

**KELI MACHINERY**  
— 科力机械 —

# INJECTION STRETCH BLOW MOLDING MACHINE

注拉吹中空成型机



 **浙江科力塑料机械有限公司**  
ZHEJIANG KELI PLASTIC MACHINERY CO., LTD.

**KELI MACHINERY**  
— 科力机械 —

## HIGHEST PERFORMANCE

高产能低能耗

Energy Consumption Reduced By **40%**  
Production Speed Increase By **25%**

耗电量减少 **40%**  
生产速度提升达 **25%**







## ENTERPRISE PROFILE 企业概况



**10+**

专利技术  
Patented Technology

**20+**

专注一步法注吹成型机20余年  
Injection Blow Molding Machine

**50+**

远销50多个国家  
Exported to more than 50 countries

浙江科力塑料机械有限公司成立于1999年，是一家集研发、生产和销售一步法注拉吹中空成型机及其配套设备与模具的省级科技型企业和国家高新技术企业，主要为医药、食品、化妆品等包装行业服务。

ISBM系列一步法注拉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，产品具有精密、高效、节能、环保、易操作、产量大、质量稳定等优点。

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

The ISBM series Injection stretch 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.

## COMPLETE TEST SYSTEM 完善的检测系统

高效  
EFFICIENT

专业  
PROFESSIONAL



我们高品质模具的制造是由工厂以高效和无缝管理的工作流程制造出来的,我们所有的流程都围绕到我们高质量的检测管理。

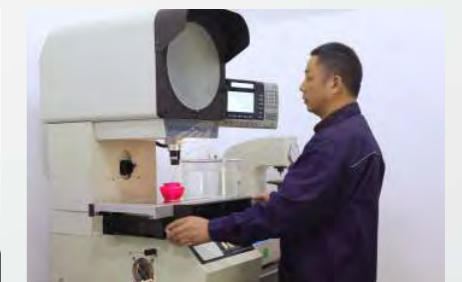
Our high-quality moulds are manufactured by the factory in an efficient and seamlessly managed workflow, which means that all of our processes are built around our high quality inspection management

三坐标-ZEISS  
Coordinate Measuring Machine-ZEISS

投影仪-TESA  
Projector-TESA

测高仪-TESA  
Altimeter-TESA

量具-TESA  
Measuring Tools-TESA





# ONE-STOP PRODUCTION

一站式生产



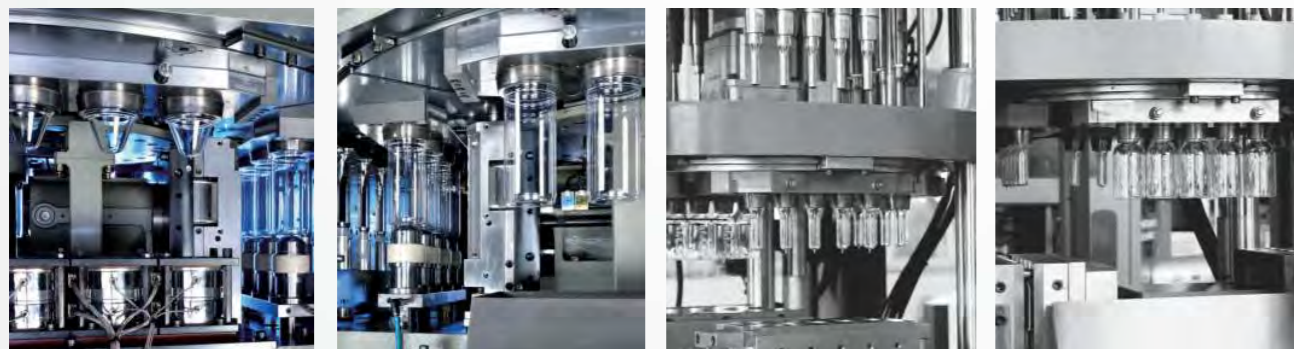
## 满足您对瓶型的渴望

专为少量多样、特殊造型设计开发, 不论是PET、PETG、PP、PC、PS、PPSU、TRITAN为原料的医药瓶、化妆瓶、香水瓶、清洁瓶、婴儿奶瓶特殊造型瓶等, 一机就能完成生产。免去购买瓶胚、另外添购射出机, 减少设备成本也大幅省下厂房空间。免去二次加热制程, 新一代的伺服系统设计, 更可省下高达40%的电力。

## Satisfy your desire for bottle shape

It is specially designed and developed for a small number of diverse and special shapes. Whether it is the material of PE/PETG/PP/PC/PS/PPSU/TRITAN medicine bottle, cosmetic bottle, perfume bottle, clean bottle, baby bottle, special shape bottle, etc., it can be produced in one machine.

Eliminates the need to purchase preforms and purchase additional injection machines, which reduces equipment costs and significantly saves plant space. Eliminate the secondary heating process, a new generation of servo system design It can save up to 40%.



## 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)

ISBM 15	口径/Neck Dia(mm)	15	17	25	32	38	48	62	83	
	直径/Body Dia(mm)	26	28	45	56	69	85	90	118	
	高度/Height(mm)	200				300				
	腔数/Cavity	8	7	6	5	4	3	2	1	

ISBM 50	口径/Neck Dia(mm)	18	21.5	24	30	35	42	60	72	80	107	
	直径/Body Dia(mm)	36	42	48	55	66	80	100	130	130	150	
	高度/Height(mm)	335										
	腔数/Cavity	10	9	8	7	6	5	4	3	2	1	

ISBM 70	口径/Neck Dia(mm)	16	25	32	34	40	57	70	93	101	118	154	
	直径/Body Dia(mm)	37	45	53	54	66	79	99	120	130	153	204	
	高度/Height(mm)	350											
	腔数/Cavity	12	10	9	8	7	6	5	4	3	2	1	

# MACHINE PARAMETERS

机器参数

注射机构/Injection	Unit	ISBM 15	ISBM 50	ISBM 70
螺杆直径/Dia of screw	mm	45	55	55
螺杆长径比/Screw L/D		26:1	26:1	26:1
最大理论注射容积/Max Theoretical Shot Volumn	cm <sup>3</sup>	240	400	400
最大注射量/Max Injection weight	g	160	300	300
塑化能力/Plasticizing Capacity	g/s	40	60	60
螺杆最大行程/Max Screw Stroke	mm	150	170	170
螺杆转速/Max Screw Speed	rpm	10-210	10-210	10-210
机筒加热功率/Total Power of Charging Barrel	kw	16	25.6	25.6
电热控制区/No. of Heating Zone	Qty	5	6	6
注模&吹模系统/Clamping System				
注模锁模力/Injection Clamping Force	kn	152	540	687
注模开合模行程/Injection Mold open&close Stroke	mm	460	630	435
吹模锁模力/Blow Clamping Force	kn	110	242	242
吹模开合模行程/Blow Mold open&close Stroke	mm	150	130	290
注模模具高度/Max Injection Mold Height	mm	420	500	470
吹模模具厚度/Max Blow Mold Thickness	mm	160	210	260
模具流道加热功率/Heating power of mold manifold	kw	3-5.5	4.5-7.5	4.5-7.5
模具调温筒加热功率/Heating power of Mold Temperature Control for Barrel	kw	0.8-1.6	1.2-2.4	1.2-2.4
模具调温芯加热功率/Heating power of Mold Temperature Control for cores	kw	0.4-0.8	0.6-1.2	0.6-1.2
驱动系统/Driving System				
液压系统驱动电机/Hydraulic System Electric Engine	kw	22+18.5	291x2	30+25+11
液压系统压力/Hydraulic System Pressure	Mpa	14	14	14
塑化驱动电机/Plasticizing Driving Engine	kw	18	31.5	31.5
转盘驱动电机/Rotary table Driving Engine	kw	2.1	4.7	6
制品尺寸范围/Product Dimension Range				
制品容积/Volumn	ml	10-2500	10-5000	10-10000
制品高度/Height	mm	≤300	≤335	≤350
制品口径/Neck opening	mm	≤83	≤107	≤154
制品直径/Diameter	mm	≤118	≤150	≤204
其他/Other				
吹气气路压力和最大流量/Pressure & max flow for blow air circuit		3.5Mpa 1000L/min	3.5Mpa 1340L/Min	3.5Mpa 1340L/Min
动作气路压力和最大流量/Pressure & max flow for action air circuit		0.8Mpa 300L/min	0.8 Mpa 460L/Min	0.8 Mpa 460L/Min
机器冷却水压力、流量、温度/Pressure flow & temperature for machine cooling water		0.3Mpa 70L/min 32°C	0.3 Mpa 83.5L/Min 32°C	0.3 Mpa 110L/Min 32°C
模具冷却水压力、流量、温度/Pressure flow & temperature for mold cooling water		0.45Mpa 160L/min 15°C	0.45 Mpa 200L/Min 15°C	0.45 Mpa 220L/Min 15°C
装机总功率/Total Power	kw	68.5	131.1	138.9
工作功率/Operating Power		30%	15-30%	15-30%
机器尺寸/Machine Size	mm	3945x1340x3098	5064x1790x3645	5640x1870x3450



# ONE STEP MOLDING

## 一步法成型

1.四个工位采用水平回旋装置，伺服驱动系统。实现速度快，定位速度快，定位精确以优化紧凑的结构大幅度减少设备运转周期。  
Four-position horizontal gyroscope, servo drive systems. Speed of implementation, speed of positioning, precise positioning to cut down cycle time.

2.采用高质量液压，气动，电气原件，实现微电脑控制而全自动，操作简便，节省设备运行能源。  
Adopt high quality hydraulic, pneumatic, electrical components, and realize of microcomputer control and fully automatic, easy operation, run the energy saving device.

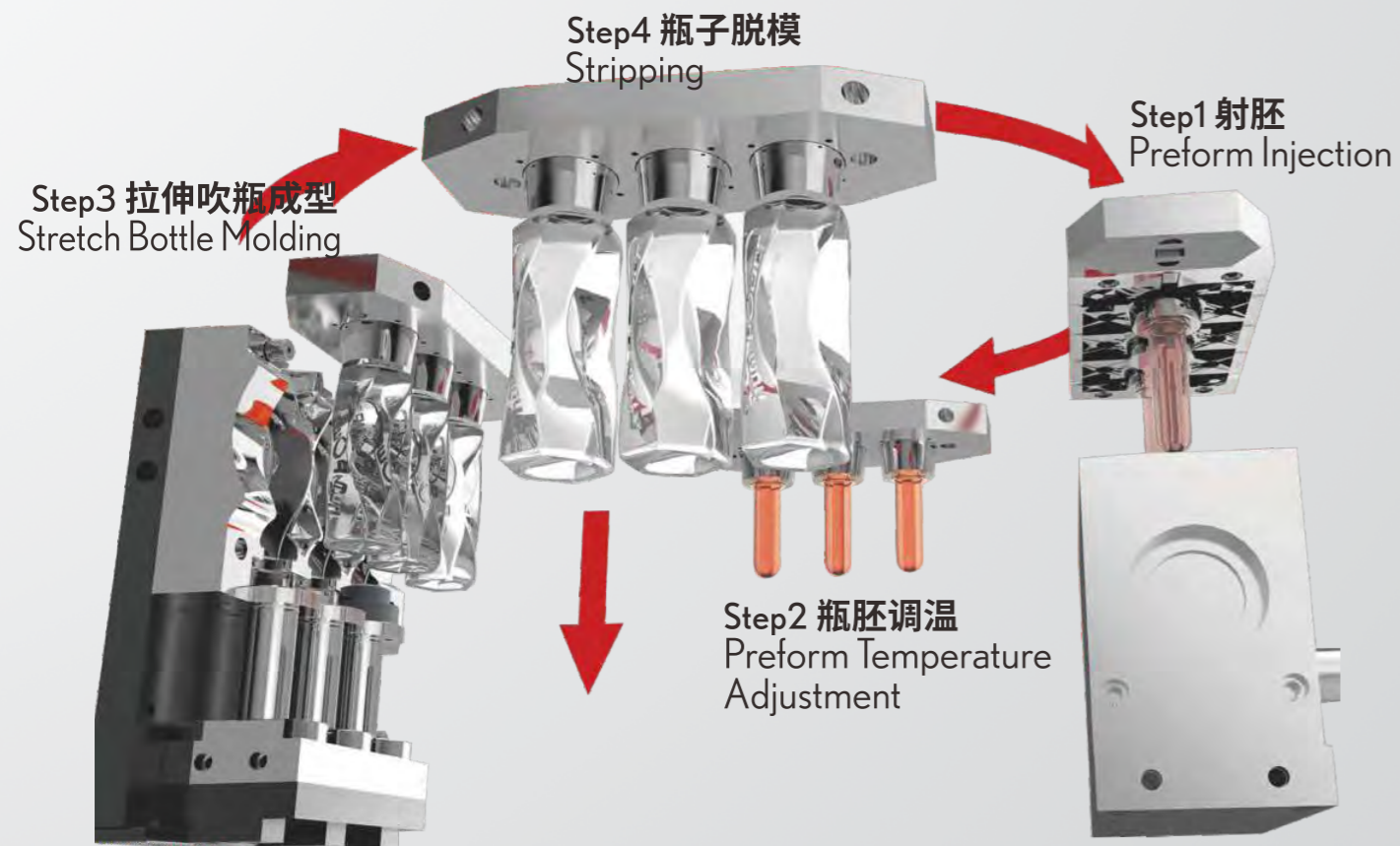
3.采用专业的热流道及控温装置，而精确控制，确保产品的稳定。  
Adopt professional hot runner and temperature control device and precise control to ensure product stability

4.一次成型瓶口和螺纹尺寸精确，与盖百分百密合，无飞边而节省原料。  
Once forming of bottle neck and thread, size accurate, 100% sealing with cap, no flash, raw material saving.

5.一步法注拉吹成型机比传统的设备要节省更多的资源。  
One step stretch-blow molding machine saves more resources than traditional devices.

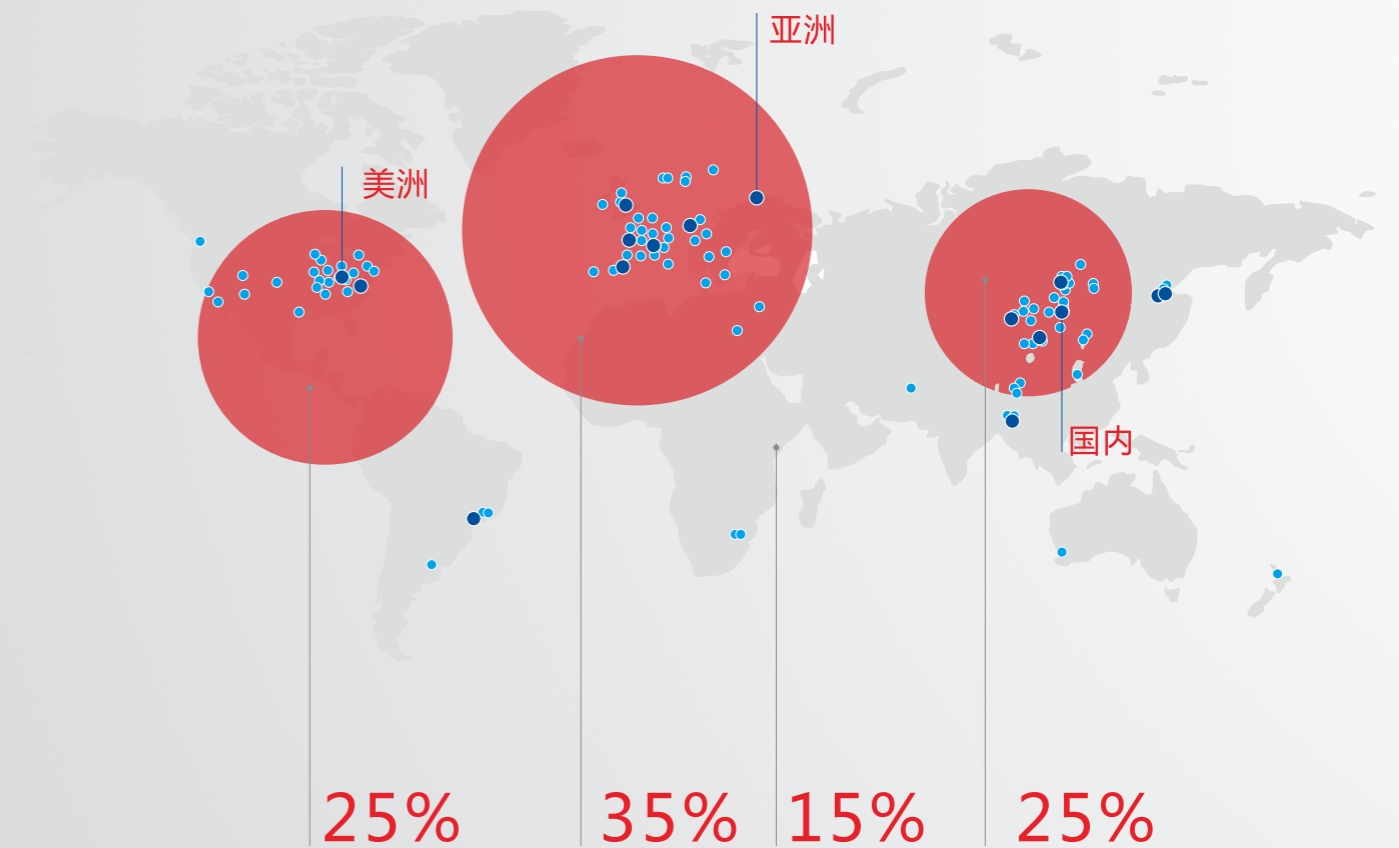
6.四个工位设计均以作标准配置，可为客户制造模具节省大量的时间。  
Standard configuration at four stations,it helps customers save plenty of time at mold manufacturing.

7.保证产品清洁卫生，特别适用于医药包装及食品包装。  
Guarantee bottles hygiene, particularly suitable for pharmaceutical packaging and food packaging.



We are dedicated to creating value to our customers in all aspects!

从始至终,为客户创造价值!



**浙江科力塑料机械有限公司**  
ZHEJIANG KELI PLASTIC MACHINERY CO., LTD.

地址: 浙江省台州市黄岩区头陀前陈工业区  
Add: Qianchen Industrial Estate, Toutuo, Huangyan, Taizhou, Zhejiang, China  
Tel: 0086-576-84911388 84911398 Fax: 0086-576-84911399 E-mail: admin@tzkeli.com.cn  
Service Special Line: 0086-13905761196 Foreign trade special line: 0086-13957627011

www.cn-keli.com