

YH178SP

外形尺寸 / Dimension Of Exterior

冷却水分配器、配电箱进线孔、工业插座 / 位置尺寸
Cooling water distribution box, distribution box into the ine hole, industrial socket / Position Size

模板尺寸 / Dimension Of Templet

动模板 / Movable platen

定模板 / Fixed platen

机器安装尺寸 / Machine installation size

YH268SP

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YH/SP 高速薄壁餐盒专用系列注塑机
YH/SP High-speed Thin-wall Lunchbox Dedicated Injection Molding Machine

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ISO9001:2008质量管理体系认证

YH428SP

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YH358SP

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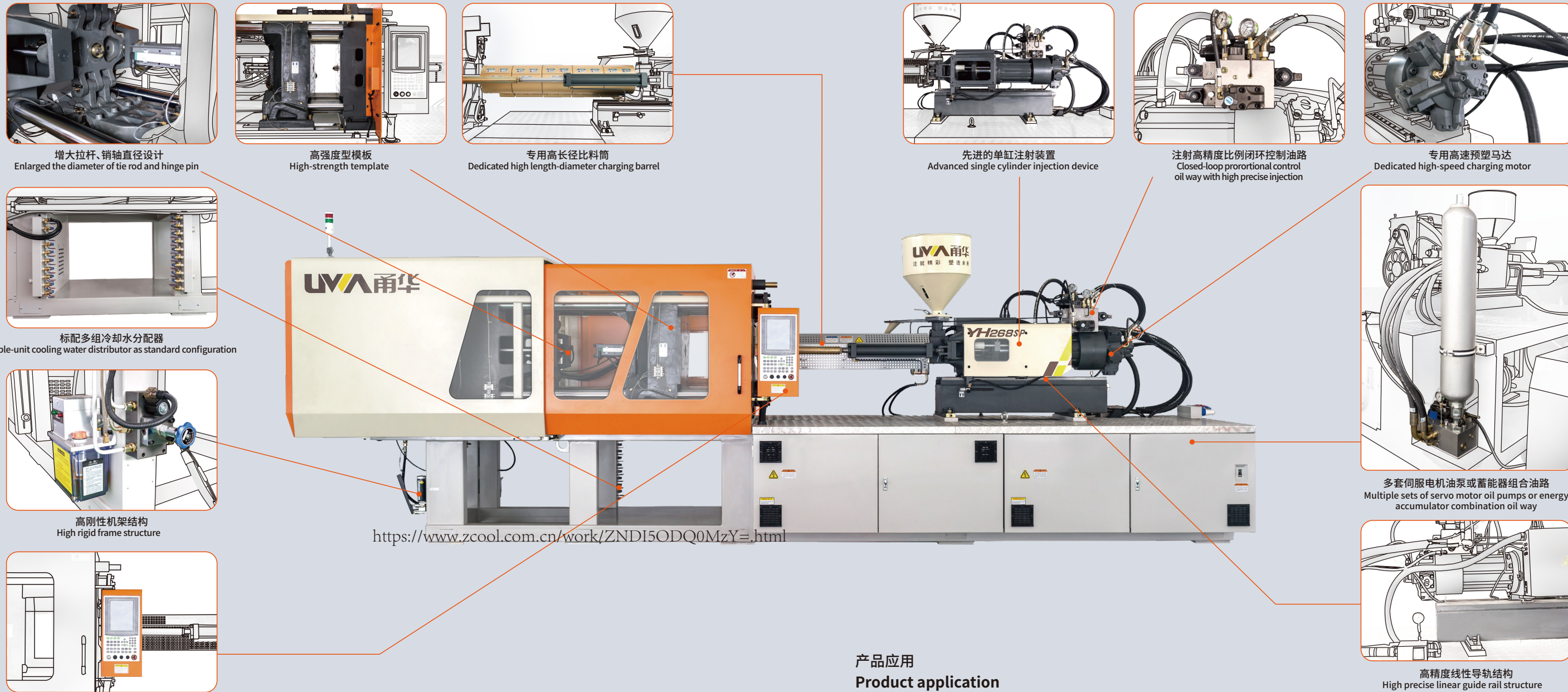
冷却水分配器、配电箱进线孔、工业插座 / 位置尺寸
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增大拉杆、销轴直径设计
Enlarged the diameter of tie rod and hinge pin

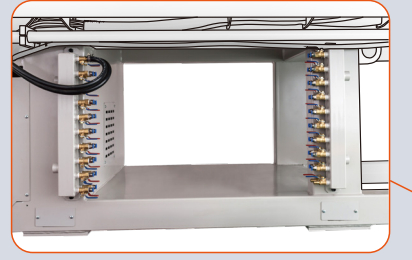
高强度型模板
High-strength template

专用高长径比料筒
Dedicated high length-diameter charging barrel

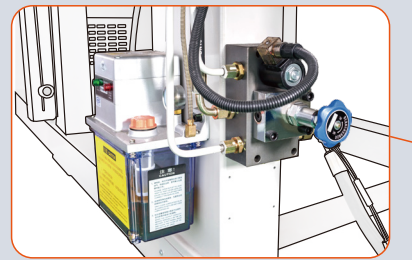
先进的单缸注射装置
Advanced single cylinder injection device

注射高精度比例闭环控制油路
Closed-loop proportional control oil way with high precise injection

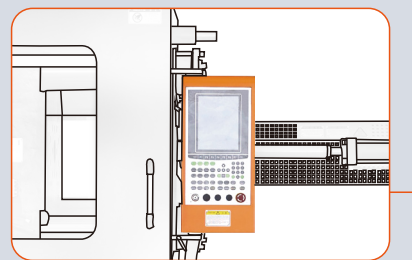
专用高速预塑马达
Dedicated high-speed charging motor



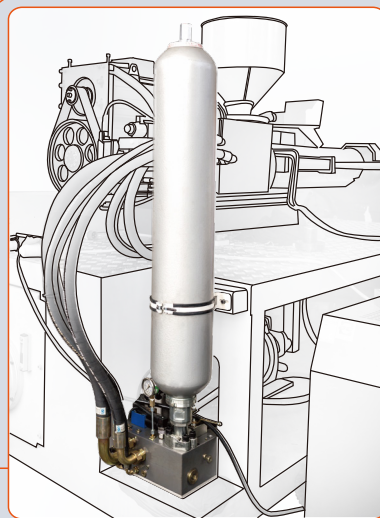
标配多组冷却水分配器
Multiple-unit cooling water distributor as standard configuration



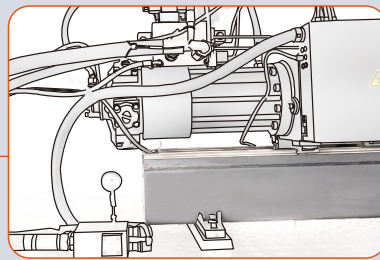
高刚性机架结构
High rigid frame structure



意大利 INOVA 电脑
Italian INOVA computer



多套伺服电机油泵或蓄能器组合油路
Multiple sets of servo motor oil pumps or energy accumulator combination oil way



高精度线性导轨结构
High precise linear guide rail structure

产品应用

Product application



餐盒
boxes

冰激凌杯
Ice cream cup

冰激凌杯
Ice cream cup

甬华YH/SP高速薄壁餐盒专用系列注塑机

甬华YH/SP系列机型采用高速低压注射和多动作复合运行相结合的先进设计理念,对合模机构、控制系统及油路系统进行重新设计并作强化处理,通过提高所有动作的运行速度并采用多动作的复合运行,大幅缩短薄壁制品的生产周期,与普通机型相比成型周期更短,生产效率更高;全新设计的机械结构及熔胶马达负载更轻,设备运行平稳,延长了机器使用时间,同时采用节能的伺服动力系统,大大降低了生产成本。

本系列注塑机主要适用于加工:快餐盒、酸奶包装盒、冰淇淋盒、PS航空杯、一次性餐具、瓶盖等各种薄壁成型制品。

Yonghua YH/SP High-speed Thin-wall Lunchbox Dedicated Injection Molding Machine

Yonghua YH/SP series model adopted the advanced design concept of combining high-speed low-pressure injection with multiple-action operation; it redesigned clamping mechanism structure, control system and oil-way system, and reinforced them; by means of improving the operation speed of all actions and adopting multi-action compound operation, it shortened the production cycle of thin-wall products, whose formation cycle is shorter with higher production efficiency compared with ordinary model. The newly designed load of mechanism structure and glue motor is lighter, which made the device to operate stably and it lengthened equipment service life; meanwhile, the application of energy-saving servo dynamical system greatly reduced production cost.

This series of injection molding machine is mainly suitable for processing various thin-wall molding products such as lunchbox, yogurt-packing box, ice cream box, PS aviation cup, disposal tableware, and bottle cap and other kinds of thin wall plastic products.

整体:

全新设计的高刚性合模机构;射移采用双线性导轨设计,配以高刚性注射支架,确保注射部件运动时的动作稳定性;单缸注射机构,射速230mm/s、330mm/s可选;创新的复合油路设计,开合模动作和熔胶动作可同时进行,在开合模的同时为注射做好准备,在提高生产效率的同时确保产品质量更稳定。

Overall:

The brand new design of high rigid clamping mechanism; shot shift adopted bilinear guide rail design that is equipped with high rigid injection support, which can guarantee the action stability of injection parts when moving; single cylinder injection mechanism with optional firing rate of 230mm/s and 330mm/s; innovative compound oil way design enabled the opening and closing mold and melt to be carried out simultaneously. It prepared for injection while mold opening and closing, and guarantee product quality while improving production efficiency.

注射:

- 采用欧洲先进的单缸注射技术,注射响应快,精度高,运动惯量小,注射终点控制精准。
 - 高精度线性导轨射出结构,确保注射时的稳定性和注射精度。
 - 特别设计专用高长径比螺杆料筒,下料速度快,达到更好的塑化能力和塑化效果,再配合精密止退环、过胶垫圈设计,大幅提高注射精度。
- 选配部份:**
1. 高速注射。
 2. 复合动作。
 3. 气动喷嘴。(原装进口气动驱动喷嘴,动作迅速,密封胶可靠,无流延。)
- 液压部分:**
1. 采用多套伺服电机油泵组合油路,可进行开模储料同步运行。
 2. 熔胶马达采用专用高速马达设计,确保运行寿命。

Injection:

- Adopted European Advanced single cylinder injection technology, quick injection response, high precision, small motion inertia, accurate injection endpoint control.
- High precise linear lead-rail ejection structure guaranteed stability and injection accuracy.
- Especially designed dedicated high length-diameter screw and charging barrel with fast blanking speed; it achieved better plasticizing capacity as well as good effect; along with precise check ring and excessive rubber gasket, its injection precision has been improved greatly.

Optional Part:

1. High-speed injection
 2. Compound Control Action
 3. Pneumatic Nozzle.
- (Imported with original packaging of pneumatic driven nozzle with rapid movement, reliable molding and no flow casting)

Hydraulic Pressure:

1. Adopted multiple sets of servo motor oil pump with compound oil way, which can achieve simultaneous operation of mold opening and charging.
2. The melt motor adopted dedicated high-speed motor design to guarantee service life.

控制系统:

- 专用高速意大利 INOVA 电脑,高精度、高响应。
- 对伺服驱动器实现数字化控制,与驱动器形成整体化系统。
- 智能注射系统,可实现免调试、快速形成产品。
- 接触器、行程开关等主要电器零件均采用施耐德、欧姆龙等进口品牌,性能稳定。

Control System:

- Dedicated Italian INOVA computer with high precision and response.
- Realized automatic control of servo motor and formed integrated system together with driver.
- Intelligent injection system can realize exemption of debugging and fast formation of products.
- The major electric parts such as contactor and travel switch all adopted imported brands including Schneider and Omron, which have stable performance.

合模:

- 采用适合于薄壁精密产品成型的高强度型模板,并通过全面的有限元技术分析,优化结构,降低应力,大幅提升模板刚性。
- 同时增大拉杆的直径设计,并采用 42CrMo 高频淬火热处理工艺,延长设备在高速运行情况下的使用寿命。
- 销轴采用专用氮化销轴,并增大销轴直径尺寸,大幅减少销轴的接触应力,确保其最好的持久耐用性。
- 销轴及滑动活动部位均采用高负载自润滑轴承设计,减少润滑油用量,保证高速运行时销轴及拉杆的良好润滑。

Clamping

- Adopted the high-strength template that is suitable for the formation of thin-wall precise products; by means of comprehensive finite element technique analysis, it optimized structure, reduced stress and enhanced template rigidity.
- The design of enlarging pull rod diameter and adoption of 42CrMo high-frequency quenching heat treatment process lengthened equipment service life in the situation of high-speed operation.
- The hinge pin adopted dedicated nitriding hinge pin with enlarging its diameter; it greatly reduced its contacting stress and guaranteed optimal durability.
- The hinge pin and sliding parts all adopt heavy-load self-lubricating bearing design, which can reduce the use of lubricating oil and guarantee good lubrication for long-time operation.

电脑界面:

- 10英寸触屏式彩色液晶画面,操作方式、设定画面可以通过直接点击屏幕,可轻松地进行操作。
- 程序更新升级和用户配置数据更新、移植均可通过面板 U 盘轻松实现。
- 可直接将用户所有机型配置集成于面板中,实现不同机型的参数自动配置。
- 多国语言支持,语种 > 10 种。

Computer Interface:

- 10-inch touch screen color liquid crystal interface made the operation method and picture setting to be realized by clicking the screen directly, which can be operated easily.
- Procedure upgrading and updating as well as transplant of user configuration data can be achieved by panel USB disk.
- It can integrate all the user model configurations into the panel to realize the automatic parameter configuration of different types.
- Support multiple languages with more than 10.

其他:

- 环保性:采用陶瓷电热圈,节约加热能耗,加热过程更加安全可靠,加热速度比普通电热圈更快。
- 人性化:料筒加热防护服、料斗滑轨、射出防护服、集中润滑控制的多项设计,在保护操作安全的同时,降低劳动强度,提高操作和维护方便性。

Others :

- Environmental Conservation: the ceramics electric heating circle it adopted can save the energy consumption when heating; the heating process is more reliable and safer and the heating speed is faster than common electric heating circle.
- Humanization: The multiple-design of charging barrel heating shield, hopper slide rail, ejection shield, and central lubrication control can reduce labor intensity, and improved the convenience of operation as well as maintenance while protecting operation safety.

产品应用:

主要适用于生产加工快餐盒、酸奶包装盒、冰淇淋盒、PS航空杯、一次性餐具、瓶盖等各种薄壁成型制品。

Product Application

This product is mainly suitable for processing various thin-wall molding products such as lunchbox, yogurt-packing box, ice cream box, PS aviation cup, disposal tableware, bottle cap and other kinds of thin wall plastic products.

技术参数表 TECHNICAL DATA										
甬华塑机(专用机)	YongHua Plastic Machinery		YH178 SP		YH268SP		YH358SP		YH428SP	
注射装置	Injection unit		A	B	B	C	A	B	A	B
螺杆直径	Screw diameter	[mm]	42	45	50	55	50	55	55	60
长径比	L/D ratio	[L/D]	23.8	22.2	25	25	25	25	25	25
注射容积	Cylinder head volume	[cm ³]	291	334	393	475	393	475	475	566
注射重量	Shot weight	[g]	268	307	357	432	357	432	432	515
注射速度	Shot speed	[mm/s]	232	232	240	240	370	370	550	550
注射速率	Rate of injection(PS)	[g/s]	292	335	429	519	661	800	1297	1544
注射压力	Injection pressure	[Mpa]	175	152	185	153	185	153	167	141
注射行程	Injection stroke	[mm]	210		200		200		200	
螺杆转速	Screw speed	[rpm]	367		300		300		300	
喷嘴球径	Sphere diameter of nozzle	[mm]	SR15		SR15		SR15		SR15	
合模装置 Clamping unit										
合模力	Clamping force	[KN]	1780		2680		3580		4280	
最大开模行程	Max.mould opening stroke	[mm]	435		540		630		650	
拉杆间距	Distance between tie bars	[mm]	470×470		565×565		680×660		730×680	
最小模具尺寸	Min.Mould size	[mm]	325×325		400×400		480×460		510×480	
最小模厚	Min.mould height	[mm]	180		230		270		280	
最大模厚	Max.mould height	[mm]	520		550		700		700	
模具定位孔直径	Dia of mould location hole	[mm]	Φ100H7		Φ100H7		Φ160H7		Φ160H7	
顶出行程	Ejector stroke	[mm]	140		125		160		160	
顶出力	Ejector force	[KN]	53		91		80		88	
顶出杆数	Ejector number	[PIECE]	5		9		9		9	
其他 General										
油泵额定压力	Rated pressure of oil pump	[Mpa]	16		16		16		17.5	
油泵马达功率	Pump motor power	[Kw]	40.9		31.4+24.1		40+40		40+28	
料筒电热功率	Heating capacity of screw cylinder	[Kw]	13		24.1		27		33	
加热段	Heating section		4+1		5+1		5+1		5+1	
油箱容积	Oil tank capacity	[L]	400		320		680		730	
机器尺寸 (长×宽×高)	Dimensions of machine (l×w×h)	[m]	5.26x1.3x2.18		7.02×1.80×2.21		7.9×2.0×2.17		7.81×2.16×2.35	
机器重量	Machine weight	[t]	6.2		10.0		15.5		23.0	

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