



品质源于专业
Quality comes from profession

TDX-III



系列注塑机 宁波余姚天达机械有限公司
NINGBO YUYAO TIANDA MACHINERY CO.,LTD.

最新科技 行业领先

The latest technology . Lead the industry.

宁波余姚天达机械有限公司

NINGBO YUYAO TIANDA MACHINERY CO.,LTD.

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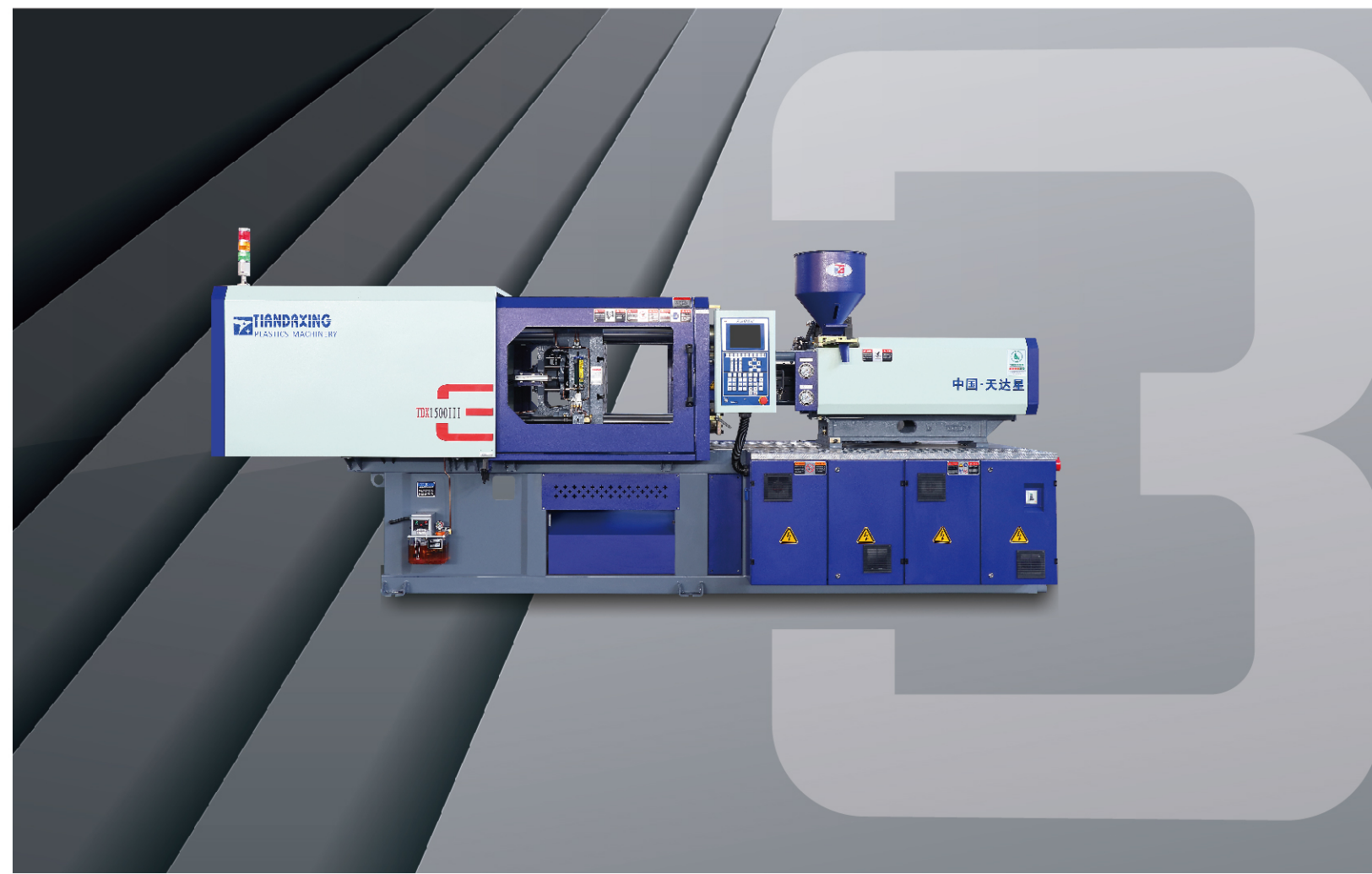
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THE LATEST TECHNOLOGY . LEAD THE INDUSTRY .

最新科技 行业领先

关于我们

宁波余姚天达机械有限公司地处拥有 7000 年文化的河姆渡遗址旁，公司占地面积 20000 余平方是一家专业生产塑料注塑成型机的高新技术企业。

公司实行先进的科学管理，坚持“质量第一”，有一支技术精湛的专业化科技人员，自行研制的 TDX 系列注塑机从设计、原材料的选择、零部件的装配、产品的出厂都经过严格检测把关。

Ningbo TIANDA Plastic Machinery Manufacture Co., Ltd. is located next to the Hemudu site with 7000 years of culture, the company covers an area of 20,000 square feet is a professional manufacturer of plastic injection molding machine high-tech enterprises.

The company implemented advanced scientific management, adhere to the "quality first". There are many skilled professionals and technical personnel, developed the TDX series injection molding machine selection of design, materials, assembly, parts are shipped products through rigorous testing checks.

ABOUT US

公司通过 ISO9001:2015 质量体系认证，产品通过国家注塑机检测中心的测试；产品的主要参数、安全性能、液压电器系统等达到同行业先进水平；TDX 系列注塑机具有外型优美、锁模能力强、低噪音、低能耗之特征。公司在中国拥有几十家营销网点和售后服务部，产品远销俄罗斯、东南亚、中东、南美洲等国家和地区，深受海内外客户的好评。

公司坚持“以人为本，客户至上”的经营理念，追求一流的高品质产品，愿与新老客户、同仁携手，共创辉煌明天。

Through ISO9001: 2015 quality system certification, product testing by the National Testing Center of the injection molding machine; main parameters of the product, safety performance, hydraulic systems and other electrical appliances to reach the advanced level; TDX series injection molding machine characteristics are strong clamp force, low noise, low energy consumption. Company in China has dozens of sales outlets and service departments, products are exported to Russia, Southeast Asia, Middle East, South America and other countries and regions, well received at home and abroad and favored customers.

The company believes "the quality first, development innovation, humanist, abides by honestly, the customer is supreme" the idea, willing to work with new and old customers, colleagues, to create a brilliant tomorrow!

TDX-PET 瓶胚专用注塑机

TDX-PET PREFORM SPECIAL INJECTION MOLDING MACHINE

根据瓶胚产品特点,多项结构、配置经过优化改进,生产效率更高,工艺更加稳定。

According to the characteristics of pet products, a number of structures and configurations have been optimized and improved, resulting in higher production efficiency and more stable process.



TDX-PVC 专用注塑机

TDX-PVC SPECIAL INJECTION MOLDING MACHINE

此系列采用料筒内压缩空气强冷装置, 镀硬铬粉料专用螺杆, 充分实现均匀塑化并有高度耐腐蚀性能, 加大油压马达以及多组抽芯, 均能保证 UPVC 粉料的生产要求。

This series adopts the strong cooling device of compressed air in the material barrel, the special screw for hard chromium plating fully realizes uniform plasticizing and has high corrosion resistance, the increase of oil pressure motor and multi-group core pulling can guarantee the production requirements of UPVC powder.



TDX- 排气式免烘料注塑机

TDX- EXHAUST TYPE NO - DRYING INJECTION MOLDING MACHINE

用排气注塑螺杆加工 ABS、PC、PA、PMMA 等改善效果非常明显。对于可电镀的 ABS 用排气注塑成型, 使制件镀层粘结性大为提高。

With exhaust injection screw processing ABS, PC, PA, PMMA and other improvements are very obvious. For electroplated ABS with exhaust injection molding, the coating adhesion is greatly improved.



TDX- 高速精密注塑机

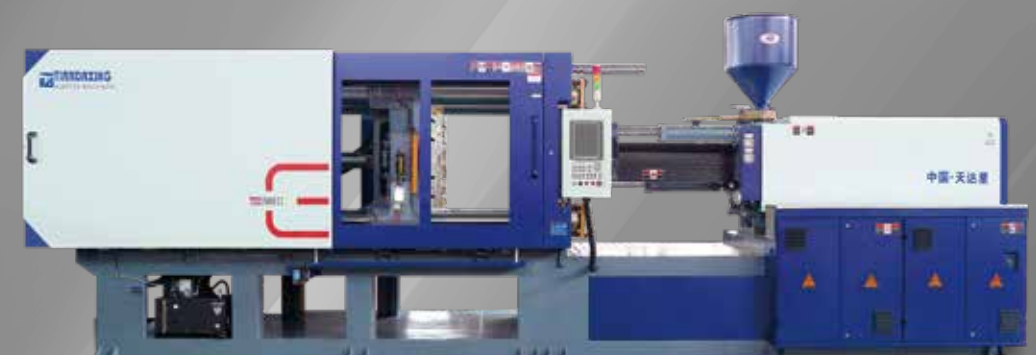
TDX- HIGH-SPEED PRECISION INJECTION MOLDING MACHINE

此机型采用进口高性能蓄能器, 注塑采用差运动方式, 合适精密要求高的超薄塑料产品的成型。

This model uses imported high-performance accumulator device, injection molding method using differential movement, Suitable for high precision thin-wall molded products.



WE HAVE MORE THAN THAT
我们拥有的不于此.....



01 STABLE AND RELIABLE CLAMPING UNIT

可靠平稳的锁模机构

合模部件通过计算机仿真，从运动学和动力学特性进行了整体优化，采用了技术领先的斜排五支点双曲肘锁模机构，模板经有限元分析，创新型空心球面结构的头板，箱式支架板和模板连体结构等，确保合模部件的高刚性和高可靠性，达到开合模平稳，锁模牢靠，同时超大的拉杆内间距，可安装较大的模具。

Clamping parts through computer simulation, from the feature of kinematics and dynamics of the whole optimization, adopted the advanced technology of oblique five fulcrum hyperbolic toggle clamping mechanism, template by the finite element analysis, an innovative hollow spherical head plate structure, box-type supporting plate and conjoined structure templates, etc., to ensure the high rigidity and high reliability of clamping parts, to achieve the process smoothly, clamping, at the same time pull rod that large span, can be installed a larger mold.

机械、液压、电器三重安全联锁保护

Mechanic, electronic & hydraulic triple interlock safety protection function

超灵敏的低压模具保护装置

Super sensitive low pressure die protection device.

多段开合模压力、速度、位置控制

Multiple stages control for mold opening clamping pressure, speed, positioning control

多种液压顶出模式

A variety of hydraulic support mode.



02 STABLE INJECTION DEVICE

稳定的射出装置

注射部件采用双缸平衡注射，双导轨直线导轨支撑。丰富的专用螺杆库供客户选择满足各种注塑材料材料的成型加工，并可配合多种专用注塑装置，方便了客户。采用了高性能低速大扭矩液压马达直接驱动螺杆预塑。

Injection parts adopt double oil cylinder balanced injection, double linear guide rail support. Rich special screw library for customers to choose to meet the requirements of various plastic injection materials molding, and can cooperate with a variety of special injection equipment, convenient for customers. High performance low-speed hydraulic motor with large torque is used to directly drive the screw preforming.

多级注射速度和压力及多级保压压力设定，可从注射时间、位置、压力三种方式控制保压切换点，保证成型质量。

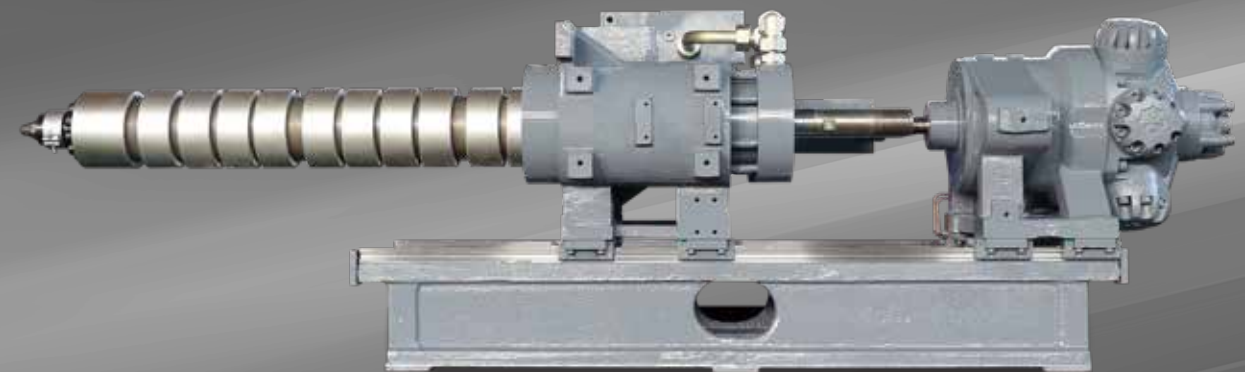
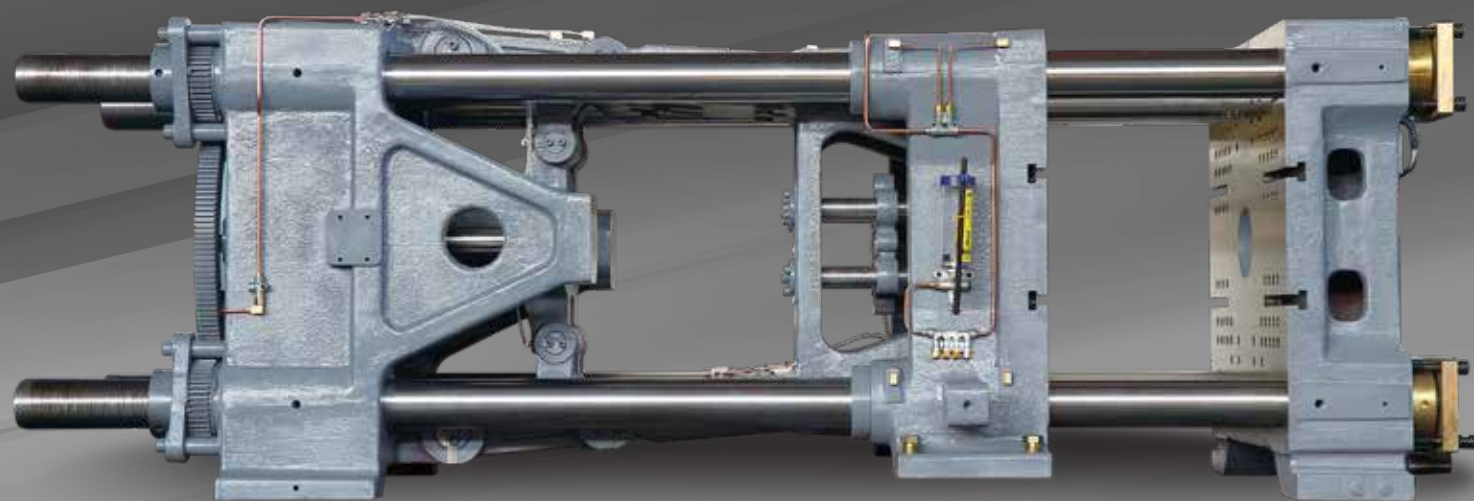
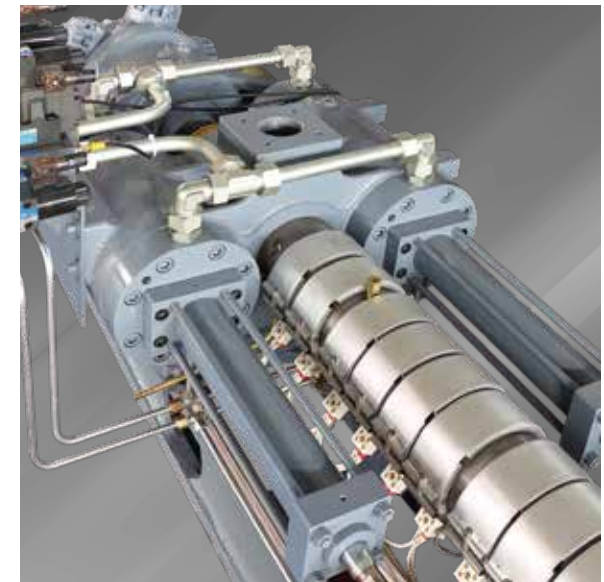
The setting of multi-stage injection speed and pressure and multi-stage pressure holding can control the pressure holding switching point from injection time, position and pressure to ensure the molding quality.

有几种螺杆、料筒，经优化设计，分别有氮化、镀硬铬、双金属等不同工艺制成，适合多种塑料及制品加工时的选择。

There are several screws and barrels with optimal design, Respectively, nitride, hard chromium plating, dual-metal, which is suitable for different plastic material's request.

大扭矩液压马达预塑质量稳定，高精度电子尺位置检测，计量准确。

Large torque hydraulic motor can make the pre-plastic quality stable, high precision electronic ruler to make accurate position detection.



03 HYDRAULIC UNIT

液压单元

在模块式设计的液压系统基础上，无论是精密节能技术，还是满足高效率生产的多同步动作，我们均可轻松为您解决。

Based on the modular design of the hydraulic system, both precision and energy saving technology, and meet the high efficiency production of synchronous movement, we can easily solve for you.

节能：标配伺服精密节能动力系统，其输出功率随负载变化而时刻调整，避免了对能量的浪费。根据产品的工艺不同，较之于传统注塑机，可节约用电20%~80%。

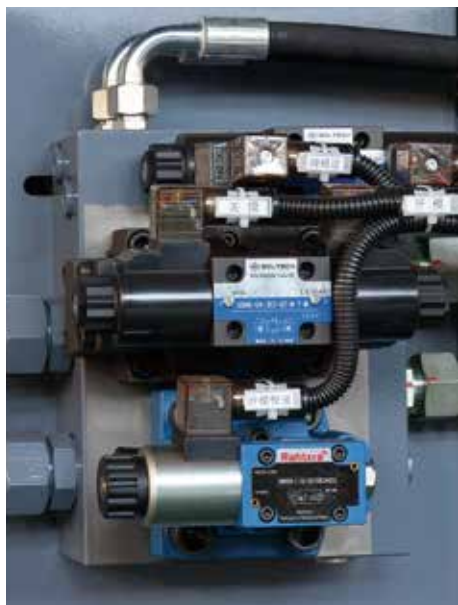
环保：机器运行低噪音、低能耗；欧洲名品液压胶管，采用DIN标准球面接头，阀板采用G螺纹密封堵头，杜绝油污污染。

方便：油箱采用可视化、可拆卸式设计，油品一目了然，方便维护；同时采用自封式磁性吸油过滤器，且所有管接头位置布置合理，维护简单、方便。

ENERGY SAVING: Standard with precision and energy saving servo power system, the output drive system is sensitively altered, according to the actual need of the plastic parts being produced, avoid energy waste. Depending on the plastic parts being produced and the material being processed, energy-saving ability can reach to 20%~80%.

ENVIRONMENTAL PROTECTION: The machine is running low noise, low power consumption; European Famous hydraulic hose, using the DIN standard spherical joints, valve plate with G thread sealing plug, to prevent oil pollution.

CONVENIENT: The oil tank adopts visual and detachable design, which makes oil products clear at a glance and easy to maintain. At the same time, self-sealing magnetic oil absorption filter, and all the pipe joints are arranged in a reasonable way, simple and convenient maintenance.



稳定可靠的硬件：采用国际一流硬件设计与生产检测技术，保证硬件产品稳定可靠；IO短路自我保护功能，使用更为放心；所有产品均通过CE标准认证，稳定的硬件性能大大减少了客户的维修和售后服务成本。

成熟的控制软件：控制软件已经非常成熟和完善。保证机器动作稳定、流畅的同时，更提供了机器自动校准、自动获取模具参数(Easy-Mold)、改进的温度PID控制等创新功能。

人性化界面设计：全新的人性化操作界面设计，布局更为合理，操作更为简便，让用户获得“机器使用原来如此轻松”的体验。

03 ELECTRIC UNIT

电控单元

STABLE AND RELIABLE HARDWARE: Adopt world first-class hardware and production testing technology, ensure its stable and reliable quality, IO short circuit protection function, more safety for using; All of product passed CE certificate, stable hardware performance reduced your maintenance and service cost.

EXCELLENT CONTROL SOFTWARE: Control software has been very mature and perfect. To ensure the stable and smooth movement of the machine, it also provides automatic calibration and automatic acquisition of the mold parameters (Easy-Mold), improved temperature PID control and other innovative features.

USER-FRIENDLY MENU DESIGN: New humanized interface design, the layout is more reasonable, more convenient operation, let the user get the experience of "machine to use the original" so easily.





可循环水离式润滑油泵

Circulating Water - Off Lubricating Oil Pump

可循环润滑油泵

CIRCULATING LUBRICATING OIL PUMP

- 可循环润滑油泵通过滤清器进行油水分离，水由自动排水装置排出，润滑油经两次自动沉淀后通过细和精细两个滤清器的过滤后进入合格油品储油室进行重复利用。达到废润滑油零排放，不污染环境的优点。
- 如果机器工作50万模,传统润滑油泵一般需要350升润滑油，可循环润滑油泵运用循环再利用只需35升润滑油，比传统润滑油泵节省90%成本。
- 可循环润滑油泵采用自动循环的方式，无需添加新油，倒废油工作，基本无需人员管理，大大节省人工，节省润滑油，延长塑机维修周期，节省维修费用提高经济效益。
- The circulating lubricating oil pump separates oil and water through the filter, the water is discharged by the automatic drainage device, and the lubricating oil enters the qualified oil storage room for reuse after two automatic precipitation through the fine and fine filters. Achieve zero discharge of waste lubricating oil, do not pollute the advantages of the environment.
- If the machine works with 500,000 molds, the traditional lubricating oil pump generally needs 350 liters of lubricating oil. The recyclable lubricating oil pump only needs 35 liters of lubricating oil for recycling, saving 90% of the cost compared with the traditional lubricating oil pump.
- The recirculating lubricating oil pump adopts the way of automatic circulation, no need to add new oil. The waste oil work basically does not need personnel management, greatly saves labor, saves lubricating oil, prolongs the maintenance cycle of the plastic machine, saves the maintenance cost, improves the economic benefit.



油冷电机
Oil-cooled motor

噪音低超级省电，体积小动力强劲，扭力大节能稳定，即环保维护方便。

Low noise, low power, small size, strong power, large torque and energy saving, which is convenient for environmental protection.



风冷电机
Air-cooled motor

低惯量，功率范围宽，高速和紧凑结构的同步伺服电机，保证系统高动态的要求。

The synchronous servo motor with low inertia, wide power range, high speed and compact structure ensures the high dynamic requirements of the system.



螺杆泵
Screw pump

压力控制精度高,上下波动小于0.5bar,提高制品的成型质量,减少原材料浪费;开合模位置重复精度高,配合高精模具,可以达到0.3%的注塑精度。

High pressure control accuracy, fluctuation less than 0.5 Bar, improve the molding quality of products, reduce the waste of raw materials; High precision of opening and closing position, with high precision mold, can achieve 0.3% injection precision.



住友泵
Sumitomo pump

为伺服泵系统特别设计，采用密封间隙补偿即使在低转速和低粘度油液情况下工作，也能保持高效率。

Specially designed for servo pump system, it can maintain high efficiency even when working at low speed and low viscosity oil with seal clearance compensation.

EXHAUST TYPE NO-DRYING INJECTION MOLDING MACHINE

排气式免烘料注塑机



用排气注塑螺杆加工ABS、PC、PA、PMMA等改善效果非常明显。对于可电镀的ABS用排气注塑成型，使制件镀层粘结性大为提高。对于PC，当水的含量才0.03%时产品质量也会有所降低，而如果采用排气注塑，物理性能没有明显降低。近年来，为了节能,减少烘干程序，排气注塑螺杆用来加工PA带水回头料被广泛地应用。



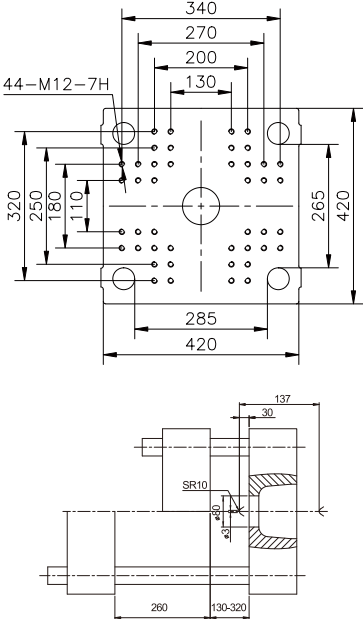
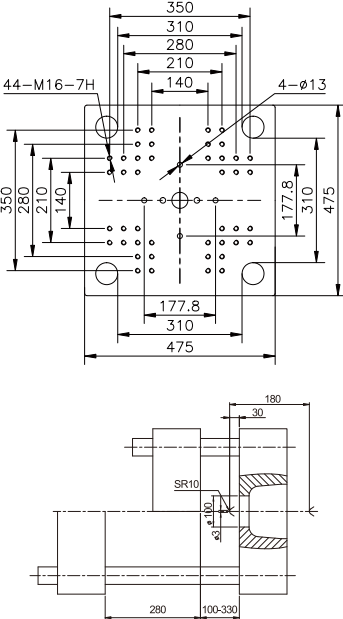
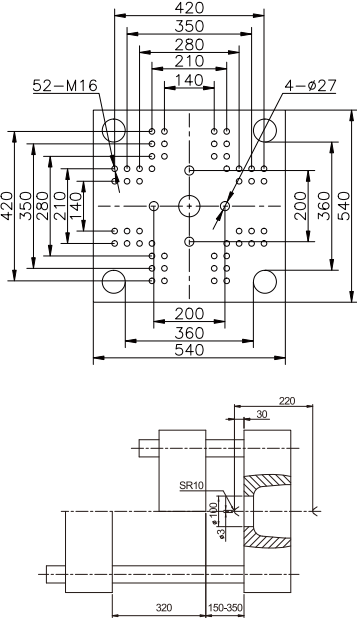
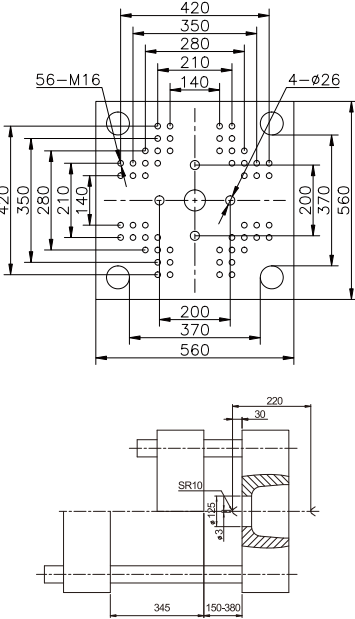
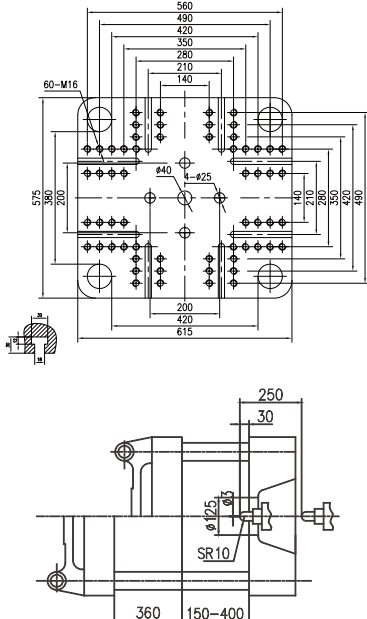
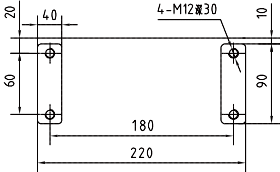
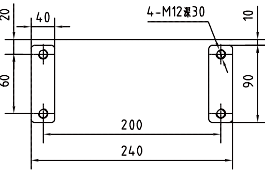
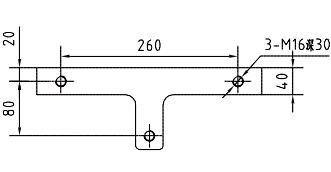
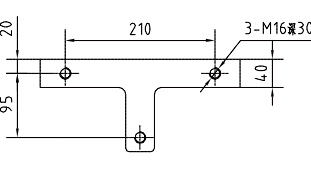
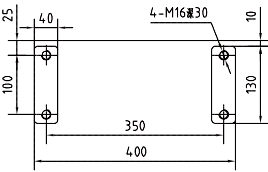
When ABS, PC, PA, PMMA and other materials are processed with exhaust injection screw, the improvement effect is very obvious. For electroplated ABS with exhaust injection molding, the product coating adhesion is greatly improved. In the production of PC material products, when the water content is 0.03%, the quality will be reduced, and if the use of exhaust injection molding, the physical performance is not significantly reduced. In recent years, in order to save energy and reduce the drying process, exhaust injection molding screw used to process PA with water return material is widely used.

技术优点 Technical Advantages

- 无须将吸水的成型材料进行预干燥，减少工序，节约时间
- 规避了一些材料存储的浪费(如:占用场地资源闲置、降低资金周转风险)
- 可以除去挥发性物质至最低限度，提高制品机械性能，改善外观质量
- 提高产品切换效率、换型时间、等待时间
- 提高成型范围，提升产品合格率，使工艺更加稳定
- 提高厂房布局利用率及提高设备合理利用率
- There is no need to pre-dry the absorbent molding material, reduce the process, save time;
- Can remove volatile substances to the minimum, improve the mechanical properties of products, improve the appearance of quality;
- Improve the molding range, improve the product pass rate, make the process more stable.
- Avoid the waste of some materials storage (such as: occupy the site resources idle, reduce the risk of capital turnover)
- Improve product switching efficiency, change-over time and waiting time;
- Improve the utilization rate of plant layout and reasonable utilization rate of equipment;



树脂	非排气成型	排气成型
尼龙66 (在空气中无条件保持24小时,含水量0.13%) Nylon 66(unconditionally remain in the air for 24 hours, moisture content 0.13%)	产生银丝(成型后制品的含水量为0.17%) Produced silver wire (moisture content of the molded product is 0.17%)	制品表面有光泽,无银丝 (成型后制品的含水量为0.07%) Products with shiny surface, no silver wire (moisture content of the molded products is 0.07%)
AS树脂 There is no need to pre-dry the absorbent molding material, reduce the	粘性物质附着在模具和成型制品上,每注射20~30次就必须清洗模具,制品表面无光泽 Sticky material is attached to the mold and molding products, every injection 20-30 times must be cleaned mold, product surface dull	产生粘性物质,模具不必清洗,能够保证制品的良好质量和均匀性 Produces the viscous material, the mold does not have to clean, can guarantee the good quality and the uniformity of the product
PC (维持无条件空气,无预干燥) PC(maintain unconditional air, no pre-drying)	出现银丝 A silver	无银丝和光泽表面 No silver and shiny surface
聚甲醛 polyoxymethylene	甲醛臭味残留在成型制品中,粘性物质附着在模具上,制品必须浸泡在温水中除臭,每注射200次必须清洗模具 Formaldehyde odor residue in the molding products, sticky substances attached to the mold, the products must be soaked in warm water deodorization, every injection of 200 times must be cleaned mold	制品无臭味,表面有光泽,不会产生粘性物质(不需除臭和清洗模具) Products odorless, shiny surface, no sticky substances (no need to deodorize and clean the mold)
ABS (无预干燥) ABS(no pre-drying)	产生银丝(需要预干燥或料斗干燥器) Produce silver wire (require pre-drying or hopper dryer)	制品表面有光泽,无银丝(不必须干燥) Produce silver wire (require pre-drying or hopper dryer)
PMMA (无预干燥) PMMA(no pre-drying)	产生银丝(需要预干燥或料斗干燥器) Produce silver wire (require pre-drying or hopper dryer)	制品无银丝,质量高,尤其在透明度方面 Silvery free, high quality, especially in terms of transparency
聚丙烯 Polypropylene	成型后聚丙烯特有臭味 After molding, polypropylene has a peculiar odor	制品无臭味,表面极光泽 Products no smell, the surface is very shiny
硬PVC (粉末状) Hard PVC(powdered)	成型周期被延长(由于树脂中吸入空气和发热,螺转速不能增加) The molding cycle is prolonged (the screw speed cannot be increased due to air inhalation and heat in the resin)	缩短了成型周期,塑化性能得到改善,特别是表面光泽性良好 The molding cycle is shortened and the plasticizing performance is improved, especially the surface gloss is good

项目	DESCRIPTION	CN	TDX-580			TDX-680			TDX-900			TDX-1000			TDX-1200		
注射装置	INJECTION UNIT		A	B	C	A	B	C	A	B	C	A	B	C	A	B	C
螺杆直径	Screw diameter	m	28	30	32	25	32	35	30	32	35	30	35	40	38	40	42
螺杆长径比	Screw L/D ratio	L/D	20.1	18.8	17.6	24	22	19	23.5	22	20.1	22	20	19	22	20	18.6
理论注射容积	Theoretical shot volume	cm³	62	70	80	64	100	125	117	133	158	120	163	214	226	251	276
注射重量	Shot weight(PS)	g	56	64	73	56	91	109	106	121	144	109	149	194	206	228	252
注射压力	Injection pressure	Mpa	168	147	129	275	166	140	230	203	170	264	194	148	215	200	186
螺杆转速	Max.screw speed	rpm	250			213			213			228			250		
锁模系统	CLAMPING UNIT																
锁模力	Clamping force	kN	580			680			900			1000			1200		
开模行程	Opening stroke	mm	260			280			320			345			360		
拉杆内间距	Distance between tie-bars	mm	285x265			310x310			360x360			370x370			420x380		
最大模厚	Max.mold height	mm	320			330			370			380			430		
最小模厚	Min.mold height	mm	110			100			150			150			150		
顶出行程	Ejector stroke	mm	60			80			90			100			120		
顶出力	Ejector force	kN	20			31			30			33			40		
其他	OTHERS																
电马达功率	Drive power	KW	5.5			7.5			11			11			13		
伺服马达功率	Servo drive power	KW	8.5			12.5			12.5			12.5			12.5		
电热功率	Heating capacity	KW	4.2			5			7			7.2			7.3		
外形尺寸	Machine dimensions	m	3.0x1.2x1.65			3.1x1.2x1.72			3.31x1.19x1.79			4.35x1.2x1.8			4.35x1.26x1.8		
机器重量	Machine weight	t	1.65			2.4			2.6			3.0			3.4		
模板尺寸图 Template Size Drawing																	
																	

该型号注射量按PS比重1.05计算
The shot weight is based on polystyrene at specific gravity of 1.05

因设计更新，以上规格如有改动，恕不另行通知。
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项目	DESCRIPTION	CN	TDX-1500			TDX-1700			TDX-1800			TDX-2000			TDX-2500		
注射装置	INJECTION UNIT		A	B	C	A	B	C	A	B	C	A	B	C	A	B	C
螺杆直径	Screw diameter	m	38	42	45	42	45	50	45	50	55	45	50	55	55	60	65
螺杆长径比	Screw L/D ratio	L/D	22	20	18.5	22	20	18.5	22	20	18.5	22	20	18.5	23	21	19
理论注射容积	Theoretical shot volume	cm³	238	290	333.8	318	365	451	397	490	593	397	497	593	724	861	1011
注射重量	Shot weight(PS)	g	216	264	303	289	332	410	361	446	540	361	446	540	659	784	920
注射压力	Injection pressure	Mpa	200	163	143	203	177	143	174	141	117	174	141	117	200	168	143
螺杆转速	Max.screw speed	rpm		250			200			210			210			187	
锁模系统	CLAMPING UNIT																
锁模力	Clamping force	kN	1500			1700			1800			2000			2500		
开模行程	Opening stroke	mm	390			435			435			475			560		
拉杆内间距	Distance between tie-bars	mm	420x420			465x465			480x480			520x520			580x580		
最大模厚	Max.mold height	mm	460			550			550			550			580		
最小模厚	Min.mold height	mm	160			200			180			200			200		
顶出行程	Ejector stroke	mm	130			150			150			155			155		
顶出力	Ejector force	kN	46			46			46			62			62		
其他	OTHERS																
电马达功率	Drive power	KW	15			15			18.5			18.5			22		
伺服马达功率	Servo drive power	KW	17			17			21			21			25.5		
电热功率	Heating capacity	KW	7.4			9.9			11.5			11.5			13.5		
外形尺寸	Machine dimensions	m	4.6x1.3x1.8			5.18x1.35x 2.2			5.2x1.45x2.25			5.45x1.4x2.3			5.98x1.47x2.3		
机器重量	Machine weight	t	4.0			5.5			6.0			6.9			8.0		
模板尺寸图 Template Size Drawing																	

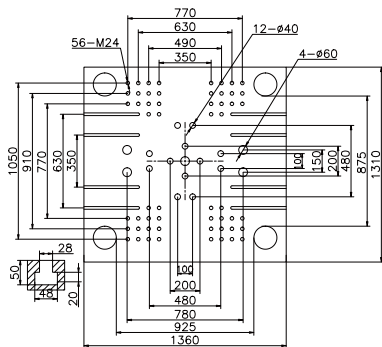
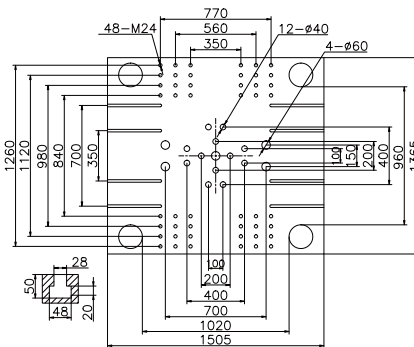
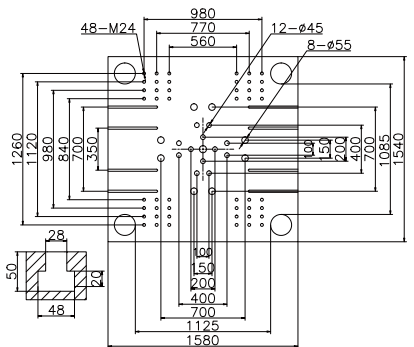
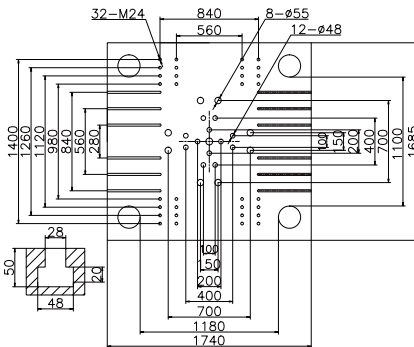
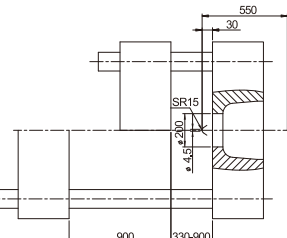
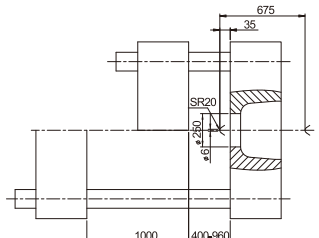
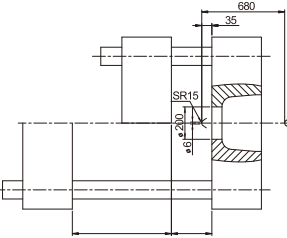
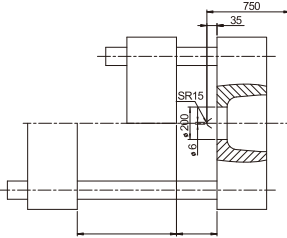
该型号注射量按PS比重1.05计算
The shot weight is based on polystyrene at specific gravity of 1.05

因设计更新，以上规格如有改动，恕不另行通知。
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项目	DESCRIPTION	CN	TDX-2800			TDX-3500			TDX-4500			TDX-5500				
注射装置		INJECTION UNIT		A	B	C	A	B	C	A	B	C	A	B	C	D
螺杆直径	Screw diameter	m	55	60	65	60	65	70	70	75	80	75	80	85	90	
螺杆长径比	Screw L/D ratio	L/D	23	21	19	23	22	20	22	20	19	23	21	20	20	
理论注射容积	Theoretical shot volume	cm³	724	861	1011	1045	1227	1423	1501	1723	1960	1727	1965	2219	2487	
注射重量	Shot weight(PS)	g	659	784	920	951	1116	1295	1366	1568	1784	1572	1788	2019	2264	
注射压力	Injection pressure	Mpa	200	168	143	214	182	157	199	173	152	191	168	148	132	
螺杆转速	Max.screw speed	rpm	200			192			200			163				
锁模系统		CLAMPING UNIT														
锁模力	Clamping force	kN	2800			3500			4500			5500				
开模行程	Opening stroke	mm	590			669			740			850				
拉杆内间距	Distance between tie-bars	mm	615x615			730x670			770x770			870x820				
最大模厚	Max.mold height	mm	630			650			860			830				
最小模厚	Min.mold height	mm	200			260			250			330				
顶出行程	Ejector stroke	mm	155			190			200			265				
顶出力	Ejector force	kN	70			70			110			150				
其他		OTHERS														
电马达功率	Drive power	KW	30			37			45			55				
伺服马达功率	Servo drive power	KW	39			42.5			53			53				
电热功率	Heating capacity	KW	18.3			22.8			29.5			33.5				
外形尺寸	Machine dimensions	m	6.1x1.56x2 .35			6.9x2.0x2.35			7.5x1.95x2.4			8.5x2.2x2.8				
机器重量	Machine weight	t	9			11.5			16.4			18.6				
模板尺寸图 Template Size Drawing																
机械手安装尺寸图 Installation dimensions of manipulator																

该型号注射量按PS比重1.05计算
The shot weight is based on polystyrene at specific gravity of 1.05

因设计更新，以上规格如有改动，恕不另行通知。
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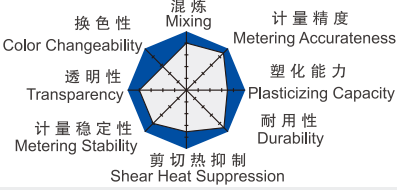
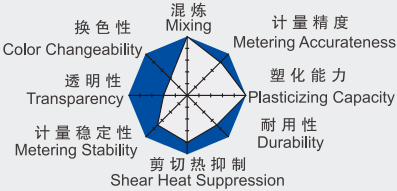
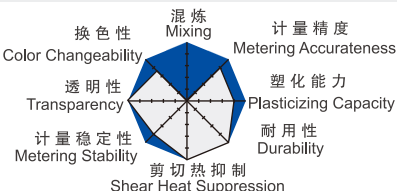
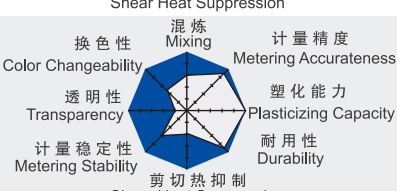
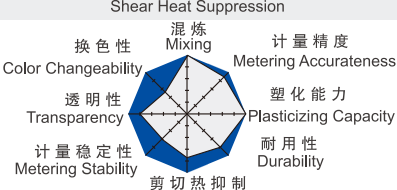
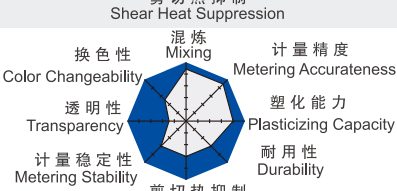
项目	DESCRIPTION	CN	TDX-6500				TDX-7500				TDX-9500			TDX-11000			
注射装置	INJECTION UNIT		A	B	C	D	A	B	C	D	A	B	C	A	B	C	D
螺杆直径	Screw diameter	m	90	95	100	105	90	95	105	110	95	100	105	100	110	120	130
螺杆长径比	Screw L/D ratio	L/D	23	21	20	19	23	21	20	18.5	23	21	20	23	21	20	18.5
理论注射容积	Theoretical shot volume	cm³	2736	3048	3377	3723	2990	3331	4070	4467	3544	3927	4330	4365	5282	6285	7377
注射重量	Shot weight(PS)	g	2489	2774	3073	3388	2721	3032	3703	4065	3225	3574	3941	3972	4805	5720	6712
注射压力	Injection pressure	Mpa	184	165	149	135	194	174	143	130	171	155	140	206	170	143	122
螺杆转速	Max.screw speed	rpm	149				125				125			125			
锁模系统	CLAMPING UNIT																
锁模力	Clamping force	kN	6500				7500				9500			11000			
开模行程	Opening stroke	mm	900				1000				1100			1250			
拉杆内间距	Distance between tie-bars	mm	925x875				1020x970				1125x1085			1180x1100			
最大模厚	Max.mold height	mm	900				960				1100			1250			
最小模厚	Min.mold height	mm	330				400				500			500			
顶出行程	Ejector stroke	mm	335				340				335			325			
顶出力	Ejector force	kN	150				210				216			245			
其他	OTHERS																
电马达功率	Drive power	KW	30+37				37+37				45+45			55+37			
伺服马达功率	Servo drive power	KW	25.5+42.5				42.5+42.5				42.5+42.5			42.5+42.5+21			
电热功率	Heating capacity	KW	42.8				54.3				61.3			63.9			
外形尺寸	Machine dimensions	m	10.2x2.2x2.71				11.43x2.4x3.14				11.7x2.8x3			11.5x2.6x2.85			
机器重量	Machine weight	t	26				35				47			50			
模板尺寸图 Template Size Drawing																	
机械手安装尺寸图 Installation dimensions of manipulator																	

该型号注射量按PS比重1.05计算
The shot weight is based on polystyrene at specific gravity of 1.05

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多种类螺杆符合各种特性的树脂材料

LOTS OF TYPE OF SCREW CAN BE APPLIED TO MANY KINDS OF RESINS

螺杆型号Screw Type	适用范围Applicability	性能Performance
GS	PS, PP, PE, ABS, EVA, SPVC, CA, POM, AS, PMMA, PA, PC, PBT, PPO, PET, TPX	
MA	PS, PP, PE, ABS, EVA, SPVC, CA, POM, AS, PMMA, PA, PC, PBT, PPO, PET, TPX	
TS	PS, ABS, AS, PMMA, PC	
MS	PS, PP, PE	
MP	PS, PP, PE, ABS, EVA, SPVC, POM, AS, PBT, PPO, PMMA, PA, PC	
RP	PS, PP, PE, PUR, POM, AS, PMMA, PA, PET	
MR	PS, PP, PE, ABS, EVA, CA, POM, AS, PMMA, PA, PC, PBT, PPO, PET, TRX	
AP	PP, PE, EVA, SPVC, RPVC	
MM	PP, PE, EVA, CA, SPVC, POM, PBT, PPO, PET, TRX	

塑胶原料性能

PLASTIC MATERIAL PERFORMANCE

中文名称	Material	比重Specific gravity	熔点Mel.point (℃)	注射温度Inj. temp (℃)	注射压力Inj. pre. (10Psi)	收缩率Shrinkage (%)
聚丙烯胶、丁二烯、笨乙烯	ABS	1.05	110	230	8~25	0.6
聚缩醛、特灵	Acetal (Homopolymer)	1.42	181	216	10~20	2.2
聚缩醛、赛钢、特灵	Acetal (Copolymer)	1.41	175	204	10~20	2
ABA弹性胶	ASA	1.07	—	243	8~25	0.6
酸性胶、醋酸纤维	CA	1.3	230	210	8~32	0.5
酸性胶、醋酸纤维	CAB	1.2	140	210	8~32	0.5
EVA胶	EVA	0.94	80	120	8~20	1
普通级笨乙烯、硬胶	GPPS	1.07	100	162~260	10~30	0.4
不碎级笨乙烯、不碎硬胶	HIPS	1.06	100	177~316	10~30	0.4
氟塑料	FEP	2.15	275	376	5~20	3~6
氟塑料	PFA	2.15	310	400	5~20	4
低密度聚乙烯、软胶	LDPE	0.92	120	149~316	8~30	1.5~5
高密度聚乙烯、软胶	HDPE	0.95	130	149~316	10~20	2~5
超高密度聚乙烯	UHMPE	0.94	130	—	—	—
尼龙6	PA6	1.13	216	260	—	1
尼龙66	PA66	1.14	265	300	—	0.8~1.5
增强尼龙	PAST	1.1	216	270	—	0.8~1.8
尼龙12	PAIZ	1.01	179	230	—	0.3~1.5
PBT胶	PBT	1.35	250	260	4~10	1.5~2.0
聚碳酸醋，防弹胶	PC	1.2	150	295	10~20	0.6
PET胶	PET	1.37	258	300	10~20	2.25
聚丙烯，百折胶	PP	0.91	176	245	10~20	1~2.5
PPO胶	PPO	1.08	112	300	14~20	0.6
聚矾	PSF	1.24	220	371	15~20	0.7
PU胶、乌拉坦胶	PU	1.15	140	204	10~20	0.1~3
硬PVC	Rigid PVC	1.3~1.58	75~105	180	10~40	0.1~0.5
软PVC	Soft PVC	1.16~1.35	75~105	175	8~25	1~5
AS胶	SAN	1.09	115	250	10~33	0.2
亚加力	PMMA	1.19	100	182	10~20	0.5
PEA弹性胶	PEA	1.39	—	400	5~10	—