶口多余溢料。
- Used to remove excess material at the mouth of the bottle.



升降平台机构 Lifting platform mechanism

- 通过平台升降减速机传动原理，以及不同吹塑工艺进行调节。
- It is adjusted by the transmission principle of the platform T lifting reducer and different blow molding processes.



下插笔装置 Pen down device

- 下插笔具有气循环拉宽功能。
- The pen has the function of air circulation widening.



光幕开关 Light curtain switch

- 感应到有物体就会让机器停止运行，避免伤人，起安全保护作用。
- It will stop the machine when it senses an object to avoid hurting people and play a safety protection role.



预夹装置 Pre-clamping device

- 针对侧打针吹气产品，机器设有预夹装置，以便达到吹气效果。
- For side injection blow products, the machine is equipped with a pre-clamping device, in order to achieve the blowing effect.



锁模架油缸 Clamping cylinder

- 压力大，推动改变开合盖动作状态，方便脱模。
- High pressure, push to change the action state of opening and closing lid, convenient for demoulding.



液压升降平台 Hydraulic lifting platform

- 连带模头及挤出系统的升降，可适应不同的模具高度。
- With the lifting of the die head and the extrusion system, it can be adapted different mold heights.



抽芯装置 Core pulling device

- 具有抽芯作用
- With core pulling function



液压开合盖装置 Hydraulic opening and closing device

- 平台前后可移动，方便安装模具。
- The platform can be moved back and forth for easy installation of molds.



预夹瓶装置 Bottle pre-clamping device

- 针对针孔吹气产品，机器设有预夹瓶装置来夹合料管口，以便打针吹气。
- For pinhole blowing products, the machine is equipped with a pre-clamping device to clamp the mouth of the material tube for injection and blowing.



缺料报警 Lack of material alarm

- 缺料时，提醒工人及时加料，减少停机时间。
- When there is a shortage of materials, remind workers to add materials in time to reduce downtime.

Small

轻巧型小Y款吹瓶机
Lightweight Small Y series Blow Molding Machine

小身材·大作为
Small figure · big action



适用于生产500mL以下的PE/PP/EVA/ABS/K料/TPU/尼龙等材质的塑料中空制品。
Suitable for producing plastic hollow products of PE/PP/EVA/ABS/K material/TPU, nylon and other materials below 500mL



设计小巧，搬运简单，设备性能稳定。
Compact design, simple handling and stable equipment performance.



使用进口著名品牌的液压、气动及电气零件。
Use imported hydraulic, pneumatic and electrical parts from famous brands.

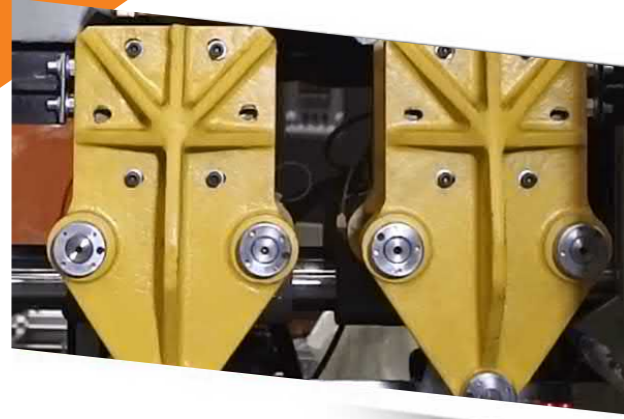


使用先进的数控设备加工零件，零件加工精度高。
Use advanced numerical control equipment to process parts with high precision.

您理想的吹瓶机 Your Ideal Blow Molding Machine

我们满足您的要求
Leshan can meet your requirements

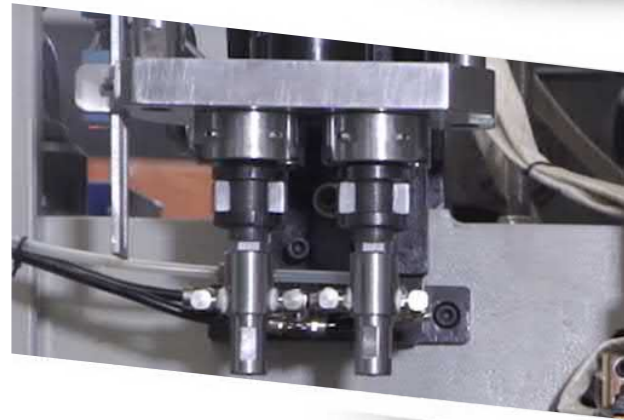




No. 1

三导柱式平衡结构 Three guide pillar balance structure

- 锁模板安装面经设备加工,确保安装基准面一致。
- The mounting surface of the clamping plate is processed by the equipment to ensure same mounting reference surface.



No. 2

插笔 Blow pin

- 前后左右可调节, 调试方便。
- Adjustable front, back, left and right, easy to debug.



No. 3

锁模架 Clamping frame

- 运动导柱导套,耐磨韧性更好,同步同齿轮装置。
- Moving guide post guide sleeve, better wear resistance and toughness. Synchronous with gearing.



No. 4

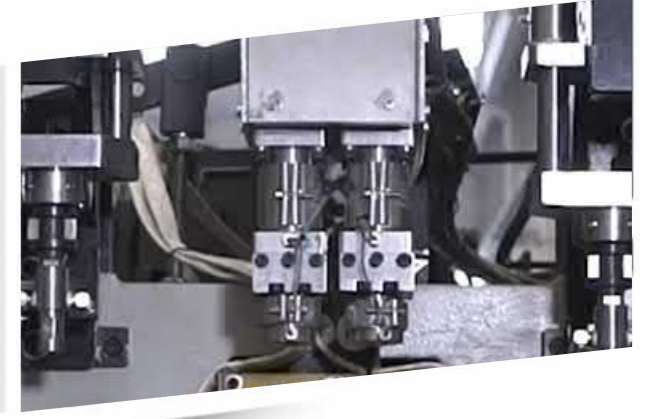
抬头支架装置 Head-up support device

- 采用气动抬头装置, 快与平稳。
- Pneumatic head-up device, fast and stable.

No. 5

模头 Die head

- 精细加工模头内部, 流道畅顺无死角积料, 确保流道两壁光滑细腻。
- The inside of the die is finely processed, flow channel is smooth without dead corner accumulation, ensuring that the two walls of the flow channel are smooth and delicate.



No. 6

液压系统装置 Hydraulic system device

- PQ阀控制油路流速和压力,动作流畅快捷。
- The PQ valve controls the flow rate and pressure of oil circuit, and the action is smooth and fast.



No. 7

挤出系统 Extrusion system

- 多段分区独立加热, 高品质螺杆风机,使用寿命悠久。
- Independent heating of multiple sections. High-quality screw fan with long service life.

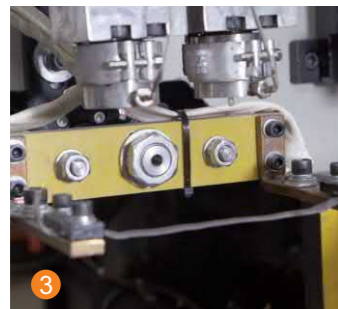
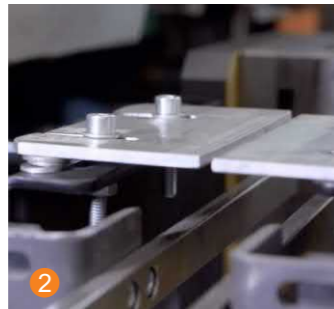


No. 8

导瓶杆装置 Bottle guide device

- 搭载导瓶杆装置。
- Equipped with bottle guide device.





- 1 集中润滑系统**
Centralized lubrication system
- 有助于零件寿命长。
 - Contributes to long component life.

- 2 送瓶架装置**
Bottle guide frame
- 搭载送瓶架装置。
 - Bottle feeding device Equipped with bottle guiding device.

- 3 切刀装置**
Cutter device
- 可搭建冷切刀、热切刀装置。
 - Can be equipped with cold and hot knife devices.

- 4 料斗**
Hopper
- 不锈钢料斗
 - Stainless steel hopper

- 5 变压器装置** Transformer device
- 搭载热切刀变压器装置。
 - Equipped with hot knife transformer device.

- 6 气阀元件** Air valve element
- 安沃驰膜片式电磁换向阀, 其余气动元件 (如减压阀、节流阀、快排阀、三联件、压力表等) 采用台湾新恭或亚德客品牌。
 - Anwarch diaphragm solenoid valve, other pneumatic components (such as pressure reducing valve, throttle valve, quick exhaust valve, triplex, Pressure gauge, etc.) using Taiwan's SHAKO or AIRTAC brand.

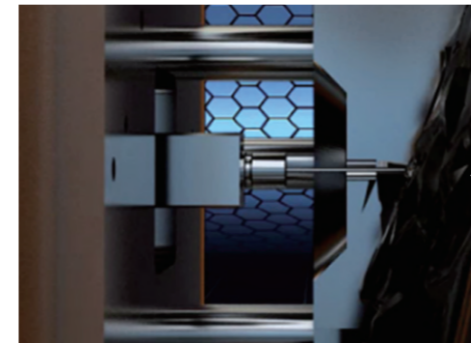
- 7 接近开关控制**
Proximity switch control
- 搭建接近开关控制。
 - Equipped with proximity switch control.

- 8 彩色触屏**
Equipped with proximity switch control.
- 西门子TP700彩色触屏, 操作简便快捷。
 - Siemens TP700 color touch screen operation is simple and fast.

- 9 防爆灯** Explosion-proof lights
- 避免灯内可能产生的电弧、火花或高温引燃周边气体和粉尘。
 - Avoid arcs, sparks, or high temperatures in the lamp that can ignite surrounding gases and dust.

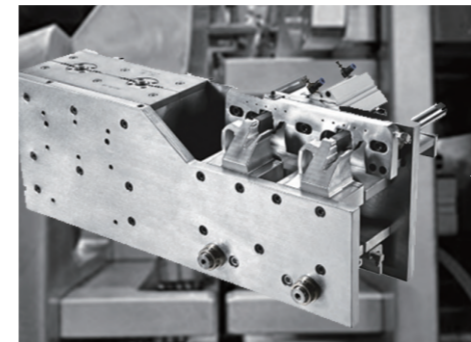
- 10 三相异步电机**
Three-phase asynchronous motor

选配功能 Optional function



侧打针功能 Side injection function

- 适用于没有瓶口的产品, 或有2个或以上的、位于不同方向的瓶口的产品。
- It is suitable for products without bottle mouths, or products with 2 or more bottle mouths in different directions.



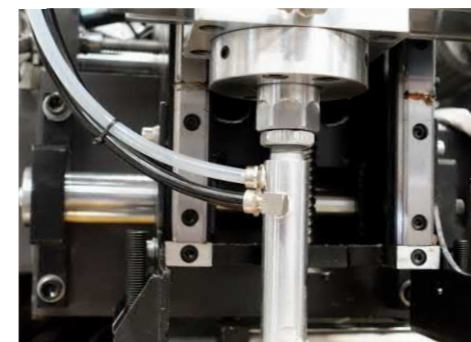
打水口装置 Side injection function

- 自动把飞边和尾料功除。
- Automatically divide burrs and tails.



二次定径冷却装置 Secondary calibration cooling device

- 加快吹瓶时瓶样内部表面的冷却速度。
- 提高瓶样离模温度, 把瓶口径径及冷却转移到二次定径位置。
- 提高生产效率, 缩短瓶样成型周期。
- Accelerate the cooling speed of the inner surface of bottle when blowing.
- Increase the temperature of the bottle from the mold, and transfer bottle sizing and cooling to the secondary calibration position.
- Improve production efficiency and shorten bottle molding cycle.



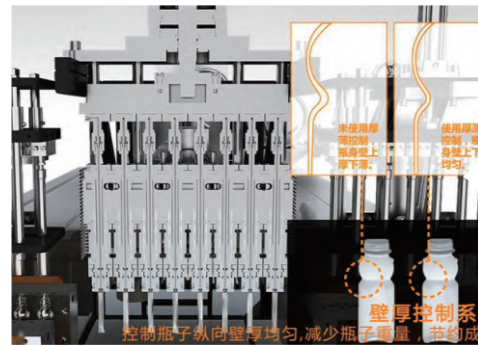
气循环功能 Air circulation function

- 加快吹瓶时瓶样内部表面的冷却速度。
- 有两种气循环的控制模式可选。
- 提高生产效率, 缩短瓶样成型周期。
- Speeds up the cooling of the inside surface of the bottle when blowing.
- There are two control modes for air circulation.
- Improve production efficiency and shorten bottle molding cycle.



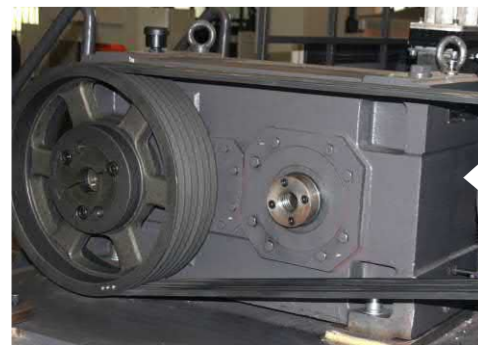
机外辮口装置 spin trimmer

- 用于剔除瓶口多余溢料
To remove the excess spillage from the ottle mouth



厚薄控制 Thickness control

- 可通过该功能实现对产品减重。
- Before blowing the product, put the label into the mold, and then use the heat of the product itself to stick the sticker on the surface of the product.



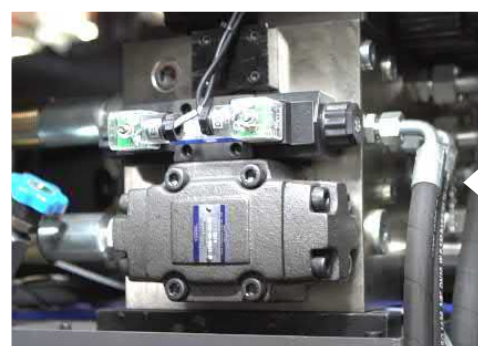
皮带轮装置 Pulley device

- 采用卡套式皮带轮
- Use Sheave belt pulley



蓄能器装置 Accumulator device

- 保证整个系统压力正常
- Ensure the pressure for whole system stable.



油阀 Oil valve

- 采用进口知名品牌油阀。
- Equipped with popular brand oil valve.

系列	Cafrory	Y型机系列 Y Series	
型号	Model	Y-30	Y-30
配置代号	Code	SCJ-85Y+H+S1×1.30D	SCJ90Y+H+S1×1.30D
基本参数 Specification			
项目	Items	Units	参数Specification
类别	Category	/	直线导轨Linear Guide Way
制品最大容量	Max. Blow Volume	L	30
适用原料	Material	/	PE,PP,PS,PC,PVC
模头坯料数量	No.Of Die Head	/	1
模头中心距	Die Head Distance (Center to Center)	mm	/
机器净重约	Net Weight	kg	6000
机器外形尺寸	Machine Dimension	mm,L×H×W	3400X3000X1800
模头 Die Head			
模头加热段数	Die Head Heating Zone	/	3
模头加热功率	Die Head Heating Power	kW	13
开合模系统 Clamping Unit			
模架数量	No.Of Station	/	1
最小合模距	Min Clamping Distance Of Mold	mm	450
最大开模距	Max Clamping Distance Of Mold	mm	900
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W820×H710
摆架行程	Carriage Stroke	mm	/
锁模力	Clamping Force	kN	400
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	85
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-66
最大塑化能力	Max Extrusion Capacity	kg/h	130
挤出电机功率	Extruder Motor Power	kW	30
机筒加热段数	Barrel Heating Zone	/	3
机筒加热功率	Barrel Heating Power	kW	10
冷却风机功率	Cooling Fan Power	kW	10.4
动力系统 Power Unit			
油泵电机额定功率	Oil Pump Motor Rated Power	kW	22
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	16
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	20
热切刀变压器功率	Hot Cutter Power	kW	/
装机总功率I	Total Installed Power	kW	102
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/300
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	15/10
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10
备注/Remarks	以上机型均可叠加100点壁厚控制系统, 叠加后改变的参数如下/ All the machines above can be optionally equipped with 100 points parison control system,parameters would be changed as below:		
壁厚伺服电机额定功率	Parison Servo Motor Rated Power	kW	5.5
装机总功率II	Total Installed Power II	kW	53.8/(61.8)
模板尺寸	Effective Dimension Of Mold Plate	(mm)	

*页面数据均源于乐善智能厂内测试, 设备具体数据以定制设备情况为准。
This parameter list is for reference only, and the actual model parameters may be adjusted.

系列	Category	Y型机系列 Y Series				系列	Category	Y型机系列 Y Series						
型号	Model	Y-100		Y-60		型号	Model	SCJ-45Y2×2.05D		SCJ 55Y2×1.05D				
配置代号	Code	100Y+H+S1X1.100D		100Y+H+S1X1.60D		配置代号	Code	SCJ-45Y2×2.05D		SCJ 55Y2×1.05D				
基本参数 Specification						基本参数 Specification								
项目	Items	Units	参数Specification		项目	Items	Units	参数Specification		项目	Items	Units	参数Specification	
类别	Category	/	直线导轨Linear Guide Way		类别	Category	/	单层 1 layer		类别	Category	/	单层 1 layer	
制品最大容量	Max. Blow Volume	L	100		制品最大容量	Max. Blow Volume	L	0.5		制品最大容量	Max. Blow Volume	L	1	
适用原料	Material	/	PE,PP,PS,PC,PVC		适用原料	Material	/	PE,PP		适用原料	Material	/	PE,PP	
模头坯料数量	No.Of Die Head	/	1		模头坯料数量	No.Of Die Head	/	2		模头坯料数量	No.Of Die Head	/	1	
模头中心距	Die Head Distance (Center to Center)	mm	/		模头中心距	Die Head Distance (Center to Center)	mm	2		模头中心距	Die Head Distance (Center to Center)	mm	/	
机器净重约	Net Weight	kg	11500		机器净重约	Net Weight	kg	2200		机器净重约	Net Weight	kg	2000	
机器外形尺寸	Machine Dimension	mm,L×H×W	5940X3800X2100		机器外形尺寸	Machine Dimension	mm,L×H×W	2400X2100X1750		机器外形尺寸	Machine Dimension	mm,L×H×W	2390×2050×1990 (1750)	
模头 Die Head						模头 Die Head								
模头加热段数	Die Head Heating Zone	/	3		模头加热段数	Die Head Heating Zone	/	5		模头加热段数	Die Head Heating Zone	/	2	
模头加热功率	Die Head Heating Power	kW	22		模头加热功率	Die Head Heating Power	kW	4.2		模头加热功率	Die Head Heating Power	kW	3.2	
开合模系统 Clamping Unit						开合模系统 Clamping Unit								
模架数量	No.Of Station	/	1		模架数量	No.Of Station	/	2		模架数量	No.Of Station	/	2	
最小合模距	Min Clamping Distance Of Mold	mm	500		最小合模距	Min Clamping Distance Of Mold	mm	100		最小合模距	Min Clamping Distance Of Mold	mm	100	
最大开模距	Max Clamping Distance Of Mold	mm	1200		最大开模距	Max Clamping Distance Of Mold	mm	230		最大开模距	Max Clamping Distance Of Mold	mm	250	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W1050×H1350		模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W220×H240		模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W220×H240	
摆架行程	Carriage Stroke	mm	/		摆架行程	Carriage Stroke	mm	300		摆架行程	Carriage Stroke	mm	300	
锁模力	Clamping Force	kN	500		锁模力	Clamping Force	kN	27		锁模力	Clamping Force	kN	27	
挤出系统 Extruder Unit						挤出系统 Extruder Unit								
螺杆直径	Extruder Diameter	mm	100		螺杆直径	Extruder Diameter	mm	45		螺杆直径	Extruder Diameter	mm	55	
螺杆长径比	Extruder Length/Diameter Ratio	L/D	27		螺杆长径比	Extruder Length/Diameter Ratio	L/D	21		螺杆长径比	Extruder Length/Diameter Ratio	L/D	24	
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-71		螺杆转速	Extruder Rotating Speed/r/min	r/min	20-60		螺杆转速	Extruder Rotating Speed/r/min	r/min	10-45	
最大塑化能力	Max Extrusion Capacity	kg/h	230		最大塑化能力	Max Extrusion Capacity	kg/h	20		最大塑化能力	Max Extrusion Capacity	kg/h	30	
挤出电机功率	Extruder Motor Power	kW	75/90		挤出电机功率	Extruder Motor Power	kW	7.5		挤出电机功率	Extruder Motor Power	kW	11	
机筒加热段数	Barrel Heating Zone	/	5		机筒加热段数	Barrel Heating Zone	/	3		机筒加热段数	Barrel Heating Zone	/	3	
机筒加热功率	Barrel Heating Power	kW	30		机筒加热功率	Barrel Heating Power	kW	4.5		机筒加热功率	Barrel Heating Power	kW	7.3	
冷却风机功率	Cooling Fan Power	kW	1.85		冷却风机功率	Cooling Fan Power	kW	0.12		冷却风机功率	Cooling Fan Power	kW	0.12	
动力系统 Power Unit						动力系统 Power Unit								
油泵电机额定功率	Oil Pump Motor Rated Power	kW	30		油泵电机额定功率	Oil Pump Motor Rated Power	kW	4		油泵电机额定功率	Oil Pump Motor Rated Power	kW	4	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	16		液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14		液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8		气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8		气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4		水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4		水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4	
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	20		通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	20		通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	19	
热切刀变压器功率	Hot Cutter Power	kW	/		热切刀变压器功率	Hot Cutter Power	kW	1		热切刀变压器功率	Hot Cutter Power	kW	1	
装机总功率I	Total Installed Power	kW	158.9		装机总功率I	Total Installed Power	kW	21.32		装机总功率I	Total Installed Power	kW	19.32	
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/300		液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/80L		液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/80L	
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	15/10		冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5		冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5	
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10		空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10		空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10	
备注/Remarks	以上机型均可叠加100点壁厚控制系统, 叠加后改变的参数如下/ All the machines above can be optionally equipped with 100 points parison control system,parameters would be changed as below:					备注/Remarks	以上机型均可叠加100点壁厚控制系统, 叠加后改变的参数如下/ All the machines above can be optionally equipped with 100 points parison control system,parameters would be changed as below:							
壁厚伺服电机额定功率	Parison Servo Motor Rated Power	kW	5.5		壁厚伺服电机额定功率	Parison Servo Motor Rated Power	kW	/		壁厚伺服电机额定功率	Parison Servo Motor Rated Power	kW	/	
装机总功率II	Total Installed Power II	kW	53.8/(61.8)		装机总功率II	Total Installed Power II	kW	/		装机总功率II	Total Installed Power II	kW	/	
模板尺寸	Effective Dimension Of Mold Plate	(mm)			模板尺寸	Effective Dimension Of Mold Plate	(mm)			模板尺寸	Effective Dimension Of Mold Plate	(mm)		

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This parameter list is for reference only, and the actual model parameters may be adjusted.

系列	Category	Y型机系列 Y Series	
型号	Model	Y-100	Y-100
配置代号	Code	SCJ 55Y2×2.05D	SCJ-45Y2×1.05D
基本参数 Specification			
项目	Items	Units	参数Specification
类别	Category	/	单层 1 layer
制品最大容量	Max. Blow Volume	L	1
适用原料	Material	/	PE,PP
模头坯料数量	No.Of Die Head	/	2
模头中心距	Die Head Distance (Center to Center)	mm	70/80/85
机器净重约	Net Weight	kg	2200
机器外形尺寸	Machine Dimension	mm,L×H×W	2390×2050×1990 (1750)
模头 Die Head			
模头加热段数	Die Head Heating Zone	/	5
模头加热功率	Die Head Heating Power	kW	4.2
开合模系统 Clamping Unit			
模架数量	No.Of Station	/	2
最小合模距	Min Clamping Distance Of Mold	mm	100
最大开模距	Max Clamping Distance Of Mold	mm	150
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W220×H240
摆架行程	Carriage Stroke	mm	300
锁模力	Clamping Force	kN	27
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	55
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	10-45
最大塑化能力	Max Extrusion Capacity	kg/h	20
挤出电机功率	Extruder Motor Power	kW	11
机筒加热段数	Barrel Heating Zone	/	3
机筒加热功率	Barrel Heating Power	kW	7.3
冷却风机功率	Cooling Fan Power	kW	0.12
动力系统 Power Unit			
油泵电机额定功率	Oil Pump Motor Rated Power	kW	4
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	19
热切刀变压器功率	Hot Cutter Power	kW	1
装机总功率I	Total Installed Power	kW	20.2
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/80L
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/water-cooled)	hp	5
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10
备注/Remarks	以上机型均可叠加100点壁厚控制系统, 叠加后改变的参数如下/ All the machines above can be optionally equipped with 100 points parison control system,parameters would be changed as below:		
壁厚伺服电机额定功率	Parison Servo Motor Rated Power	kW	/
装机总功率II	Total Installed Power II	kW	/
模板尺寸	Effective Dimension Of Mold Plate	(mm)	

模块Unit	大Y型功能配置 Configuration and Function	标准配置 Standard configuration	备选配置 Optional configuration
挤出机及模头部分 Extruder and Die Head Parts	硬齿面齿轮减速机Hardened gear reducer	●	
	皮带传动机构Belt drive mechanism	●	
	挤出电机saving extrusion motor	●	
	皮带罩Belt cover	●	
	不锈钢料斗 (带放料口) Stainless steel hopper (with discharge port)	●	
	自动缺料报警Automatic empty hopper alarm	●	
	网线式发热圈及发热板Cable heating ring and heating plate	●	
	机筒冷却风机Barrel cooling fan	●	
	38CrMoAl螺杆38CrMoAl screw	●	
	储料模头Storage die head	●	
	汇川控制器Inovance Inverter	●	
	电机直连式减速机机构Motor direct connection reducer mechanism		○
	磁力架Magnetic frame		○
	镶合金螺杆Inlay alloy screw		○
	配合真空上料机、四合一上料系统、螺旋式上料机等所用料斗Euipped with hopper for material feeder,Four-in-one feeding system,spiral feeder,etc.		○
锁模机构部分 Clamping Mechanism Parts	手动换网机构 (机架总成需变更) Manual filfter net changing mechanism (Frame assembly need to be changed)		○
	液压换网机构 (机架总成需变更) Hydraulic filfter net changing mechanism (Frame assembly need to be changed)		○
	模头防烫保护罩Anti-hot protective cover for die head		○
	瓷接头式发热圈或发热板Porcelain connector heating ring and heating plate		○
	对角拉杆导轨式锁模机构Diagonal tie rod rail type clamping mechanism	●	
	标准机型锁模力 (参考画册参数) Standard model clamping force (Refer to album parameters)	●	
	标准机型容模尺寸 (参考画册参数) Standard model allowed mold size(Refer to album parameters)	●	
	开合模运动采用液压油缸驱动Mold clamping use draulic cylinder drive	●	
	运动导向采用线性导轨Motion guide using linear guide	●	
	同步齿轮机构Synchronous gear mechanism	●	
机架部分 Frame Parts	模具装卸机构 (电葫芦) Mold Loading crane mechanism(electric hoist)		○
	加大锁模行程Increase the clamping stroke		○
	加大或减小容模尺寸Increase or decrease the allowed mold size		○
	摆架运动采用液压油缸驱动Station movement use hydraulic cylinder drive		○
	前后整体式机架Front and rear integral frame	●	
	电动升降Electric platform lifting	●	
安全门部分 Safety Door Parts	升降用蜗轮蜗杆减速机Lifting Worm Gear Reducer	●	
	模头支撑架Die head supporting frame	●	
	楼梯Stairs	●	
	平台防护栏Platform guard railing	●	
	挤出平台左右移动功能Extrusion platform left and right movement function		○
插笔架部分 Blow Pin Parts	避震脚Foot shock		○
	Y型机安全门外观 (参考画册) Standard Y-type series machine safety door appearance(Refer to album)	●	
	标准配色 (参考画册) Standard color(Refer to album)	●	
	浅蓝色半透明亚克力观察窗Light blue translucent acrylic viewing window	●	
	主电箱Main carbinet	●	
下插笔架部分 Lower pen holder	悬挂式后门Hanging rear door	●	
	与标准配色不同的配色要求Different color requirements from standard color		○
	下插笔架Lower pen holder	●	
	气循环插笔Gas circulation pen	●	
	拉宽功能Widening function	●	
	侧打针装置Side needle device		○
链轮式手动升降功能 Sprocket manual lifting function	预夹坯功能Hanging rear door		○
	链轮式手动升降功能Sprocket manual lifting function		○
	斜插功能Slant insertion function		○

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This parameter list is for reference only, and the actual model parameters may be adjusted.

模块Unit	大Y型功能配置Configuration and Function	标准配置 Standard configuration	备选配置 Optional configuration
	旋牙功能		○
电气控制 部分 Electrical Control Parts	SIEMENS S7-200控制系统SIEMENS S7-200 Control system	●	
	SIEMENS TP700彩色触摸屏SIEMENS TP700 Color Touch Screen	●	
	SIEMENS 交流接触器SIEMENS AC Contactor	●	
	安川变频器Yaskawa inverter	●	
	CO-TRUST控温模块CO-TRUST Temperature Control Module	●	
	转速、位移、压力、流量、温度、时间参数设定、编辑、存取; Speed, displacement, pressure, flow, temperature and time parameters can be set, edited, accessed	●	
	100套模具工艺参数储存功能Receipt Data Storage of 100 Sets of Mould	●	
	故障报警、记录、自诊断功能; Malfunction Alarm, Malfunction Record, Malfunction Self-diagnose	●	
	输入、输出、动作状态、动作时间监控功能; Monitoring of Input, Output, Action State and Action Time	●	
	自动计算产量、自动复位功能; Output Auto-counting, Auto-reset	●	
	一键恢复功能; Auto-reset	●	
	挤出机温度超高、超低保护; Protecting Extruder from Low Temperature and High Temperature	●	
	模具温度报警功能; Mould Temperature Alarm	●	
	油温超高报警功能; Oil High Temperature Alarm	●	
	中英文操作界面, 多语种HMI Chinese and English operation screen, multilingual HMI	●	
	电脑控温Computer temperature control	●	
	外置单循环启动停止功能External single cycle start stop function	●	
	对射式光幕Pair of light curtains	●	
	远程维护功能Remote maintenance function	●	
	模具抽芯功能Mold pin moving system		○
	模具顶出功能Mold ejection function		○
	西门子 12 显示屏SIEMENS 12 Inch Color Touch Screen		○
	模咀用温控表控制Head nozzle controlled with temperature-controlled meter		○
	模咀用电脑控温Head nozzle use PLC temperature control		○
	液压100点壁厚控制系统100 points hydraulic parison control system		○
	其他语言操作界面Other language operation screen		○
	左右摆架自动平衡系统; Station auto-balanced system		○
液压系统 部分 Hydraulic System Parts	油研液压阀YUKEN Oil Valve	●	
	冷却器Cooler	●	
	管路过滤器In-line filter	●	
	液位计Level gauge	●	
	压力表Pressure Meter	●	
	锁模油缸Clamp cylinder	●	
	扣压软管总成Buckling hose assembly	●	
	油箱Oil tank	●	
	汇川控制器INOVANCE Inverter	●	
	内啮合齿轮泵Internal gear pump	●	
	伺服电机 servo motor	●	
模具开合盖功能Mold stretching function	●		
平台前后移动功能Platform front and rear movement function	●		
气动系统 Pneumatic Parts	独立配置0.3立方储气罐Independent configuration 0.3 cubic gas storage tank	●	
	二联件Two pieces	●	
	标准气缸Standard air cylinder	●	
	安沃驰膜片式电磁换向阀Aventis electromagnetic reversing Valve	●	
	节流阀Throttle valve	●	
	减压阀Relief Valve	●	
	快排阀Aerofluxus Valve	●	
	消音器Silencer	●	
	压力表Pressure Meter	●	
	PA管PA tube	●	
气循环快速换气系统Air circulation rapid ventilation system	●		

模块Unit	大Y型功能配置Configuration and Function	标准配置 Standard configuration	备选配置 Optional configuration
气动系统 Pneumatic Parts	气体低温冷却系统(冰气机) Gas cryogenic cooling system (ice machine)		○
	插笔用储气罐 Blow pin use air compressor		○
润滑系统 Lubrication system	自动油脂润滑泵Automatic grease lubrication pump	●	
	分配器Distributor	●	
	PA管PA tube	●	
	可供购买0号、00号锂基润滑脂Gas cryogenic cooling system (ice machine)		○
冷却系统 Servo motor bottle feeder	模具运水一进一出, 管径不小于1.25寸; The mold transports water in and out, and the pipe diameter is not less than 1.25 inches;	●	
	模具分水块Mold water block	●	
	涡流水流量计Eddy current flow meter		○
机械手 Robot	气动送瓶机械手Pneumatic bottle feeder	●	
	伺服电机送瓶机械手Servo motor bottle feeder		○

模块Unit	小Y型功能配置Configuration and Function	标准配置 Standard configuration	备选配置 Optional configuration
挤出机及 模头部分 Extruder and Die Head Parts	硬齿面齿轮减速箱Hardened gear reducer	●	
	皮带传动机构Belt drive mechanism	●	
	挤出电机saving extrusion motor	●	
	皮带罩Belt cover	●	
	不锈钢料斗(带放料口) Stainless steel hopper (with discharge port)	●	
	自动缺料报警Automatic empty hopper alarm	●	
	网带式发热圈及发热板Cable heating ring and heating plate	●	
	机筒冷却风机Barrel cooling fan	●	
	38CrMoAl螺杆38CrMoAl screw	●	
	连续挤出式模头Continuous extrusion die head	●	
	汇川控制器Inovance Inverter	●	
	电机直连式减速箱机构Motor direct connection reducer mechanism		○
	磁力架Magnetic frame		○
	镶合金螺杆Inlay alloy screw		○
	配合真空上料机、四合一上料系统、螺旋式上料机所用料斗Euipped with hopper for material feeder,Four-in-one feeding system,spiral feeder,etc.		○
	手动换网机构(机架总成需变更) Manual fifter net changing mechanism (Frame assembly need to be changed)		○
	液压换网机构(机架总成需变更) Hydraulic fifter net changing mechanism (Frame assembly need to be changed)		○
	模头防烫保护罩Anti-hot protective cover for die head		○
	瓷接头式发热圈或发热板Porcelain connector heating ring and heating plate		○
	锁模机构 部分 Clamping Mechanism Parts	三导柱锁模机构Three-column column clamping mechanism	●
标准机型锁模力(参考画册参数) Standard model clamping force (Refer to album parameters)		●	
标准机型容模尺寸(参考画册参数) Standard model allowed mold size(Refer to album parameters)		●	
摆架运动采用液压油缸驱动Station movement use hydraulic cylinder drive		●	
开合模运动采用液压油缸驱动Mold clamping use draulic cylinder drive		●	
运动导向采用导柱导套Motion guide use pillar guides		●	
同步齿轮机构Synchronous gear mechanism		●	
模具装吊机构(电葫芦) Mold Loading crane mechanism(electric hoist)		○	
机架部分 Frame Parts	前后整体式机架Front and rear integral frame	●	
	气动抬头机构Pneumatic lifting head mechanism	●	
	挤出平台左右移动功能Extrusion platform left and right movement function	●	
	避震脚Suspension foot	●	

