

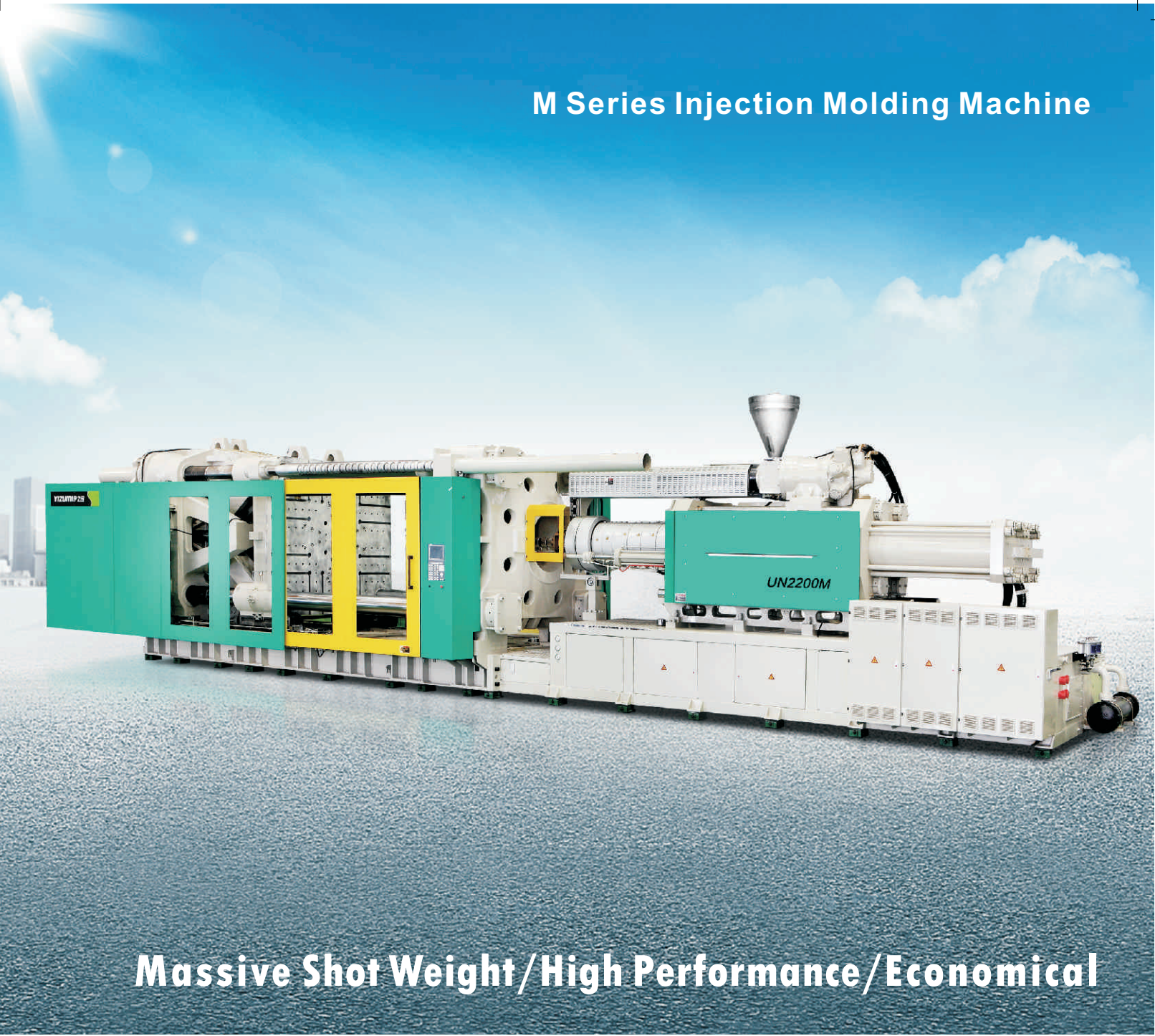


Technical Specifications

Model	UNIT	UN400M		UN480M		UN650M		UN800M		UN1100M		UN1400M		UN1800M		UN2400M		UN2800M	
International Classification		34920/6500		34920/6500		34920/6500		34920/8000		57700/11000		57700/14000		84960/18000		84960/24000		135300/28000	
Injection Unit																			
		A	B	A	B	A	B	A	B	A	B	A	B	A	B	A	B	A	B
Screw Diameter	mm	68		68		84		84		100		100		120		120		135	
Screw L: D Ratio		25:1		25:1		25:1		25:1		25 : 1		25 : 1		25 : 1		25 : 1		25 : 1	
Plunger diameter	mm	150	180	150	180	180	210	180	210	210	250	210	250	250	300	250	300	300	340
Shot Volume	cm³	15020	21629	15020	21629	27991	38099	27991	38099	43294	61357	43294	61357	68720	98957	68720	98957	113094	145263
Shot Weight	g (克)	10815	15573	10815	15573	20153	27431	20153	27431	31172	44177	31172	44177	49479	71249	49479	71249	81428	104589
	oz (盎司)	381	548.3	380.8	548.3	709.6	965.9	709.6	965.9	1097.6	1555.5	1097.6	1555.5	1742.2	2508.8	1742.2	2508.8	2867.2	3682.7
Injection Pressure	MPa	131	90.7	130.7	90.7	124.8	91.7	124.8	91.7	133.4	94.1	133.4	94.1	123.7	85.9	123.7	85.9	119.7	93.2
Max. injection speed	mm/s	34.7		34.7		33.8		33.8		33.7		33.7		32.4		32.4		31	
Dry Shot Rate	cm3/s	613	880	613	880	860	1170	860	1170	1160	1650	1160	1650	1590	2290	1590	2290	2190	2810
Screw Stroke	mm	850		850		1100		1100		1250		1250		1400		1400		1600	
Screw Speed	r/min	196		196		147		147		124		124		120		120		132	
Clamping Unit																			
Clamping Force	kN	4000		4800		6500		8000		11000		14000		18000		2400		2800	
Opening Stroke	mm	660		760		900		1025		1150		1350		1560		1750		1950	
Space Between Tie-bars	mmxmm	760x710		860x810		930x930		1030x1030		1130x1130		1310X1310		1560X1560		1850X1650		1950X1800	
Max. Daylight	mm	1390		1570		1800		2025		2300		2700		3210		3570		3830	
Mold Thickness (Min.-Max.)	mm	240-730		260-810		350-920		400-1000		450-1150		600-1350		800-1650		850-1820		900-1880	
Ejector Stroke	mm	210		220		280		320		360		380		400		430		430	
Number of Ejector		13		13		21		21		21		29		33		33		33	
Ejector Force	kN	110		110		182		274		274		303		303		460		460	
Power Unit																			
Hydraulic System Pressure	MPa	17.5		17.5		17.5		17.5		17.5		17.5		17.5		17.5		17.5	
Pump Motor	kW	60		60		31+60		31+60		60×2+15		60×2+15		60×3		60×3		60×4	
General																			
Dry cycle time	s	4		4.7		6.5		8.8		12		13		13		16.5		17	
Oil Tank Capacity	l	780		780		820		1100		1380		1600		1900		2000		2300	
Machine Dimensions (L×W×H)	mxmxm	7.9x1.9x2.6		8.3x2x2.6		9.2x2.3x2.7		10.3x2.3x2.8		11.1x2.8x3.0		13.5x2.9x3.5		15.1x3.5x3.5		16.5x3.8x3.8		18.5x3.8x3.8	
Machine Weight	kg	20500		22500		33500		43000		55000		80000		114000		153000		200000	

Note:
1. Shot volume = barrel cross section× injection stroke
2. Shot weight = shot volume × 0.72 (for PP)
3. Specifications are subject to change for improvement without notice.
4. Inform us of your special requirements, like using PVC, PC, PMMA and other engineering plastics for injection molding.

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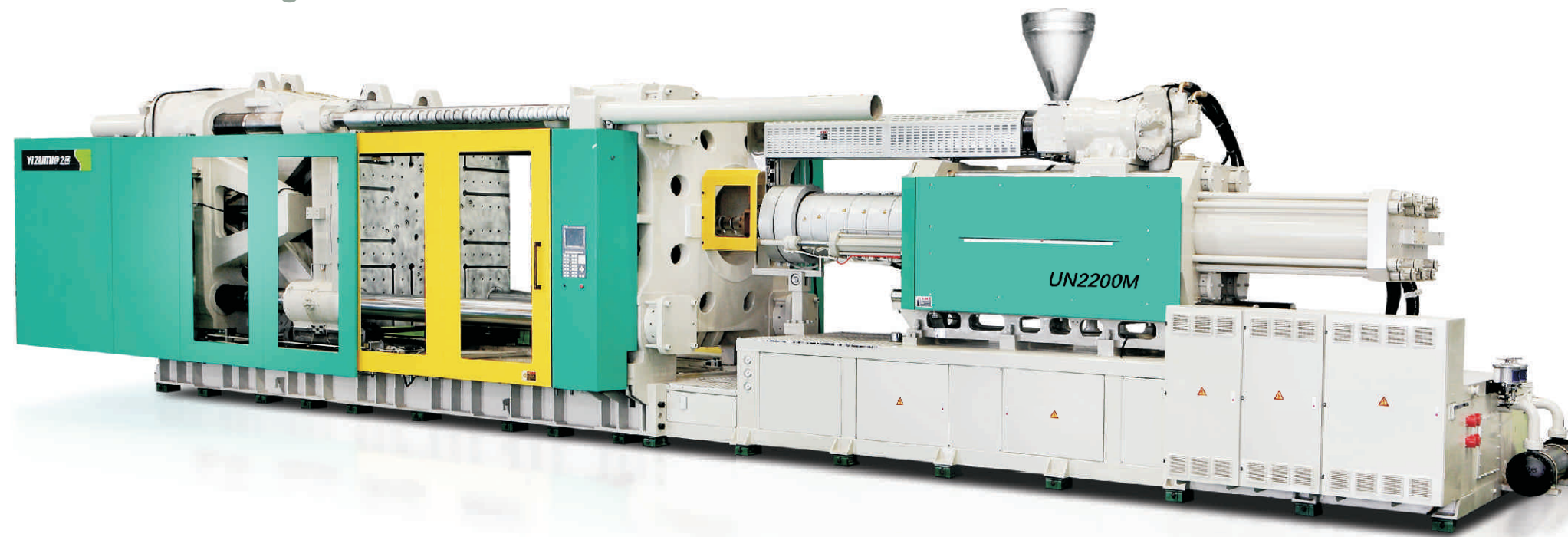


Energy-saving / Precise / Stable



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Stock Code: 300415

Specially designed for products requiring massive shot weight



Scope of application

Molding of large and super large PE pipe fittings



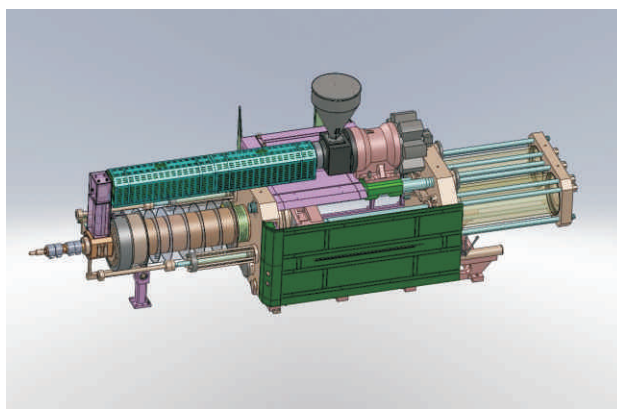
Application case



Molded product: gas pipe elbow
Color: orange
Weight: 37kg
Raw material: PE100
Machine model: UN1800M
Mold cavitation: 1
Cycle time: 1800s
Molding temperature: 240°C-220°C
Injection speed: 30mm/s
Injection pressure: 12MPa
Injection time: 50s
Holding pressure time: 360s
Cooling time: 170s

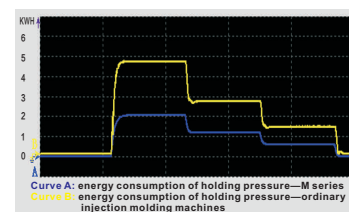
Super large shot weight

- Injection by plunger, unrestricted shot volume and wider range of application.
- Lower cost per shot and a higher price /performance ratio.



Energy-saving

- Fast heating, high efficiency and significant energy savings thanks to Nano infrared heating technology.
- Ultra-low resistance to the moving parts, injection resistance at no load below 1 kgf, extremely low reactive power and more energy savings.



- Self adaptive servo hydraulic system saves energy by 70% in regard to normal holding pressure in the long term.
- Groove design on the plasticizing barrel and plunger barrel, reducing 40% cooling water and 30% heat loss in transfer.

Stable

- **Stable plasticizing performance**
Plasticizing rather than injection is carried out by the screw, with high plasticizing capacity and little temperature difference throughout the molten plastic.
- **Bi-metallic injection plunger with longer service life**



- **More stable and reliable control**
Switching between plasticizing and injection is via a specially-treated rod, which is heat-resistant so that the motions of moving parts are flexible, reliable and stable.
- **More precise temperature control**
Temperature control is more precise and reliable with the use of Japan-made computer-based controller, the British solid-state heating control components and infrared ceramic heater bands.

Precise

High-mixing double-wave screw delivers low shear, fast and uniform plasticizing and precision.



High-rigidity platens, flashes not easy to be generated and higher part repeatability.

Repeatability of molded products

