

Leshan 乐善®

K Series

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

—— 提供吹瓶技术整体解决方案 ——
Provide total solutions in blow molding



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



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【乐善智能-微信公众号】



【Youtube】



【Facebook】

广东乐善智能装备股份有限公司

地址：佛山市顺德区大良街道五沙居委会新辉路1号
电话：0757-2837 6168（总机）
传真：0757-2830 8505
邮箱：leshan@china-leshan.com

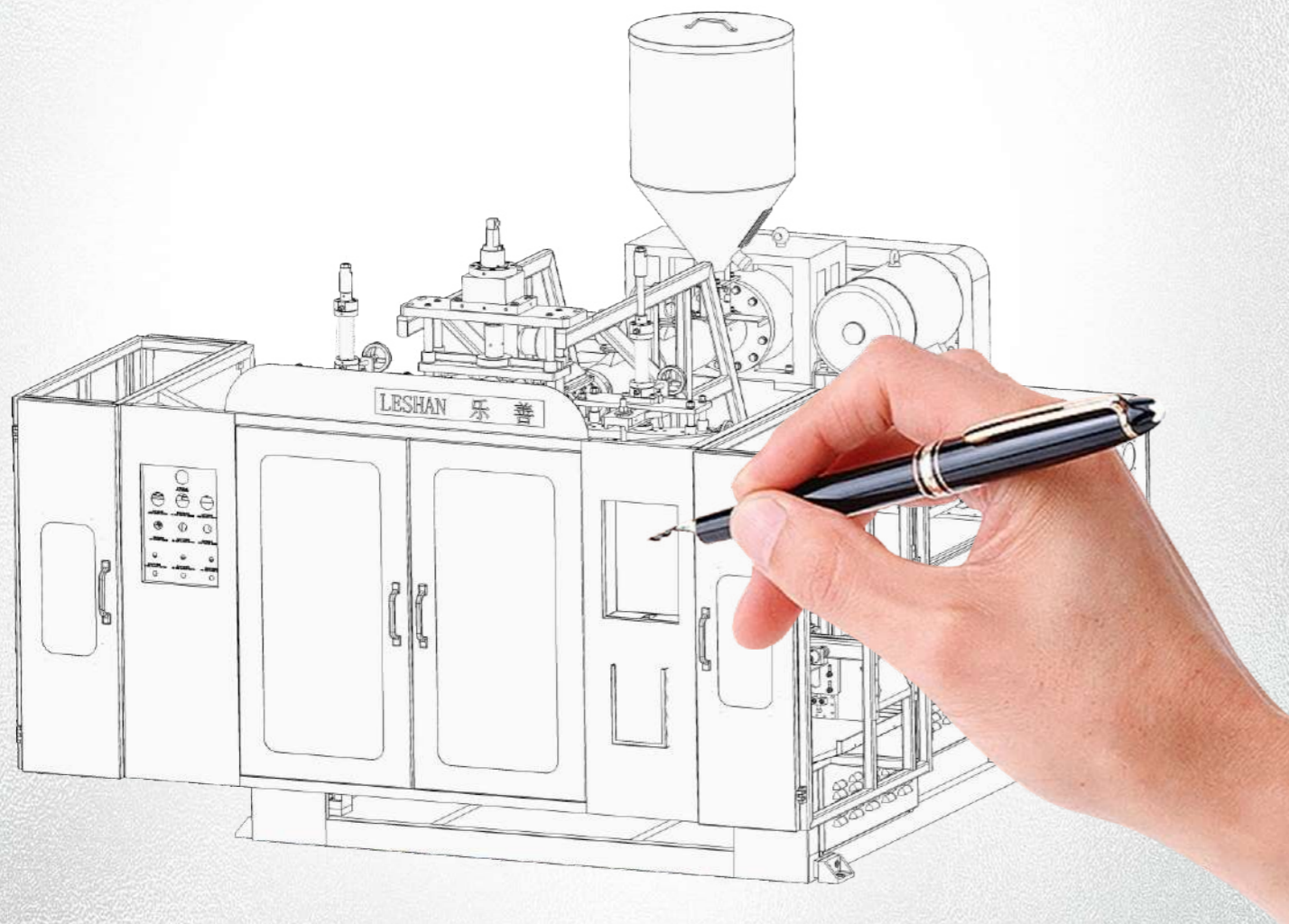
GUANGDONG LESHAN INTELLIGENT EQUIPMENT CORP.,LTD.

No.1 Xinhui Road,Wusha,Daliang,Shunde District,
Foshan City,Guangdong Province,China
TEL: +86-757-2837 6168
FAX: +86-757-2830 8505
E-mail: leshan@china-leshan.com

www.china-leshan.com

匠心品质 · 卓尔不群 INGENUITY AND OUTSTANDING

凝聚每一点的强大用心研发
CONCENTRATE ON EVERY POINT OF DEVELOPMENT



至惠TM 至快

ECONOMY, FAST

K Series Extrusion
Blow Molding Machine

<p>1</p> <p>适用范围广 Widely Use</p> <p>PE, PP, EVA, ABS, TPU, 尼龙等材质的塑料中空制品。 PE, PP, EVA, ABS, TPU, Nylon material blow molding products</p>	<p>2</p> <p>性价比高 Cost-effective</p> <p>经济型设备, 成本不高, 物超所值。 Economy equipment. Excellent quality and reasonable price.</p>	<p>3</p> <p>体积小 Small size</p> <p>占地面积小, 小身材, 大作为。 It just need small space, small size with large production.</p>	<p>4</p> <p>节能消耗 Low energy consumption</p> <p>优化液压油路设计, 省电、动作快、参数调节方便。 Improve hydraulic oil-way design, save energy, quick movement, Convenience parameter adjustment</p>
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精工制造 · 品质卓越

PERFECT MANUFACTURING · EXCELLENT QUALITY

<p>优质材质 High Quality Material</p>	<p>持久耐用 Long life time</p>	<p>精密加工 Precision Machining</p>	<p>高效工作 High Efficiency</p>	<p>人性化设计 Humanized Design</p>	<p>节能降耗 Save Energy</p>
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多层共挤模头 Multi-layer extrusion die head

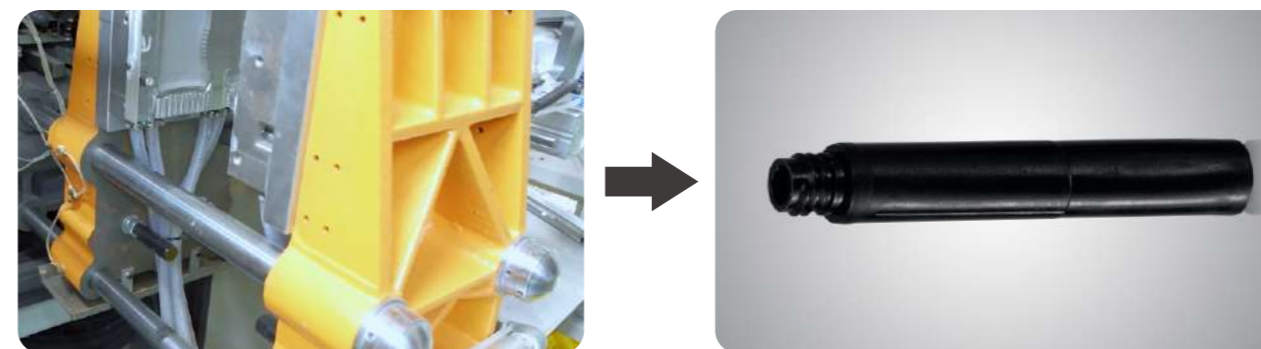
乐善多层共挤模头精巧稳定, 流道光滑, 模头内压力分布合理, 模头分段加热, 适用于PE/PA/OH的多种材料共融多层产品吹制, 且能配合厚薄控制器调整每一层的厚度。

Leshan multi-layer extrusion die head compact and stable, smooth passage. The pressure distribution in die head is reasonable, section heating of die head, be suitable for PE/PA/OH and different kinds of material blow molding multi-layer product. And controlled by thickness control system to adjust each layer thickness.



K系列锁模板 K series clamping plate

其优点在于即使是超长的模具也能安装, 而且锁模板下方同样提供足够的锁模力抵抗吹制时的压力。
The advantage is that even very long molds can be installed, and the lower part of the locking plate also provides enough clamping force to resist blowing pressure.



PROVIDING

COMPLETE BLOW MOLDING STRATEGY ACCORDING TO CLIENTS' REQUIREMENT

根据客户要求提供完整吹塑策略!

应用领域

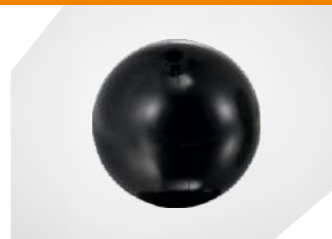
Application areas



Oil Tank Product Bottle
机油罐制品瓶



Dairy Product Bottle
奶制品瓶



Ball Product Bottle
球制品瓶



Laundry Liquid Bottle
洗衣液制品瓶



Seasoning Bottle
调味制品瓶



Barrel Products
桶制品



Dishwashing Product Bottle
洗洁精制品瓶



Special Product
特殊制品

随着消费者可选择的产品越来越多，产品需要更能体现个性、更丰富多彩、使用更加便利。

对各类制品生产商而言，这通常意味着在保证正常生产的同时具备一定的灵活性：

-更独立的产品

-更短的产品周期

-更快的换型

As consumers choose more and more products, products need to be more personalized, more colorful, and more convenient to use.

For manufacturers of various types of products, this usually means a certain degree of flexibility while ensuring normal production:

- More independent products

- shorter product cycle

- faster changeover

PP、PE、EVA、PVCT

提供PP、PE、EVA、PVC瓶的全面解决方案

PROVIDE A COMPREHENSIVE SOLUTION FOR PP、PE、EVA、PVC BOTTLES.



初步评估

根据您的生产目标、产品特性以及铺市计划来进行项目初步评估。

Initial evaluation

According to your plan and product features.



方案确定

根据您的工厂布局讨论并绘制生产线平面布置图，确立最终的项目实施方案。

Plan determination

Make product layout on base of your factory diagram to confirm the final decision.



人员培训

根据您的生产工程人员的技术水平，培训整线及相关设备的操作技巧。

Personnel training

Train the engineer according to his technology.



参数设计

分析并设计您的工程项目技术参数，包括工艺、机械及电气控制设计等。

Parameter design

Analyze and design your technical parameter including the technology, mechanical and electric control.



制造监控

制定和监督您的项目制造进度，直到整体工程通过性能测试验收合格。

Manufacture supervision

Follow up the project until passing the final test.



客户服务

秉承以客户利益为中心的服务理念，为您提供快速、高效的工程的售后服务。

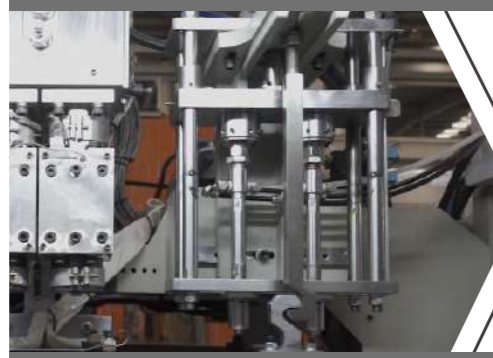
After-sales service

Offer the fast and efficient service customer is the first.

好品质 HIGH QUALITY

始于工艺细节 懂您所需

Excellent process details and we know what you need.

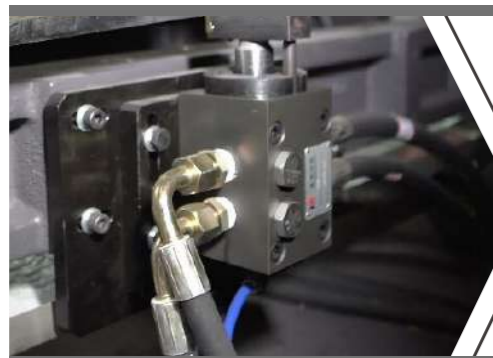


01 插笔结构/Blow Pin Structure

- * 插笔上下运动采用液压油缸驱动,导柱导套导向。
- * 手动前后调节丝杆调节插笔架。
- * Up and down movement for blow pin is driven by hydraulic cylinder, Guide pillar and guide sleeve.
- * Manual front and rear adjustment screw to adjust pen holder.

02 锁模架/Clamping Plate

- * 四导柱平衡式拉推结构,可以容纳超长超宽的模具。
- * 运动导向采用导柱导套。
- * 同步同齿轮装置。
- * Four guide pillar balance pull and push structure, to suitable for over width and over height mold.
- * Movement with guide pillar and guide sleeve.
- * Synchronous gear plant device.



03 锁模架减速阀装置 Clamping Plate Deceleration Valve Device

- * 具有架上架下定位准确。
- * 运行性平稳,能耗低。
- * With accurate positioning on the shelf.
- * Stable operation, low energy consumption.

04 插笔设有瓶内快速冷却系统 Blow Pin With Rapid Cooling System

- * 插笔设有吹气气阀,气循环控制能将瓶内热量吸走。
- * 可选配该功能。
- * Blow pin equipped with blow valve, air circulation control can take away the heat inside the bottle.

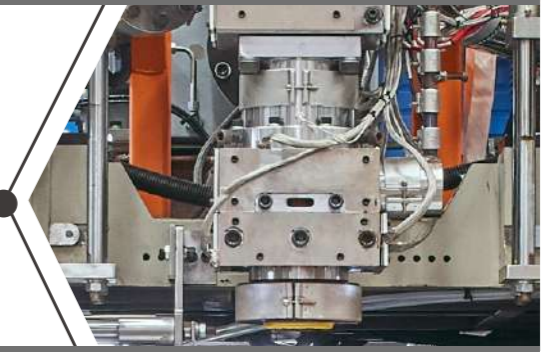


05 除溢装置/Auto deflasher device

- * 搭载自动上打水口功能。
- * 旋切搭载装置。
- * 平推搭载装置。
- * Up and down movement for blow pin is driven by hydraulic cylinder, Guide pillar and guide sleeve.
- * Manual front and rear adjustment screw to adjust pen holder.

06 模头/Die Head

- * 双气缸抬头功能,最大行程50mm。
- * 圆圈调节式模头或前调式模头。
- * Double air cylinder head lifting function, maximum stroke is 50mm.
- * Circular adjustment die head or front adjustment die head.

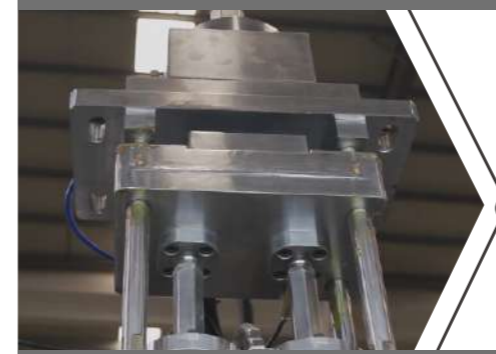
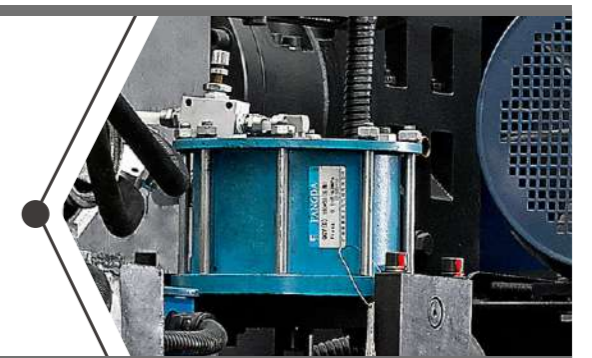


07 平台/Platform

- * 手动平台升降功能,最大行程200mm。
- * 升降采用蜗轮蜗杆减速机。
- * Manual head lifting function, maximum stroke is 200mm.
- * Lifting using worm gear reducer.

08 气动抬头/Air head lifting

- * 运行平稳。
- * 结构简单,成本低。
- * Smooth movement.
- * Simple structure, low cost.



09 壁厚控制系统/Thickness Control System

- * 50点壁厚控制。
- * 伺服阀采用日本油研。
- * 50 points thickness control system.
- * Equipped with Yuken servo valve.



10 挤出系统/Extruder System

- * 机筒入料口设有冷却环
- * 配三相异步电机
- * 国茂减速机
- * The feeding mouth of the barrel is equipped with a cooling ring.
- * Equipped with three - phase asynchronous motor.
- * GUOMAO reducer.

11 排气组件装置/Exhaust component device

- * 新结构快排吹功能。
- * 排气快，制品冷却良好。
- * New structure blow and exhaust function.
- * Fast exhaust and accelerate the cooling.



12 液压插笔/Hydraulic blow pin

- * 搭载液压插笔，多插笔配分气分水块，可拆卸式剪口环。
- * Equipped with hydraulic blow pin, with separate air and water block.



13 双比例阀系统装置 Double proportional valve system

- * PQ阀控制油路流速和压力。
- * 换向阀控制流向，动作流畅快捷。
- * 搭载进口自密封油管接头。
- * Double proportional valve control the flow rate and pressure for oil way.
- * Reversing valve control flow, smooth and fast action.
- * Equipped with imported self-sealing oil pipe joints.

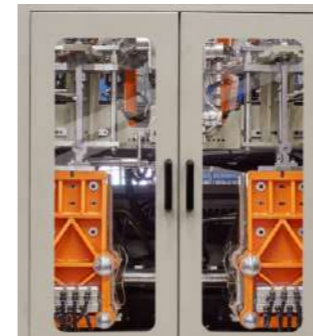


14 切刀/cutter

- * 冷切刀。
- * 热切刀。
- * 封口切刀。
- * Cool cutter
- * Hot cutter
- * Pre-sealing cutter



一次用心选择，只因您比别人更懂它
CHOOSE WITH HEART, ONLY BECAUSE YOU KNOW IT BETTER THAN



安全门/Safe Door

- 组合式，配送瓶架及接料盘配前安全防护网。
- 安全门有联动开关
- Combined type. Distributed bottle rack and receiving plate with before safety protection net.
- The safety door with linkage switch.



自动缺料报警装置 Auto Empty Hopper Alarm Device

- 具有自动缺料报警功能，缺料时，提醒工人及时加料，减少停机时间。
- With auto empty hopper alarm function. Remind workers to feed when empty hopper to reduce shut down period.



润滑系统 Lubrication System

- 自动润滑系统。
- Automatic grease lubrication system.



皮带轮装置 Pulley Gear

- 带动螺杆转动作用。
- 电机皮带轮罩起了安全，保护作用，外观整洁美观。
- Drive screw rotation action. The motor pulley cover is safe protective, and its appearance is neat and beautiful.



温控系统 Temperature Control System

- 模头、机筒、模嘴温度均在HMI屏上显示，电脑控温。
- The temperature of die head, barrel and nozzle are displayed on the HMI screen controlled by computer.



三相异步电机 Three-Phase Asynchronous Motor

- 带动螺杆转动作用。
- Drive screw rotation action.



料斗/Hopper

- 不锈钢料斗
- Stainless Steel Hopper



导瓶杆/Bottle Guide Frame

- 配有导瓶杆，送瓶架。
- 起了导向作用。
- Equipment with bottle guide frame.
- Guide Role.



除溢装置/Auto Deflasher Device

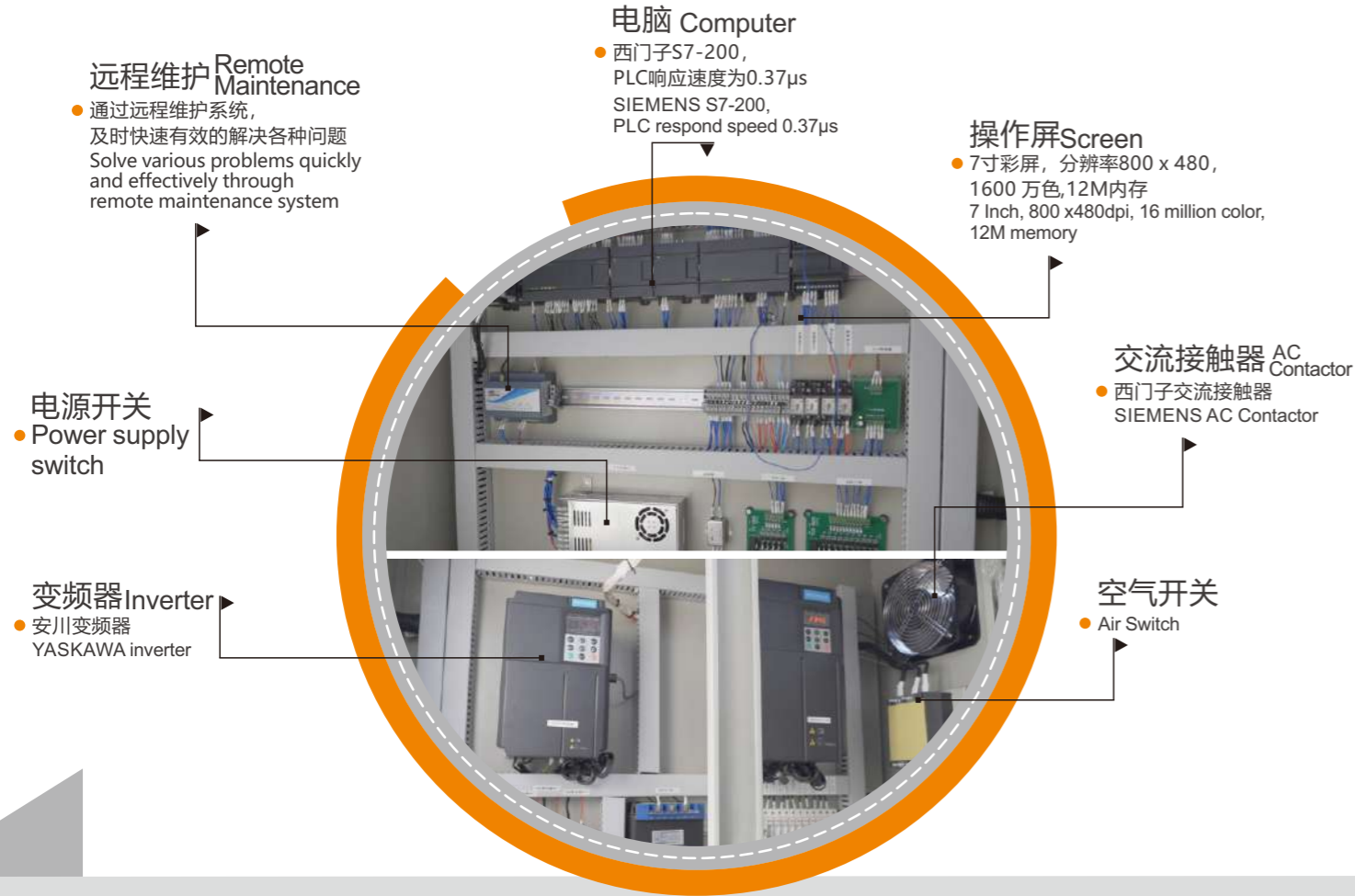
- 用于剔除瓶口多余溢料。
- Use for remove the trimming.



插笔挂钩/Plow Pin Pothook

- 防止插笔时模板向下沉及瓶口容易剪断和平整，起了平衡作用。
- It can prevent the form work from sinking when inserting the pen and the bottle mouth is easy to cut and level off.

电气系统 Electrical system



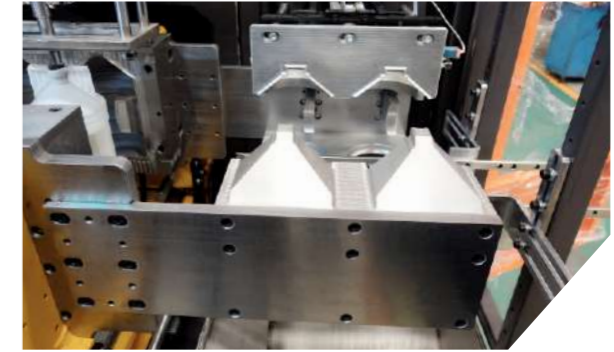
功能系统 Functional system



远程维护 Modern remote maintenance

标配

- PID 多段温控
- 压力、流量、温度、时间参数设定、编辑、存取
- 100套模具工艺参数储存功能;
- 故障报警、记录、自动诊断功能;
- 输入、输出、动作状态、动作时间监控功能;
- 自动计算产量、自动复位功能;
- 中、英文操作界面切换功能;



自动除溢 auto deflasher

Standard

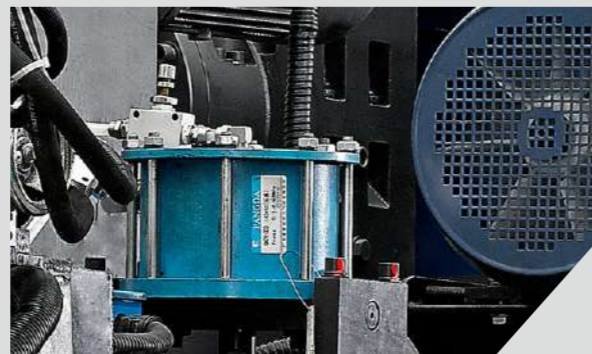
- PID Multistage temperature control
- Pressure, flow, temperature and time parameters can be set, edited, accessed
- Receipt Data Storage of 100 Sets of Mould
- Malfunction Alarm, Malfunction Record, Malfunction Self-diagnose
- Monitoring of Input, Output, Action State and Action Time
- Output Auto-counting, Auto-reset
- Easy Switch Between Chinese and English Interface

气动元件 Pneumatic Parts



气阀 Air Valve

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。
Aventis Electromagnetic Reversing Valve, other Pneumatic parts, such as Relief Valve, Throttle valve, Aerofluxus Valve, Triad-parts, Pressure Meter are from SHAKO or ARI TAC



气缸 Air Cylinder

抬头气缸使用肇庆方大定制气缸, 其余使用台湾新恭或亚德客品牌。
Air Cylinder of Elevating Die Head Is from QGVD, and the others are from SHAKO or ARI TAC.
70U/10F/85 barrel/90barrel and below can be used lifting by air cylinder.

人性化设计 User-Friendly Design

安全防护部分

- 前安全门具有防护开关, 门打开则机器停止动作;
- 设置急停按钮, 按下急停按钮则整机停止动作, 并且切断; 整机控制电路电源;
- 设置紧急开模按钮, 按下紧急开模按钮, 则模板立即打开;
- 缺料报警;
- 挤出机温度超高、超低保护;
- 操作标示及安全警告标志。

Safety Protection

- Protection Switch of Safety Door: Action Stops when Safety Door is Opened
- Emergency Button: Machine Stops and power Supply is Cut off when Emergency Button is Pushed
- Emergency Mould Open Button: Mould Plate opens when Emergency Mould Open Button is Pushed
- Empty Hopper Alarm
- Protecting Extruder from Low Temperature and High Temperature
- Operation Marking and Safety Warrant Sign

选配功能 Optional function



厚薄控制 Thickness Control

- 可通过该功能实现对产品减重。
- It can reduce the weight of the product by this function.



过滤网 Filter Screen

- 过滤回收料中的杂质，提高制品质量。
- Filter out the impurities in the material.



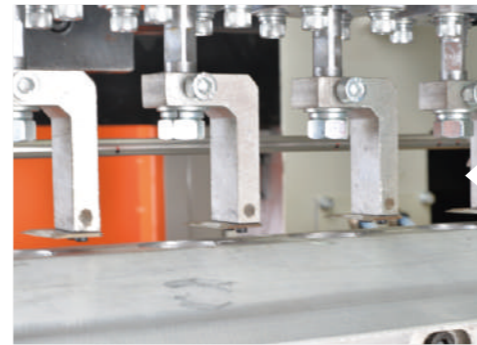
模内贴标 Intra Die Labeling

吹制品前把标签放入模具内，再借用制品本身的热度将标贴紧贴于制品表面。
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.



斜插笔 Slant Blow Pin

根据制品的成型工艺要求；相对特殊的制品，可配置斜插笔。
According to different technological requirements of bottle, for some special one, machine will install slant blow pin.



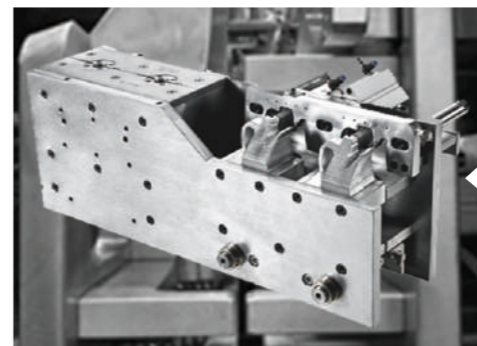
切瓶口装置 Bottle mouth cutting device

- 适用于有气囊设计的产品,自动把气囊部分切除把产品的尾料切除。
- Suitable for airbag design product, auto to cut the airbag and bottom trimming.



二次定径冷却装置 Secondly sizing and cooling device

- 加快吹瓶时瓶样内部表面的冷却速度；
- 提高生产效率，缩短瓶样成型周期；
- Accelerate the cooling inside the bottle.
- Improving production efficiency, shorten cycle time.



打水口装置 Auto deflasher device

- 自动把飞边和尾料切除。
- Auto cut the trimming.



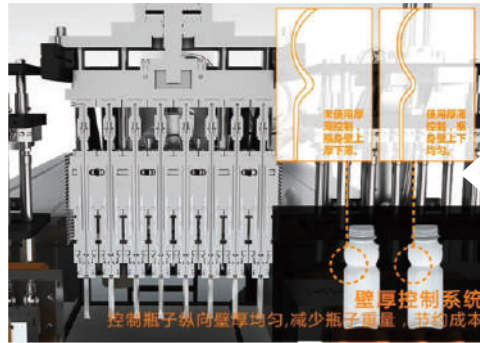
皮带轮装置 Pulley device

- 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.



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.



模具吊装龙门款 Simple mold changing device

- 此装置吊装模具重量不大于1500KG。
- 于用吊装模具。
- This device suitable for mold less than 1500KGS.
- Use for changing mold.



模内贴标 Intra Die 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贴紧贴于制品表面。
- 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.



模具吊装电葫芦装置 Mold hoist device

- 装置吊装模具重量不大于1500KG。
- 操作灵活性强。
- This device suitable for mold less than 1500KGS.
- Flexible operation.



视觉检测 Visual Inspection

- 对制品的外观尺寸和外观光洁度进行检测，适用于人工成本高或招工困难的地区。
- The inspection of the appearance and appearance of the products is suitable for the areas with high labor cost or difficulty in recruiting workers.



换模装置 Changing mold device

- 模装置吊装模具重量不大于800KG。
- 换模装置适用于组合式分体模具。
- This device suitable for mold less than 800KGS.
- This device suitable for conjoin mold.



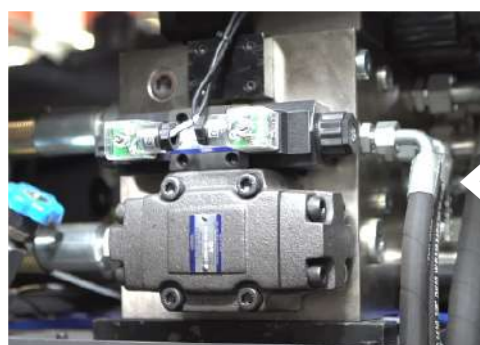
侧打针功能 Side Needle Function

- 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 with no bottle mouth or 2 or more bottles in different directions.



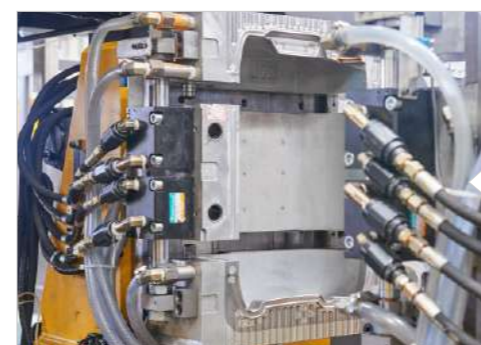
机内锣口装置 Spin trimmer

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



油阀 Oil valve

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



上下开合盖 Open and Close Insert on Mold

- 适用于那种手柄、平底有内凹，且凹进较多的制品。
- Suitable for product has a concave surface.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)	
型号	Model	K-2	K-2
配置代号	Code	SCJ-45K2×1.2D	SCJ 55K2×1.2D
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	2
适用原料	Material	/	PE,PP
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	4000
机器外形尺寸	Machine Dimension	mm,L×H×W	3130X2100X1930
模头 Die Head			
模头加热段数	Die Head Heating Zone	/	2
模头加热功率	Die Head Heating Power	kW	3.5
开合模系统 Clamping Unit			
模架数量	No.Of Station	/	3.5
最小合模距	Min Clamping Distance Of Mold	mm	130
最大开模距	Max Clamping Distance Of Mold	mm	330
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W250×H320
摆架行程	Carriage Stroke	mm	400
锁模力	Clamping Force	kN	27
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	45
螺杆长径比	Extruder Length/Diameter Ratio	L/D	32
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-60
最大塑化能力	Max Extrusion Capacity	kg/h	20
挤出电机功率	Extruder Motor Power	kW	7.5
机筒加热段数	Barrel Heating Zone	/	3
机筒加热功率	Barrel Heating Power	kW	4.3
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	5.5
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	16
热切刀变频器功率	Hot Cutter Power	kW	2
装机总功率I	Total Installed Power	kW	22.92
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L
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	5.5
装机总功率II	Total Installed Power II	kW	28.42
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	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)	
型号	Model	K-2	K-2
配置代号	Code	SCJ 55K2×2.2D	SCJ 55K2×4.2D
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	2
适用原料	Material	/	PE,PP
模头坯料数量	No.Of Die Head	/	1
模头中心距	Die Head Distance (Center to Center)	mm	120-160
机器净重约	Net Weight	kg	3400
机器外形尺寸	Machine Dimension	mm,L×H×W	3130X2100X1930
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	4.1
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	130
最大开模距	Max Clamping Distance Of Mold	mm	330
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W250×H320
摆架行程	Carriage Stroke	mm	400
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	23
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-60
最大塑化能力	Max Extrusion Capacity	kg/h	32
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	6
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	5.5
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
热切刀变频器功率	Hot Cutter Power	kW	2
装机总功率I	Total Installed Power	kW	28.72
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L
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	5.5
装机总功率II	Total Installed Power II	kW	34.22
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.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)				
型号	Model	K-2		K-2		
配置代号	Code	SCJ 55-40K2×1.2D		SCJ 55-40K2×2.2D		
基本参数 Specification						
项目	Items	Units	参数Specification			
类别	Category	/	双层 2 layers		双层 2 layers	
制品最大容量	Max. Blow Volume	L	2		1	
适用原料	Material	/	PE,PP		PE,PP	
模头坯料数量	No.Of Die Head	/	1		2	
模头中心距	Die Head Distance (Center to Center)	mm	/		100-120	
机器净重约	Net Weight	kg	4000		4400	
机器外形尺寸	Machine Dimension	mm,L×H×W	3130X2100X1930		3130X2100X1930	
模头 Die Head						
模头加热段数	Die Head Heating Zone	/	3		3	
模头加热功率	Die Head Heating Power	kW	4		2.7	
开合模系统 Clamping Unit						
模架数量	No.Of Station	/	2		2	
最小合模距	Min Clamping Distance Of Mold	mm	130		130	
最大开模距	Max Clamping Distance Of Mold	mm	330		330	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W250×H320		250X300	
摆架行程	Carriage Stroke	mm	400		400	
锁模力	Clamping Force	kN	27		27	
挤出系统 Extruder Unit						
螺杆直径	Extruder Diameter	mm	55	40	55	40
螺杆长径比	Extruder Length/Diameter Ratio	L/D	23	24	23	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-60	20-40	20-60	20-40
最大塑化能力	Max Extrusion Capacity	kg/h	32	10	32	10
挤出电机功率	Extruder Motor Power	kW	11	5.5	11	5.5
机筒加热段数	Barrel Heating Zone	/	3	3	3	3
机筒加热功率	Barrel Heating Power	kW	6	4.3	6	4.3
冷却风机功率	Cooling Fan Power	kW	0.12	0.04	0.12	0.04
动力系统 Power Unit						
油泵电机额定功率	Oil Pump Motor Rated Power	kW	5.5		5.5	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14		14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8		0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4		0.4	
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	19		19	
热切刀变频器功率	Hot Cutter Power	kW	2		2	
装机总功率I	Total Installed Power	kW	38.43		37.16	
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L		46#/160L	
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5		5	
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10		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		5.5	
装机总功率II	Total Installed Power II	kW	43.96		42.66	
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	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)				
型号	Model	K-2		K-2		
配置代号	Code	SCJ 55-25K2×1.2D		SCJ 55-40-25K2×1.2D		
基本参数 Specification						
项目	Items	Units	参数Specification			
类别	Category	/	单层+液位线 1 layer with view stripe		双层+液位线 2 layers with view stripe	
制品最大容量	Max. Blow Volume	L	2		2	
适用原料	Material	/	PE,PP		PE,PP	
模头坯料数量	No.Of Die Head	/	1		1	
模头中心距	Die Head Distance (Center to Center)	mm	/		/	
机器净重约	Net Weight	kg	4400		3500	
机器外形尺寸	Machine Dimension	mm,L×H×W	3130X2100X1930		3130X2100X1930	
模头 Die Head						
模头加热段数	Die Head Heating Zone	/	6		3	
模头加热功率	Die Head Heating Power	kW	5.5		3.5	
开合模系统 Clamping Unit						
模架数量	No.Of Station	/	2		2	
最小合模距	Min Clamping Distance Of Mold	mm	130		130	
最大开模距	Max Clamping Distance Of Mold	mm	330		330	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W250×H320		W250×H320	
摆架行程	Carriage Stroke	mm	400		400	
锁模力	Clamping Force	kN	27		27	
挤出系统 Extruder Unit						
螺杆直径	Extruder Diameter	mm	55	25	55	25
螺杆长径比	Extruder Length/Diameter Ratio	L/D	23	22	23	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-60	20-25	20-60	20-40
最大塑化能力	Max Extrusion Capacity	kg/h	32	2	32	10
挤出电机功率	Extruder Motor Power	kW	11	2.2	11	5.5
机筒加热段数	Barrel Heating Zone	/	3	2	3	3
机筒加热功率	Barrel Heating Power	kW	6	1.7	6	4.3
冷却风机功率	Cooling Fan Power	kW	0.12	/	0.12	0.4
动力系统 Power Unit						
油泵电机额定功率	Oil Pump Motor Rated Power	kW	5.5		5.5	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14		14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8		0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4		0.4	
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	19		19	
热切刀变频器功率	Hot Cutter Power	kW	2		2	
装机总功率I	Total Installed Power	kW	34.02		42.22	
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L		46#/160L	
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5		5	
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10		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		5.5	
装机总功率II	Total Installed Power II	kW	39.52		47.72	
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.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)	
型号	Model	K-5	K-5
配置代号	Code	SCJ-65K2×1.5D	SCJ 65K2×2.5D
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	2
适用原料	Material	/	PE,PP
模头坯料数量	No.Of Die Head	/	1
模头中心距	Die Head Distance (Center to Center)	mm	160
机器净重约	Net Weight	kg	4600
机器外形尺寸	Machine Dimension	mm,L×H×W	3400X2200X2100
模头 Die Head			
模头加热段数	Die Head Heating Zone	/	2
模头加热功率	Die Head Heating Power	kW	4
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	200
最大开模距	Max Clamping Distance Of Mold	mm	450
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W300×H400
摆架行程	Carriage Stroke	mm	450
锁模力	Clamping Force	kN	43
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	65
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-67
最大塑化能力	Max Extrusion Capacity	kg/h	60
挤出电机功率	Extruder Motor Power	kW	15
机筒加热段数	Barrel Heating Zone	/	3
机筒加热功率	Barrel Heating Power	kW	7
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	7.5
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	14
热切刀变频器功率	Hot Cutter Power	kW	2
装机总功率I	Total Installed Power	kW	35.62
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L
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		kW	5.5
装机总功率II		kW	41.12
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	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)	
型号	Model	K-5	K-5
配置代号	Code	SCJ 65K2×3.5D	SCJ 65K2×4.5D
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	/	3
模头中心距	Die Head Distance (Center to Center)	mm	110
机器净重约	Net Weight	kg	4600
机器外形尺寸	Machine Dimension	mm,L×H×W	3400X2200X2100
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	6
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	200
最大开模距	Max Clamping Distance Of Mold	mm	450
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W300×H400
摆架行程	Carriage Stroke	mm	450
锁模力	Clamping Force	kN	43
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	65
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-67
最大塑化能力	Max Extrusion Capacity	kg/h	60
挤出电机功率	Extruder Motor Power	kW	15
机筒加热段数	Barrel Heating Zone	/	3
机筒加热功率	Barrel Heating Power	kW	7
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	7.5
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	21
热切刀变频器功率	Hot Cutter Power	kW	2
装机总功率I	Total Installed Power	kW	37.62
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L
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	5.5
装机总功率II	Total Installed Power II	kW	43.12
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.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)			
型号	Model	K-5		K-5	
配置代号	Code	SCJ 65-45K2×1.5D		SCJ 65-45K2×2.5D	
基本参数 Specification					
项目	Items	Units	参数Specification		
类别	Category	/	双层 2 layers	双层 2 layers	
制品最大容量	Max. Blow Volume	L	5	2	
适用原料	Material	/	PE,PP	PE,PP	
模头坯料数量	No.Of Die Head	/	1	120-160	
模头中心距	Die Head Distance (Center to Center)	mm	/	160	
机器净重约	Net Weight	kg	4400	4400	
机器外形尺寸	Machine Dimension	mm,L×H×W	3400X2200X2100		3400X2200X2100
模头 Die Head					
模头加热段数	Die Head Heating Zone	/	5	5	
模头加热功率	Die Head Heating Power	kW	6.5	3.1	
开合模系统 Clamping Unit					
模架数量	No.Of Station	/	2	2	
最小合模距	Min Clamping Distance Of Mold	mm	200	200	
最大开模距	Max Clamping Distance Of Mold	mm	450	450	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W300×H400		W300×H400
摆架行程	Carriage Stroke	mm	450	450	
锁模力	Clamping Force	kN	43	43	
挤出系统 Extruder Unit					
螺杆直径	Extruder Diameter	mm	65	65	45
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24	24	21
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-67	20-40	20-40
最大塑化能力	Max Extrusion Capacity	kg/h	60	14	14
挤出电机功率	Extruder Motor Power	kW	15	5.5	5.5
机筒加热段数	Barrel Heating Zone	/	3	3	3
机筒加热功率	Barrel Heating Power	kW	7	4.5	4.5
冷却风机功率	Cooling Fan Power	kW	0.12	0.04	0.04
动力系统 Power Unit					
油泵电机额定功率	Oil Pump Motor Rated Power	kW	7.5	7.5	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14	14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8	0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4	0.4	
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	14	20	
热切刀变频器功率	Hot Cutter Power	kW	2	2	
装机总功率I	Total Installed Power	kW	43.65	44.76	
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L		46#/160L
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5	5	
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10	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		kW	5.5	5.5	
装机总功率II		kW	49.16	50.26	
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	Catrrory	K型机系列(4导柱型) K Series(4 Tie Bar)			
型号	Model	K-5		K-5	
配置代号	Code	SCJ 65-25K2×1.5D		SCJ 65-45-25K2×1.5D	
基本参数 Specification					
项目	Items	Units	参数Specification		
类别	Category	/	单层+液位线 1 layer with view stripe	双层+液位线 2 layers with view stripe	
制品最大容量	Max. Blow Volume	L	5	5	
适用原料	Material	/	PE,PP	PE,PP	
模头坯料数量	No.Of Die Head	/	1	1	
模头中心距	Die Head Distance (Center to Center)	mm	/	/	
机器净重约	Net Weight	kg	4400	4600	
机器外形尺寸	Machine Dimension	mm,L×H×W	3400X2200X2100		3400X2200X2100
模头 Die Head					
模头加热段数	Die Head Heating Zone	/	5	5	
模头加热功率	Die Head Heating Power	kW	8.2	3.5	
开合模系统 Clamping Unit					
模架数量	No.Of Station	/	2	2	
最小合模距	Min Clamping Distance Of Mold	mm	200	200	
最大开模距	Max Clamping Distance Of Mold	mm	450	250	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W300×H400		W300×H400
摆架行程	Carriage Stroke	mm	450	450	
锁模力	Clamping Force	kN	43	43	
挤出系统 Extruder Unit					
螺杆直径	Extruder Diameter	mm	65	25	65
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24	22	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-67	20-25	20-67
最大塑化能力	Max Extrusion Capacity	kg/h	60	2	60
挤出电机功率	Extruder Motor Power	kW	15	2.2	15
机筒加热段数	Barrel Heating Zone	/	3	2	3
机筒加热功率	Barrel Heating Power	kW	7	1.7	7
冷却风机功率	Cooling Fan Power	kW	0.12	/	0.12
动力系统 Power Unit					
油泵电机额定功率	Oil Pump Motor Rated Power	kW	7.5	7.5	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	16	14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8	0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4	0.4	
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	14	14	
热切刀变频器功率	Hot Cutter Power	kW	2	2	
装机总功率I	Total Installed Power	kW	43.72	49.06	
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L		46#/160L
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5	5	
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10	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	5.5	
装机总功率II	Total Installed Power II	kW	49.22	54.56	
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.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Category	K型机系列(4导柱型) K Series(4 Tie Bar)	
型号	Model	K-10	K-10
配置代号	Code	SCJ 75K2×1.10D	SCJ 75K2×2.10D
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	7
适用原料	Material	/	PE,PP
模头坯料数量	No.Of Die Head	/	1
模头中心距	Die Head Distance (Center to Center)	mm	170.200
机器净重约	Net Weight	kg	6300
机器外形尺寸	Machine Dimension	mm,L×H×W	3930X2500X2200
模头 Die Head			
模头加热段数	Die Head Heating Zone	/	2
模头加热功率	Die Head Heating Power	kW	9.5
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	230
最大开模距	Max Clamping Distance Of Mold	mm	580
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W380×H460
摆架行程	Carriage Stroke	mm	500
锁模力	Clamping Force	kN	100
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	75
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-63/ (20-78)
最大塑化能力	Max Extrusion Capacity	kg/h	95/(105)
挤出电机功率	Extruder Motor Power	kW	22/(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	0.3
动力系统 Power Unit			
油泵电机额定功率	Oil Pump Motor Rated Power	kW	11
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	15
热切刀变频器功率	Hot Cutter Power	kW	2
装机总功率I	Total Installed Power	kW	54.8/(62.8)
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/200L
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	5.5
装机总功率II	Total Installed Power II	kW	60.3/(68.3)
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	K型机系列(4导柱型) K Series(4 Tie Bar)	
型号	Model	K-10	K-10
配置代号	Code	SCJ 75K2×4.10D	SCJ 75-55K2×1.10D
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	/	4
模头中心距	Die Head Distance (Center to Center)	mm	85.100
机器净重约	Net Weight	kg	6300
机器外形尺寸	Machine Dimension	mm,L×H×W	3930X2500X2200
模头 Die Head			
模头加热段数	Die Head Heating Zone	/	9
模头加热功率	Die Head Heating Power	kW	8.5
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	230
最大开模距	Max Clamping Distance Of Mold	mm	580
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W380×H460
摆架行程	Carriage Stroke	mm	500
锁模力	Clamping Force	kN	100
挤出系统 Extruder Unit			
螺杆直径	Extruder Diameter	mm	75
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-63/ (20-78)
最大塑化能力	Max Extrusion Capacity	kg/h	95/(105)
挤出电机功率	Extruder Motor Power	kW	22/(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	0.3
动力系统 Power Unit			
油泵电机额定功率	Oil Pump Motor Rated Power	kW	11
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	15
热切刀变频器功率	Hot Cutter Power	kW	2
装机总功率I	Total Installed Power	kW	53.8/(61.8)
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	8
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	59.3/67.3
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.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Category	K型机系列(4导柱型) K Series(4 Tie Bar)			
型号	Model	K-10		K-10	
配置代号	Code	SCJ 75-55K2×2.10D		SCJ 75-25K2×1.10D	
基本参数 Specification					
项目	Items	Units	参数Specification		
类别	Category	/	双层 2 layers	单层+液位线 1 layer with view stripe	
制品最大容量	Max. Blow Volume	L	5	7	
适用原料	Material	/	PE,PP	PE,PP	
模头坯料数量	No.Of Die Head	/	2	1	
模头中心距	Die Head Distance (Center to Center)	mm	160.200	/	
机器净重约	Net Weight	kg	7000	7000	
机器外形尺寸	Machine Dimension	mm,L×H×W	3930X2500X2200		3930X2500X2200
模头 Die Head					
模头加热段数	Die Head Heating Zone	/	6	3	
模头加热功率	Die Head Heating Power	kW	12.5	10	
开合模系统 Clamping Unit					
模架数量	No.Of Station	/	2	2	
最小合模距	Min Clamping Distance Of Mold	mm	230	230	
最大开模距	Max Clamping Distance Of Mold	mm	580	580	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W380×H460		W380×H460
摆架行程	Carriage Stroke	mm	500	500	
锁模力	Clamping Force	kN	100	125	
挤出系统 Extruder Unit					
螺杆直径	Extruder Diameter	mm	75	55	25
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24	23	22
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-63	20-40	20-25
最大塑化能力	Max Extrusion Capacity	kg/h	90/(100)	25	90
挤出电机功率	Extruder Motor Power	kW	22/(30)	7.5	22/(30)
机筒加热段数	Barrel Heating Zone	/	3	3	2
机筒加热功率	Barrel Heating Power	kW	10	6.2	10
冷却风机功率	Cooling Fan Power	kW	0.3	0.08	0.3
动力系统 Power Unit					
油泵电机额定功率	Oil Pump Motor Rated Power	kW	11	11	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14	14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8	0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4	0.4	
通用制品耗气量(压缩后)	Universal product air consumption(compressed)	M³/H	17	15	
热切刀变频器功率	Hot Cutter Power	kW	2	2	
装机总功率I	Total Installed Power	kW	71.58/(79.58)		59.2/(67.2)
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/200L		46#/200L
冷水机选型(风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	8	8	
空压机选型(加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10	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		5.5
装机总功率II	Total Installed Power II	kW	77.08/(85.08)		64.7/(72.7)
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	K型机系列(4导柱型) K Series(4 Tie Bar)			
型号	Model	K-10		K-2	
配置代号	Code	SCJ 75-55-25K2×1.10D		65K2×6.2D-A (乐百氏专机)	
基本参数 Specification					
项目	Items	Units	参数Specification		
类别	Category	/	双层+液位线 2 layers with view stripe	单层 1 layer	
制品最大容量	Max. Blow Volume	L	7	0.25	
适用原料	Material	/	PE,PP	PE,PP	
模头坯料数量	No.Of Die Head	/	1	6	
模头中心距	Die Head Distance (Center to Center)	mm	/	70	
机器净重约	Net Weight	kg	7000	5000	
机器外形尺寸	Machine Dimension	mm,L×H×W	3930X2500X2200		3465X2160X3304
模头 Die Head					
模头加热段数	Die Head Heating Zone	/	2	13	
模头加热功率	Die Head Heating Power	kW	9.2	6	
开合模系统 Clamping Unit					
模架数量	No.Of Station	/	2	2	
最小合模距	Min Clamping Distance Of Mold	mm	230	160	
最大开模距	Max Clamping Distance Of Mold	mm	580	310	
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W380×H460		W380×H270
摆架行程	Carriage Stroke	mm	500	500	
锁模力	Clamping Force	kN	100	27	
挤出系统 Extruder Unit					
螺杆直径	Extruder Diameter	mm	75	55	65
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24	23	22
螺杆转速	Extruder Rotating Speed/r/min	r/min	20-63	20-40	20-25
最大塑化能力	Max Extrusion Capacity	kg/h	90	30	70
挤出电机功率	Extruder Motor Power	kW	22/(30)	7.5	2.2
机筒加热段数	Barrel Heating Zone	/	3	3	2
机筒加热功率	Barrel Heating Power	kW	10	6.2	7
冷却风机功率	Cooling Fan Power	kW	0.3	0.08	0.12
动力系统 Power Unit					
油泵电机额定功率	Oil Pump Motor Rated Power	kW	11	7.5	
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14	14	
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8	0.8	
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4	0.4	
通用制品耗气量(压缩后)	Universal product air consumption(compressed)	M³/H	15	24	
热切刀变频器功率	Hot Cutter Power	kW	2	2	
装机总功率I	Total Installed Power	kW	72.18/(80.18)		37.62
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/200L		46#/160L
冷水机选型(风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	8	5	
空压机选型(加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10	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		5.5
装机总功率II	Total Installed Power II	kW	77.68/(85.68)		43.12
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.

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

系列	Category	K型机系列(4导柱型) K Series(4 Tie Bar)			
型号	Model	K-2	K-5	K-5	
配置代号	Code	65K2×6.2D-A (乐百氏专机)	SCJ 75K+S2×6.5D-A	SCJ 75K2×4.5D-A	
基本参数 Specification					
项目	Items	Units	参数Specification		
类别	Category	/	单层 1 layer	单层 1 layer	单层 1 layer
制品最大容量	Max. Blow Volume	L	0.5	0.5	1.25
适用原料	Material	/	PE,PP	PE,PP	PE,PP
模头坯料数量	No.Of Die Head	/	4	6	4
模头中心距	Die Head Distance (Center to Center)	mm	90	80	125
机器净重约	Net Weight	kg	5000	6500	6500
机器外形尺寸	Machine Dimension	mm,L×H×W	3500X3300X2200	3350X2420X3900	3350X2420X3900
模头 Die Head					
模头加热段数	Die Head Heating Zone	/	9	13	13
模头加热功率	Die Head Heating Power	kW	5	7.3	6.5
开合模系统 Clamping Unit					
模架数量	No.Of Station	/	2	2	2
最小合模距	Min Clamping Distance Of Mold	mm	160	200	200
最大开模距	Max Clamping Distance Of Mold	mm	310	360	360
模板尺寸	Effective Dimension Of Mold Plate	mm W×H	W380×H270	W480×H400	W480×H400
摆架行程	Carriage Stroke	mm	500	600	600
锁模力	Clamping Force	kN	27	70	70
挤出系统 Extruder Unit					
螺杆直径	Extruder Diameter	mm	65	75	75
螺杆长径比	Extruder Length/Diameter Ratio	L/D	24	24	24
螺杆转速	Extruder Rotating Speed/min	r/min	20-67	20-83	20-83
最大塑化能力	Max Extrusion Capacity	kg/h	60	125	125
挤出电机功率	Extruder Motor Power	kW	15	22/(30)	22/(30)
机筒加热段数	Barrel Heating Zone	/	3	3	3
机筒加热功率	Barrel Heating Power	kW	7	10	10
冷却风机功率	Cooling Fan Power	kW	0.12	0.3	0.3
动力系统 Power Unit					
油泵电机额定功率	Oil Pump Motor Rated Power	kW	7.5	7.5	7.5
液压系统额定工作压力	Hydraulic System Rated Working Pressure	Mpa	14	14	14
气动系统额定工作压力	Pneumatic System Rated Working Pressure	Mpa	0.8	0.8	0.8
水冷系统额定工作压力	Cooling System Rated Working Pressure	Mpa	0.4	0.4	0.4
通用制品耗气量 (压缩后)	Universal product air consumption(compressed)	M ³ /H	21	22	6
热切刀变频器功率	Hot Cutter Power	kW	2	2	2
装机总功率I	Total Installed Power	kW	36.62	49.1/(57.1)	48.3/(56.3)
液压油牌号/油箱容积	Hydraulic oil NO. / tank volume	L	46#/160L	46#/160L	46#/160L
冷水机选型 (风冷/水冷)	Chiller recommend (air-cooled/ water-cooled)	hp	5	8	8
空压机选型 (加储气罐)	Air compressor recommend (Add gas storage tank)	hp	10	10	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	5.5	5.5
装机总功率II	Total Installed Power II	kW	42.12	54.6/(62.5)	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.

模块Unit	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	●	
	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、螺旋式上料机等所用料斗Equipped 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 filter net changing mechanism (Frame assembly need to be changed)		○
	液压换网机构(机架总成需变更)Hydraulic filter 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		○
	四导柱锁模机构Four guide pillar clamping locking	●	
	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	●	
	摆架运动采用减速阀Station movement use reduction valve	●	
	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		○	
机架部分 Frame Parts	前后整体式机架Front and rear integral frame	●	
	手动升降Manual lifting	●	
	升降用蜗轮蜗杆减速机Lifting Worm Gear Reducer	●	
	气动抬头机构Pneumatic lifting head mechanism	●	
	预留机械手安装位置Reserved the position for robot hand	●	
	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		○	
避震脚Foot shock		○	
安全门部分 Safety Door Parts	标准K型机安全门外观(参考画册)Standard K-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	●	
	悬挂式后门Hanging rear door	●	
	前安全门防护网Front safety door protection net	●	
	送瓶架Bottle guide rod	●	
导瓶杆Bottle guide frame	●		
与标准配色不同的配色要求Different color requirements from standard color		○	

K型塑料中空挤出吹瓶机系列

K Series Extrusion Blow Molding Machine

模块Unit	功能配置Configuration and Function	标准配置 Standard configuration	备选配置 Optional configuration
插笔架 部分 Blow Pin Parts	插笔上下运动采用液压油缸驱动，导柱导套pen up and down movement is driven by a hydraulic cylinder, guide post guide is guided.	●	
	手动手轮左右调节插笔架Manual handwheel to adjust the pen holder	●	
	手动前后调节丝杆调节插笔架Manual front and rear adjustment screw adjustment pen holder	●	
	前调式插笔杆Pre-modulation blow pin	●	
	多插笔配分气分水块Multi blow pin with air and water distributor	●	
	可拆卸式剪口环Removable cutting ring	●	
	侧打针装置Side inject blowing system		○
	气循环插笔Air circulation blow pin		○
	下插笔架Lower pen holder		○
	插笔杆带导向功能Plunger with guiding function		○
	旋转式斜插笔架Rotary oblique blow pin		○
	插笔架带简易机械手功能blow pin		○
	上提式插笔架Uplift blow pin		○
	切刀部分 Knife Parts	通用冷热共用切刀（横向）Universal hot and cold sharing knife (horizontal)	●
1-2千瓦热切刀变压器1-2 KW hot knife transformer		●	
通用热切刀（前后）Universal hot knife (front and rear)			○
封口切刀Seal knife			○
多模头特殊用冷切刀Multi-die head special cold knife			○
冷切刀片Cold cutting blade			○
进口热切刀片Imported hot cutting blade		○	
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	●	
	汇川变频器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	●	
	左右摆架自动平衡系统；Station auto-balanced system	●	
	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	●	
	模咀调温器Die nozzle thermostat	●	
	远程维护系统Remote maintenance system	●	○
	模内贴标功能In-mold labeling program		○
	侧打针功能Side inject blowing system		○
	模具抽芯功能Mold pin moving system		○
	二次合模功能Secondary mold closing function		○
	西门子 12 显示屏SIEMENS 12 Inch Color Touch Screen		○
	模头防静电装置Die head static remover		○
	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		○	
对射式光幕Light curtain		○	
其他语言操作界面Other language operation screen		○	
电动100点壁厚控制系统100 points servo parison control system		○	
模具顶出功能		○	

模块Unit	功能配置Configuration and Function	标准配置 Standard configuration	备选配置 Optional configuration
液压系统 部分 Hydraulic System Parts	海特克双联叶片泵Haitek double vane pump	●	
	油研液控阀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	●	
	扣压式软管总成Buckling hose assembly	●	
	三相异步电机Three phrase asynchronous motor	●	
	油箱Oil tank	●	
	海特克双联叶片泵HIGH-TECH Double pump	●	
	汇川控制器INOVANCE Inverter	●	
	内啮合齿轮泵Internal gear pump		○
	储能器Accumulator		○
伺服电机 servo motor		○	
液压抬头功能Hydraulic lifting head function		○	
模具开合盖功能Mold stretching function			
平台左右移动功能Platform left and right movement function			
气动系统 Pneumatic Parts	空气净化器Air cleaner	●	
	三联件Triple piece	●	
	标准气缸Standard air cylinder	●	
	安沃驰膜片式电磁换向阀Aventis electromagnetic reversing Valve	●	
	方大抬头气缸Die head elevating is from QGVD	●	
	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		○	
插笔用储气罐（15L机器标配）Blow pin use air compressor(standard configuration for 15L machine)		○	
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Available to purchase 0#, 00# lithium grease		○
冷却系统 Cooling System	模具运水一进一出，管径不小于1.25寸mold water is transported in and out, pipe diameter is not less than 1.25 inches.	●	
	模具分水块Mold water distributor	●	
	涡流水流量计Vortex flowmeter		○
除溢装置 Deflasher	平推式除溢装置Horizontal deflasher		○
	旋切式除溢装置Turing deflasher		○
	机内锣口机(左右) In-machine spin trimmer(Left&right)		○
	线上锣口机(单套) Online spin trimmer(One set)		○
	模具一体式除溢装置Mold integrated deflasher		○