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# KELI MACHINERY

— 科力机械 —

## Injection Blow Molding Machine

注吹中空成型机



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## Company Introduction 公司简介

浙江科力塑料机械有限公司成立于一九九九年，是一家集研发、生产和销售一步法塑料注吹中空成型机及其配套设备与模具的省级科技型企业 and 国家高新技术企业，主要为医药、食品、化妆品等包装行业服务。

SZCX系列一步法注吹中空成型机采用世界知名品牌的液压、气动、电气元件配套，实现机、电、气、液一体化，具有精密、高效、节能、环保、易操作、产量大、产品质量稳定等优点。其中公司自主研发的SZCX系列一步法注吹中空成型机荣获2010年国家火炬计划项目，该系列机集注塑、吹塑成型工艺于一台机器，具有自主知识产权，并获得多项专利，技术水平居中国领先地位。

公司产品不断远销海外，美国、加拿大、英国、德国、俄罗斯、巴西、土耳其、马来西亚、墨西哥、菲律宾、印度尼西亚、印度、越南、埃及等许多国家都有我们的客户。



Zhejiang keli plastic machinery co.,ltd was established in 1999.It is a provincial science and technology enterprise as well as national high and new-technology industrial enterprise that researches,manufactures and sells one step injection blow molding machine(IBM) as well as related components and molds.The machine is widely used in medical,food and cosmetic packaging field.

The SZCX series injection blow molding machine consist of worldwide known hydraulic,pneumatic and electric components realizing their combination,featuring in precision,high-efficiency,energy-saving, environment-friendly,easy operation,high output and good quality advantages.The self-research SZCX series injection blow molding machine integrates injection molding and blow molding in one machine,won torch project 2010.It has self-intellectual properties,been authorized many patents for invention.The technical level is on the top in China in this field.

Our machines have been exported to many countries,like America, Canada, UK, Germany, Russia, Brazil, Turkey, Malaysia, Mexico, Philippines, Indonesia, India, Vietnam and Egypt,etc.

采用科力设备生产包装容器的名牌客户  
Packaging container from KELI machine—famous brand list:



▶ 以上排名不分先后  
▶ Above in no particular order

▶ 品牌数量众多，恕不一一列举  
▶ Just part of the famous list





**SZCX 130/30**

**一步法三工位注吹中空成型机**  
One step 3 station injection blow molding machine

附表：制品尺寸对应的每模腔数(仅供参考)  
Cavity number of the mould corresponding to product dimension.(For reference)

直径 diameter (D) (mm)	28	34	38	52	80
高 height (H) (mm)	50	60	70	90	100
中心距 central distance (mm)	38	45	50	65	100
腔数 cavity	6	5	4	3	2



## SZCX130/30主要技术参数 Main Technical Parameters

注射机构	Injection system	Unit	Parameter
螺杆直径	Dia.of Screw	mm	40
螺杆长径比	Screw L/D		22:1
最大理论注射容积	Max Theoretical Shot Volume	cm <sup>3</sup>	200
最大注射量 (HDPE)	Injection Weight	g	130
塑化能力	Plasticing Capacity Approx	g/s	32
螺杆最大行程	Max.Screw Stroke	mm	167
螺杆转速	Max Screw Speed	rpm	10~235
机筒加热功率	Total Power for Charging Barrel	kw	8.8
电热控制区	No.of Heating Zone	Qty	5
<b>合模&amp;吹塑系统</b>	<b>Clamping System</b>		
注模锁模力	Injection Clamping Force	kn	300
吹模锁模力	Blow Clamping Force	kn	46
开模行程	Opening Stroke of Mould Platen	mm	120
最大回转半径	Max Swing Radius	mm	378
塔台提升高度	Liftion Height of Rotary Table	mm	60
最大模板尺寸	Max Platen Size of Mould (LxW)	mm	320x270
最小模具厚度	Min Mould Thickness	mm	180
模具加热功率	Mould Heating Power	kw	2.4
<b>脱模系统</b>	<b>Stripping System</b>		
脱模行程	Stripping Stroke	mm	170
空运转时间	Dry Cycle Time	s	2.8
<b>驱动系统</b>	<b>Driving System</b>		
驱动电机	Motor Power	kw	23
液压系统压力	Hydraulic Working Pressure	Mpa	14
<b>制品尺寸范围</b>	<b>Product Dimension Range</b>		
制品容积	Range of Formability Product	ml	2 ~ 500
制品高度	Height of Formability Product	mm	≤165
制品直径	Dia.of Formability Product	mm	≤100
<b>其它</b>	<b>Other</b>		
压缩空气压力	Compressed Air Pressure	Mpa	0.7 ~ 0.9
压缩空气排量	Compressed Air Discharge Rate	m <sup>3</sup> /min	0.3
冷却水压力	Cooling Water Pressure	Mpa	0.3 ~ 0.4
装机总功率	Total Power	kw	34.2
工作功率	Operating Power		30 ~ 44%
外形尺寸	Overall Dimension (LxWxH)	mm	2900x1500x2200
重量 (约)	Machine Weight Approx.	T	3.5

— 以上参数仅供参考，不断研发改进，如有变动，恕不另行通知。  
— All specifications and designs are subject to change without notice.

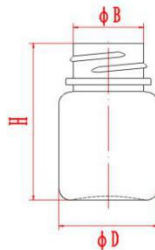


# SZCX 160/45

**一步法三工位注吹中空成型机**  
One step 3 station injection blow molding machine

附表：制品尺寸对应的每模腔数(仅供参考)  
Cavity number of the mould corresponding to product dimension.(For reference)

直径 diameter (D) (mm)	28	32	36	42	48	55	65	75
高 height (H) (mm)	55	75	80	85	90	100	110	125
中心距 central distance (mm)	38	42	48	54	62	75	90	100
腔数 cavity	10	9	8	7	6	5	4	3



## SZCX160/45主要技术参数 Main Technical Parameters

注射机构	Injection system	Unit	Parameter
螺杆直径	Dia.of Screw	mm	45
螺杆长径比	Screw L/D		22:1
最大理论注射容积	Max Theoretical Shot Volume	cm <sup>3</sup>	238
最大注射量 (HDPE)	Injection Weight	g	160
塑化能力	Plasticating Capacity Approx	g/s	40
螺杆最大行程	Max. Screw Stroke	mm	150
螺杆转速	Max Screw Speed	rpm	10~235
机筒加热功率	Total Power for Charging Barrel	kw	11.8
电热控制区	No.of Heating Zone	Qty	5
合模&吹塑系统	Clamping System		
注模锁模力	Injection Clamping Force	kn	450
吹模锁模力	Blow Clamping Force	kn	78
开模行程	Opening Stroke of Mould Platen	mm	120
最大回转半径	Max Swing Radius	mm	456
塔台提升高度	Liftion Height of Rotary Table	mm	60
最大模版尺寸	Max Platen Size of Mould (LxW)	mm	480x370
最小模具厚度	Min Mould Thickness	mm	240
模具加热功率	Mould Heating Power	kw	3.6
脱模系统	Stripping System		
脱模行程	Stripping Stroke	mm	215
空运转时间	Dry Cycle Time	s	3
驱动系统	Driving System		
驱动电机	Motor Power	kw	29.1
液压系统压力	Hydraulic Working Pressure	Mpa	14
制品尺寸范围	Product Dimension Range		
制品容积	Range of Formability Product	ml	2 ~ 750
制品高度	Height of Formability Product	mm	≤210
制品直径	Dia.of Formability Product	mm	≤100
其它	Other		
压缩空气压力	Compressed Air Pressure	Mpa	0.7 ~ 0.9
压缩空气排量	Compressed Air Discharge Rate	m <sup>3</sup> /min	0.4
冷却水压力	Cooling Water Pressure	Mpa	0.3 ~ 0.4
装机总功率	Total Power	kw	44.5
工作功率	Operating Power		32 ~ 46%
外形尺寸	Overall Dimension (LxWxH)	mm	3400x1540x2160
重量 (约)	Machine Weight Approx.	T	5

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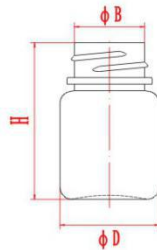


# SZCX 250/60

**一步法三工位注吹中空成型机**  
One step 3 station injection blow molding machine

附表：制品尺寸对应的每模腔数(仅供参考)  
Cavity number of the mould corresponding to product dimension. (For reference)

直径 diameter (D) (mm)	28	32	35	37	40	43	48	54	60	70	80
高 height (H) (mm)	50	55	60	70	85	90	90	90	95	100	105
中心距 central distance (mm)	38	42	45	49	52	57	63	70	80	90	105
腔数 cavity	16	15	14	13	12	11	10	9	8	7	6



## SZCX250/60主要技术参数 Main Technical Parameters

注射机构	Injection system	Unit	Parameter
螺杆直径	Dia.of Screw	mm	52
螺杆长径比	Screw L/D		23:1
最大理论注射容积	Max Theoretical Shot Volume	cm <sup>3</sup>	380
最大注射量 (HDPE)	Injection Weight	g	250
塑化能力	Plasticating Capacity Approx	g/s	58
螺杆最大行程	Max. Screw Stroke	mm	180
螺杆转速	Max Screw Speed	rpm	10~235
机筒加热功率	Total Power for Charging Barrel	kw	15.2
电热控制区	No.of Heating Zone	Qty	6
合模&吹塑系统	Clamping System		
注模锁模力	Injection Clamping Force	kn	673
吹模锁模力	Blow Clamping Force	kn	96
开模行程	Opening Stroke of Mould Platen	mm	140
最大回转半径	Max Swing Radius	mm	570
塔台提升高度	Liftion Height of Rotary Table	mm	70
最大模板尺寸	Max Platen Size of Mould (LxW)	mm	700x400
最小模具厚度	Min Mould Thickness	mm	280
模具加热功率	Mould Heating Power	kw	4.8
脱模系统	Stripping System		
脱模行程	Stripping Stroke	mm	255
空运转时间	Dry Cycle Time	s	3.2
驱动系统	Driving System		
驱动电机	Motor Power	kw	29.1+12
液压系统压力	Hydraulic Working Pressure	Mpa	14
制品尺寸范围	Product Dimension Range		
制品容积	Range of Formability Product	ml	2 ~ 1000
制品高度	Height of Formability Product	mm	≤250
制品直径	Dia.of Formability Product	mm	≤110
其它	Other		
压缩空气压力	Compressed Air Pressure	Mpa	0.7 ~ 0.9
压缩空气排量	Compressed Air Discharge Rate	m <sup>3</sup> /min	0.8
冷却水压力	Cooling Water Pressure	Mpa	0.3 ~ 0.4
装机总功率	Total Power	kw	61.1
工作功率	Operating Power		33 ~ 46%
外形尺寸	Overall Dimension (LxWxH)	mm	4100x1650x2400
重量 (约)	Machine Weight Approx.	T	9.5

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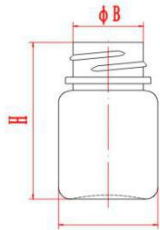


# SZCX 160/50X

一步法三工位注吹中空成型机 (欧式)  
One step 3 station injection blow molding machine (EUROPEAN-STYLE)

附表：制品尺寸对应的每模腔数(仅供参考)  
Cavity number of the mould corresponding to product dimension.(For reference)

直径 diameter (D) (mm)	28	32	36	42	48	55	65	75
高 height (H) (mm)	55	75	80	85	90	100	110	125
中心距 central distance (mm)	38	42	48	54	62	75	90	100
腔数 cavity	10	9	8	7	6	5	4	3



## SZCX160/50X主要技术参数 Main Technical Parameters

注射机构	Injection system	Unit	Parameter
螺杆直径	Dia.of Screw	mm	45
螺杆长径比	Screw L/D		22:1
最大理论注射容积	Max Theoretical Shot Volume	cm <sup>3</sup>	238
最大注射量 (HDPE)	Injection Weight	g	160
塑化能力	Plasticing Capacity Approx	g/s	40
螺杆最大行程	Max.Screw Stroke	mm	150
螺杆转速	Max Screw Speed	rpm	10~235
机筒加热功率	Total Power for Charging Barrel	kw	11.8
电热控制区	No.of Heating Zone	Qty	5
合模&吹塑系统	Clamping System		
注模锁模力	Injection Clamping Force	kn	500
吹模锁模力	Blow Clamping Force	kn	70
开模行程	Opening Stroke of Mould Platen	mm	120
最大回转半径	Max Swing Radius	mm	480
塔台提升高度	Liftion Height of Rotary Table	mm	60
最大模板尺寸	Max Platen Size of Mould (LxW)	mm	480x370
最小模具厚度	Min Mould Thickness	mm	240
模具加热功率	Mould Heating Power	kw	3.6
脱模系统	Stripping System		
脱模行程	Stripping Stroke	mm	215
空运转时间	Dry Cycle Time	s	2.9
驱动系统	Driving System		
驱动电机	Motor Power	kw	29.1
液压系统压力	Hydraulic Working Pressure	Mpa	14
制品尺寸范围	Product Dimension Range		
制品容积	Range of Formability Product	ml	2 ~ 750
制品高度	Height of Formability Product	mm	≤210
制品直径	Dia.of Formability Product	mm	≤100
其它	Other		
压缩空气压力	Compressed Air Pressure	Mpa	0.7 ~ 0.9
压缩空气排量	Compressed Air Discharge Rate	m <sup>3</sup> /min	0.6
冷却水压力	Cooling Water Pressure	Mpa	0.3 ~ 0.4
装机总功率	Total Power	kw	44.5
工作功率	Operating Power		34 ~ 48%
外形尺寸	Overall Dimension (LxWxH)	mm	3850x1550x1950
重量 (约)	Machine Weight Approx.	T	6

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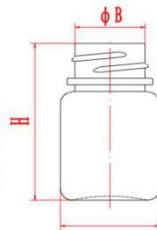


# SZCX 300/70X

一步法三工位注吹中空成型机 (欧式)  
One step 3 station injection blow molding machine (EUROPEAN-STYLE)

附表：制品尺寸对应的每模腔数(仅供参考)  
Cavity number of the mould corresponding to product dimension. (For reference)

直径 diameter (D) (mm)	28	30	32	35	37	40	43	48	55	60	65	75	85
高 height (H) (mm)	50	52	55	60	70	85	90	90	90	95	100	105	110
中心距 central distance (mm)	38	40	42	45	50	52	57	63	70	75	85	95	105
腔数 cavity	18	17	16	15	14	13	12	11	10	9	8	7	6



## SZCX300/70X主要技术参数 Main Technical Parameters

注射机构	Injection system	Unit	Parameter
螺杆直径	Dia. of Screw	mm	55
螺杆长径比	Screw L/D		24:1
最大理论注射容积	Max Theoretical Shot Volume	cm <sup>3</sup>	400
最大注射量 (HDPE)	Injection Weight	g	300
塑化能力	Plasticating Capacity Approx	g/s	60
螺杆最大行程	Max. Screw Stroke	mm	170
螺杆转速	Max Screw Speed	rpm	10~235
机筒加热功率	Total Power for Charging Barrel	kw	18.7
电热控制区	No. of Heating Zone	Qty	6
<b>合模&amp;吹塑系统</b>	<b>Clamping System</b>		
注模锁模力	Injection Clamping Force	kn	705
吹模锁模力	Blow Clamping Force	kn	110
开模行程	Opening Stroke of Mould Platen	mm	150
最大回转半径	Max Swing Radius	mm	612
塔台提升高度	Liftion Height of Rotary Table	mm	75
最大模板尺寸	Max Platen Size of Mould (LxW)	mm	780x460
最小模具厚度	Min Mould Thickness	mm	254
模具加热功率	Mould Heating Power	kw	5.6
<b>脱模系统</b>	<b>Stripping System</b>		
脱模行程	Stripping Stroke	mm	255
空运转时间	Dry Cycle Time	s	2.9
<b>驱动系统</b>	<b>Driving System</b>		
驱动电机	Motor Power	kw	36.7+12
液压系统压力	Hydraulic Working Pressure	Mpa	14
<b>制品尺寸范围</b>	<b>Product Dimension Range</b>		
制品容积	Range of Formability Product	ml	2 ~ 1000
制品高度	Height of Formability Product	mm	≤250
制品直径	Dia. of Formability Product	mm	≤100
<b>其它</b>	<b>Other</b>		
压缩空气压力	Compressed Air Pressure	Mpa	0.7 ~ 0.9
压缩空气排量	Compressed Air Discharge Rate	m <sup>3</sup> /min	0.8
冷却水压力	Cooling Water Pressure	Mpa	0.3 ~ 0.4
装机总功率	Total Power	kw	72
工作功率	Operating Power		30 ~ 41%
外形尺寸	Overall Dimension (LxWxH)	mm	4830x1750x2200
重量 (约)	Machine Weight Approx.	T	10.5

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# SZCX 700/135X

一步法三工位注吹中空成型机 (欧式)  
One step 3 station injection blow molding machine (EUROPEAN-STYLE)

附表：制品尺寸对应的每模腔数(仅供参考)

Cavity number of the mould corresponding to product dimension.(For reference)

直径 diameter (D) (mm)	20	23	25	27	31	35	39	43	48	52	62	72	90	105
中心距 central distance (mm)	32	34	36	38	42	46	50	55	60	68	78	90	110	130
腔数 cavity	34	32	30	28	26	24	22	20	18	16	14	12	10	8



## SZCX700/135X主要技术参数 Main Technical Parameters

注射机构	Injection system	Unit	Parameter
螺杆直径	Dia.of Screw	mm	70
螺杆长径比	Screw L/D		24:1
最大理论注射容积	Max Theoretical Shot Volume	cm <sup>3</sup>	825
最大注射量 (HDPE)	Injection Weight	g	700
塑化能力	Plasticing Capacity Approx	g/s	75
螺杆最大行程	Max.Screw Stroke	mm	215
螺杆转速	Max Screw Speed	rpm	10~235
机筒加热功率	Total Power for Charging Barrel	kw	31.6
电热控制区	No.of Heating Zone	Qty	6
<b>合模&amp;吹塑系统</b>	<b>Clamping System</b>		
注模模力	Injection Clamping Force	kn	1240
吹模锁模力	Blow Clamping Force	kn	245
开模行程	Opening Stroke of Mould Platen	mm	160
最大回转半径	Max Swing Radius	mm	812
塔台提升高度	Liftion Height of Rotary Table	mm	85
最大模板尺寸	Max Platen Size of Mould (LxW)	mm	1140x520
最小模具厚度	Min Mould Thickness	mm	254
模具加热功率	Mould Heating Power	kw	8.4
<b>脱模系统</b>	<b>Stripping System</b>		
脱模行程	Stripping Stroke	mm	290
空运转时间	Dry Cycle Time	s	3.2
<b>驱动系统</b>	<b>Driving System</b>		
驱动电机	Motor Power	kw	67+12
液压系统压力	Hydraulic Working Pressure	Mpa	14
<b>制品尺寸范围</b>	<b>Product Dimension Range</b>		
制品容积	Range of Formability Product	ml	5 ~ 1500
制品高度	Height of Formability Product	mm	≤285
制品直径	Dia.of Formability Product	mm	≤100
<b>其它</b>	<b>Other</b>		
压缩空气压力	Compressed Air Pressure	Mpa	0.7 ~ 0.9
压缩空气排量	Compressed Air Discharge Rate	m <sup>3</sup> /min	1.2
冷却水压力	Cooling Water Pressure	Mpa	0.3 ~ 0.4
装机总功率	Total Power	kw	119
工作功率	Operating Power		24 ~ 32%
外形尺寸	Overall Dimension (LxWxH)	mm	5500x2270x2400
重量 (约)	Machine Weight Approx.	T	15

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—All specifications and designs are subject to change without notice.



### ▶ 用途 Usage

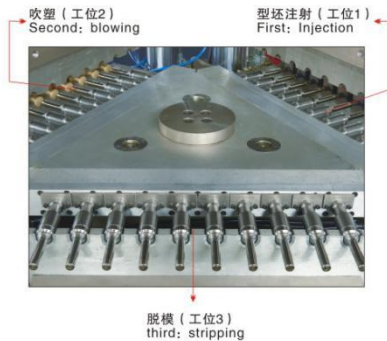
本机为一步法三工位注射中空成型机，用于生产PE、PP、PS、BAREX、PC、PVC为原料的药瓶及食品、化妆品瓶等（如生产PC、PVC为原料的瓶，需特殊订货）。

This machine is one step 3station injection blow molding machine, it is suitable to make pharmaceutical, food, cosmetic bottles of many kind of material in PE、PP、PS、BAREX、PC、PVC.

### ▶ 工作原理 Operating Principle

一步法注吹工艺的核心部件是一个三角转盘，按120度旋转，芯棒安装在转盘的端面。

The core part of the one step injection blowing technics is a triangle-turnplate. The mandrils are assembled on the side face of the triangle-turnplate which rotation is 120 degree.



#### • 工位1 THE FIRST SERVICE POSITION

塑性熔体在低注射压力下射入型坯，并且瓶子颈部被精确成型。经过适当的控制后，模具打开，芯棒连同型坯一起转到工位2。

The bottle neck will be molded accurately after injecting the material into the cavity. After proper control, the mold open and the mandrils turn to the second service position along with the parison.

#### • 工位2 THE SECOND SERVICE POSITION

吹塑在该型腔，经冷却成型工位完成。(模具型腔决定瓶子的形状和外观)。型坯被从芯棒出来的空气吹胀，紧贴模具，然后，模具打开，芯棒连同型坯一起转到工位3。

Blowing action was done at this cavity. Molding would be completed after cooling. (cavity of mold decide the shape and outward appearance of the bottle). The air came out from the mandrils expand the parison, making the parison cling to the mold. Then the mold open and the mandrils turn to the third service position along with bottles.

#### • 工位3 THE THIRD SERVICE POSITION

在这一工位完成脱模，然后就通过流水线进行包装或灌装了。注射、吹塑、脱模三动作同时进行，高效节能。

The bottle automatically stripped from the mold at this position and then to packed through pipelining. The three actions of Injection, Blowing and stripping work at the same time, which makes the machine high output and energy saving.

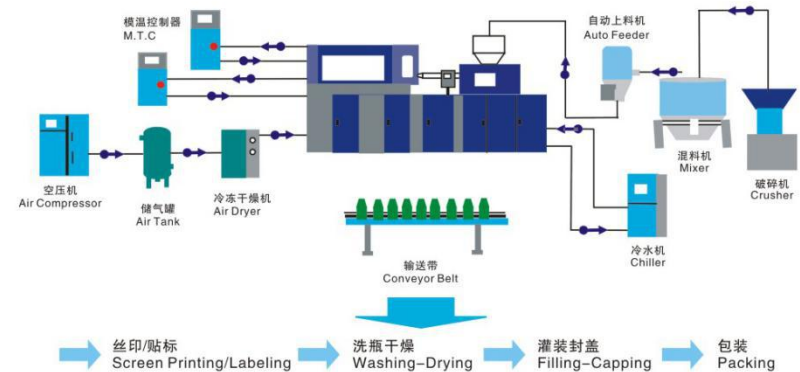
### ▶ 机器特点

- \* 多腔生产
- \* 双比例控制液压系统
- \* 三工位按120度布置，可同时注射、吹塑和脱模，生产效率
- \* 先进的PID精密温控系统
- \* 采用德国、日本知名品牌液压气动元件
- \* 采用知名品牌PLC控制系统，整机操作简单、方便
- \* 原材料利用率高、成品率高、投资回报率高
- \* 所产瓶颈、瓶口和螺纹精度高、密封性好

### ▶ Characteristic :

- \* Multicavity production
- \* Double proportional hydraulic control system
- \* Three stations arranged at 120 degree, reduction of the cycle time, increase in production efficiency
- \* Advanced and accurate PID temperature control system
- \* Adopted hydraulic and pneumatic components of well-known brands from Germany and Japan.
- \* PLC control system of well-known brands and the whole machine operated easy and convenient
- \* High utilization of raw material, high yield, high rate of return on investment
- \* High precision in bottle neck and screw, best seaming

### ▶ 生产线组成 Production Line Components



### ▶ 按客户订单要求制造成型设备

The machine can manufactured according to the customers requirement

科力并非单纯地批量制造设备。从千差到万别的产品形状、用途到设备产量与成本关系，予以全面的分析之后，制造性能与其相符合的设备。

Keli is not produce machinery in batches, it will analyse the bottle shape, purpose, output and cost in order to make more suitable machine.

### ▶ 完善的客户服务 Flawless customer service

为开发最新的技术和产品，以适应市场日益增加和日益多样化的需要。在科力，我们朝气蓬勃的团队正不分昼夜的工作着，我们不仅帮助客户在他们的工厂中安装机器和培训操作人员，而且提供完善的售前、售中、售后服务。

Keli not to help customers to assemble the machine in their factory and train the worker but also offer before-sale, middle-sale and after-sale service, in order to develop new technology and products to satisfy the diversified need of market.

► 注吹与挤吹的比较

The comparison of injection blowing and extrusion blowing

序号 Number	注吹 Injection Blowing	挤吹 Extrusion Blowing
1	瓶子重量变化约1% Bottle weight will change about 1%	瓶子重量变化约3% Bottle weight will change about 3%
2	壁厚均匀 Uniformity wall thick	壁厚变化10-20% The change of wall thick is about 10-20%
3	无载坯口 None kerf	有载坯口, 并削弱瓶底强度 Not only has the kerf but also weaken the intension of the bottle bottom
4	瓶底上凸性很好 Good convexity at the bottom of the bottle	因有载坯口瓶底上凸性差 Bad convexity at the bottom of the bottle
5	生产过程不产生废料 None flash	20-40%的边角料 20-40% flashes
6	不能成型壁厚很薄的产品 can not produce very thin thickness product	利用控制器可调节壁厚 can use equipment to adjust the thickness
7	生产时对环境的变化不敏感 not sensitive to the environment change	需要更多的调整以维持正常 need more adjustments during the production
8	腔数多、产量高、瓶口平 Multicavity, high output smooth bottleneck	腔数较少、产量低、瓶口不平整 Less cavities, low output uneven bottle neck
9	模具寿命较长, 适合长期生产 High mould lifetime, suitable for long time production but high price	模具寿命短, 适合短期生产 Short mould lifetime, suitable for short time production and low price
10	系统紧凑, 占地少 Compact machine system, less occupation of land	辅机多, 占地多 Need more assistant machines, more occupation of land
11	较难成型椭圆形产品 Difficult of ellipse plastic container	较易成型 Easy

► 辅机设备

The auxiliary equipments



► 应用领域  
Application domain

