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**MM** 雙色成型注塑機系列

MULTI-MOULD MASTER PLASTIC  
INJECTION MOULDING MACHINE SERIES



# Introduction

## 公司簡介



仁興集團成員內歷史最悠久為仁興機器廠有限公司，該公司成立於香港二十世紀五十年代，致力研制注塑成型機，是香港該行始創者之一。創業至今都以質量及信譽奉為經營之道，五十多年來所研制的各系列注塑成型機均以質量優越而享譽國際。

九十年代初，仁興集團在中國深圳市成立仁興機械（深圳）有限公司，自資興建廠房及購置進口生產設備，更獲ISO9001質量保證證書。近年又積極研制AM系列冷、熱室金屬壓鑄機。

*Yan Hing Group was established in Hong Kong since 1950's. Going through more than 50 years of development, our subsidiary company includes Yan Hing Engineering Works Ltd, Yan Hing Machinery (Shen Zhen) Co. Ltd, Yan Hing Machinery (Fo Shan) Co. Ltd, Glory Machinery Ltd. Our core business has been to produce and improve plastic injection moulding machines. By putting top priority on high quality and continuous improvement, Yan Hing's high quality products have since gained worldwide reputation.*

*In 1991, Yan Hing Machinery (Shenzhen) Co. Ltd. was set up as a branch factory in Shenzhen, China. With a purpose-built and well-designed industrial complex, the factory possesses a wide range of advanced facilities for manufacturing.*

仁興集團另一個成員威信機械有限公司，致力研制PW系列冷、熱室金屬壓鑄機。該系列凝聚了精密和高速於一身，得到國內外買家愛戴。又於2003年成功研制國內首臺鎂合金冷、熱室金屬壓鑄機。

仁興集團再在中國佛山市擬建超級工業園，除加強研制注塑成型機及金屬壓鑄機外，更計劃製造其它精密機械。

經過半個世紀之穩步發展，仁興集團已建造了多個重型設備的製造基地，除具備各種精密加工機械及工藝外，亦擁有一團優秀的機械設計及製造和管理人才，成為最具競爭優勢之機械製造商；又憑着完善和豐富的企業管理經驗，在注塑機成型機製造行業成績卓越外，集團再積極投放發展金屬壓鑄機械，亦取得了重大的成果，獲客戶一致好評。



*Having been accredited with ISO9001 as proof of our achievement, we endeavor to build a heavy industrial base and recruit a team of best skilled and dedicated employees. As a result, we succeed in maintaining a competitive position in the marketplace. Under an innovative and dynamic management, we have demonstrated remarkable successes in introducing the new product of die-casting machine into our business as well as securing enduring relationship with our esteemed customers. In recent years, we are also actively developing AM series hot/cold chamber die casting machines.*

*The other member of the Yan Hing Group, Glory Machinery Limited, has successfully developed PW series hot/cold chamber die casting machines. Machineries in this series have attracted worldwide attention for its accurate and high speed functions. In 2003, we successfully developed the first magnesium alloy hot/cold chamber die casting machine in the country.*

*Yan Hing Group is now building a new headquarter in the Fo Shan China. Our aim for this is not only to strengthen our development in injection molding and die casting machines but also planning to diversify our product to other type of machineries.*

*During the 60 years, Yan Hing Group has grown into a corporate consisting of heavy CNC centres, strong production team, talented machinery designers and excellent management team.*

## 發展歷程—仁興歷史大事記

- 1950年 在香港仁興第一臺柱塞式注塑機誕生
- 1959年 開發生產液壓驅動式注塑機
- 1960年 開發生產預熔器注塑機，採用開關式電氣元件和繼電器控制
- 1974年 開發生產螺旋直射注塑機
- 1979年 開發生產數控注塑機
- 1982年 開發生產程序控制注塑機
- 1988年 開發生產全電腦控制注塑機
- 1991年 中國成立仁興機械（深圳）有限公司，深圳寶安龍華自資興建20000平方米工業廠房
- 1995年 開發生產直壓式鎖模精密注塑機
- 1999年 香港將軍澳工業邨新建15000平方米工業廠房正式運行
- 1999年 獲發ISO9001品質保證證書
- 2000年 同香港生產力促進局聯合開發生產環保節能高效全電動注塑機
- 2002年 引進德國技術、開發壓鑄機項目
- 2003年 深圳20000平方米第二期工業廠房正式運行
- 2003年 開發生產大型兩板夾齒開合鎖模式液壓注塑機
- 2003年 寶弘PW壓鑄機品牌推出鎂合金冷、熱室壓鑄機
- 2004年 開發生產鎂鋅合金鑄機
- 2004年 寶弘PW壓鑄機品牌推出全東南亞首臺半固態壓鑄機
- 2005年 開發生產油電混合式注塑機
- 2006年 在深圳仁興第一臺熱室壓鑄機誕生
- 2006年 開發生產冷室壓鑄機
- 2006年 佛山120000平方米新工業園項目正式啓動
- 2007年 同香港生產力促進局聯合開發生產超微型注塑機
- 2008年 成功收購香港寶弘PW壓鑄機品牌技術
- 2008年 雙色注塑機榮獲香港工業獎
- 2009年 仁興推出注塑機伺服節能系統
- 2010年 加強研發大型注塑機及壓鑄機
- 2011年 引進美國進口“ERP SYSTEM”企業資源規劃系統
- 2012年 佛山工業園正式投入生產



# history and development

- 1950 Development and production of plunger-type injection moulding machine
- 1959 Development and production of hydraulic driven injection moulding machine
- 1960 Development and production of pre-plasticising injection moulding machine.
- 1974 Development and production of in-line screw injection moulding machine
- 1979 Development and production of digital controlled injection moulding machines
- 1982 Development and production of PLC controlled injection moulding machines
- 1988 Development and production of computer controlled injection moulding machine
- 1991 Yan Hing Machinery (Shenzhen) Co. Ltd. was established
- 1995 Development and production of hydraulic direct clamping injection moulding machines
- 1999 (Hong Kong, Tseung Kwan O )15,000-squared-metre industrial base established
- 1999 Granted the BSI ISO9001 quality certificate
- 2000 Joined together with Hong Kong Productivity Council, developed 'high efficiency, energy-saving injection moulding machines
- 2002 Invest in high technology technique for die-casting machine development
- 2003 Launched PW series 850 tonnes Multi-function High Speed Magnesium and Aluminium Alloy Cold Chamber Die Casting Machine
- 2003 Shenzhen plant expansion. Completed construction of second phase factory.
- 2003 Development and production of two-platen hydraulic-mechanical clamping injection moulding machine
- 2004 Launched the first PW series Semi-solid Die-Casting Machine in Southeast Asia and China
- 2005 Development and production of servo-driven power saving injection moulding machines
- 2006 First hot chamber die-casting machine and cold chamber die-casting machine manufactured in Yan Hing, Shenzhen
- 2006 Started building a 1,320,000-squared-metre- industrial park in Gao Ming, Fo Shan city
- 2007 Developed the fully electric micro-injection moulding machine
- 2007 First magnesium-zinc alloy die-casting machines produced in Yan Hing
- 2008 Awarded the '2008 HK Awards for Industries Machinery and Machine Tools Design Award' for our design in MM series multi-colour injection moulding machine
- 2008 Merged and acquired Hong Kong Pro-win die casting machines brand and production in the aim of supplying the overseas market
- 2009 Yan Hing launched "EcoPow" servo-drive system.
- 2010 Enhance development of heavy series injection moulding and die casting machinery
- 2011 Introduced the use of US brand ERP system
- 2012 Production starts in Fo Shan plant

# MM

## 雙色成型注塑機系列

MULTI-MOULD MASTER PLASTIC INJECTION MOULDING MACHINE SERIES

轉盤式清雙（多）物料注塑功能  
Turntable Transfer Mechanism Function

轉軸式清雙（多）物料注塑功能  
Rotation of Core Function

雙（多）物料混色注塑功能  
Two Colour Mixing Device Function



■ 機器型號(Model): MM130、MM200、MM300、MM400

### MM雙色成型注塑機系列

MM系列多物料注塑機帶領進入多物料注塑技術新領域。它不但容許生產包含兩種不同塑料/顏色的制品，還可配合客戶要求增加注射裝置，達到注塑更多物料/顏色制品的要求。其獨有的模具轉盤設計由專用伺服電機驅動，可準確控制模具轉向位置。

#### Multi-Mould Master Plastic Injection Moulding Machine Series

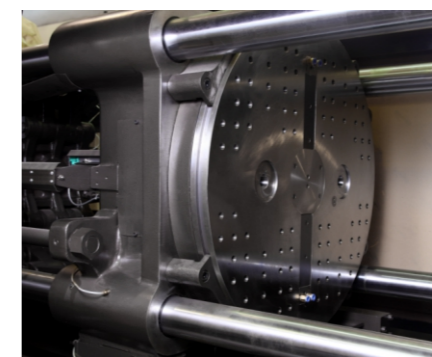
MM Series Multi-mould machine leads you to the new era of multi-component moulding technology. It is designed to mould a product consisting of two different materials/ colour by rotating the mould halves by rotary table mounted on the movable platen. The enlarged rotary table driven by servo motor can accurately index the designated position. MM Series machine can also be promoted with additional injection units for multi-materials / colour injection.

#### 轉盤式清雙（多）物料注塑功能

利用轉盤轉換模腔實現雙（多）物料注塑是本系列標準配置的功能，無需增加其他裝置就可以直接在模具上注射成型。本系列包括兩套水平且平行布置的獨立控制注射系統，活動模板上裝有由伺服馬達驅動的

轉盤，轉盤可以按預高的指令在0度和180度之間反復轉動，且可在其中任何一個位置停固面進行注塑。

在進行第一次塑料注射後開模，轉盤帶動模具及塑件轉至180度位置，經過電器及機械定位後已初塑的工件再合模進行第二次塑料注射成型。由於兩組平行的注射系統同步進行，因此，每一次開模後（一個周期完成），就獲得一件由兩種特料/顏色注塑成型的產品。本機操作簡單容易，祇需在電腦屏幕上設置“轉盤使用方式”為“使用轉盤”即可。

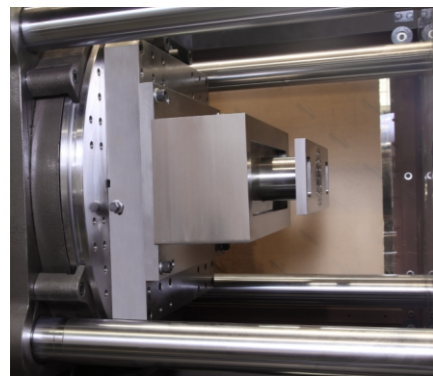


#### Turntable Transfer Mechanism

The turntable device is a built-in component in the machine, which can be used directly without any installation. The series consists of two independent injection systems. A servo motor is implemented on the moving platen to drive the turntable device. The turntable can be rotated by 0° and 180° reciprocally. After the first component is initially injected in one mould, the generated first part is then transferred to another blank mould with a rotation of 180°, in which the injection of the second component is occurred. With the use of the turntable, parts with multi-component are manufactured in a single step, which can reduce the cycle time. This transfer mechanism set up is simple. Users can select this mode directly on the LCD screen and input the required parameters.

## 轉軸式雙（多）物料注塑功能

于轉盤式注塑機的基楚上，在活動模板內增加一套轉軸及頂出機構，轉軸會自動執行電腦指令，在0度和180度範圍內往覆轉動及指定的行程內伸出及縮回。在進行第一次塑料注射後開模，轉軸會自動把連帶已初塑制品的模芯頂出。伺服馬達帶動轉軸從0度旋轉180度之後模芯縮回，然後再合模，下一周期對已初塑的半成品進行第二次塑料注射成型。由于兩組平行的注射系統同步進行，因此，每一次開模後（一個周期），就可以獲得一件由兩種物料注塑成型的產品。這種轉軸注塑方式，適合于第一種被第二種塑料全包或注塑穿透類的產品，例如有通透塑字的牙刷柄等。此工



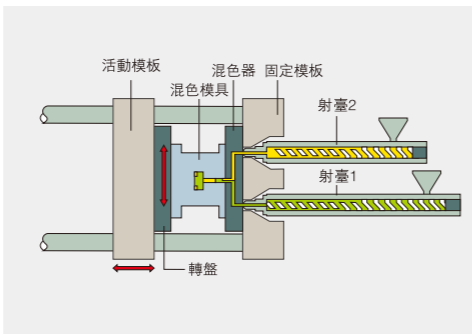
藝還較機械手更準、更快、亦比人手放置更安全。

本機操作簡單容易，祇需在電腦屏幕上設置“轉盤使用方式”為“使用轉芯”即可，轉芯旋轉、頂出及縮回等參數可隨意設置。

### Rotation of Core

*In this transfer mechanism, over moulding of two materials can be performed in a single plastic injection moulding machine with one multi-cavity mould. This mould consists of two symmetric mould bases with a central rotary core. The core is driven by a servo motor, which can be rotated by 0° and 180°. It can extend and contract at a predefined distance before rotation. After the first injection, the core extends outwards and rotates by 180°, and retracts inwards, after which the first part is over moulded with another material. Parts with multi-component are manufactured in a single step. This type of mechanism is most suitable in the manufacturing of over moulding products, such as toothbrushes. The rotation of core transfer mechanism is more accurate and effective than robotic arm transfer mechanism and is safer than done manually. This transfer mechanism set up is simple. Users can select this mode directly on the LCD screen and input the required parameters.*

## 雙（多）物料混色注塑功能



本機在原有配置下，可以注塑成雲彩或多層次色彩的產品。祇需在固定模板上疊裝一件由電腦控制的混色器，在裝模時，再與模具連接，便可具備混色注塑的功能。從電腦設置指令控制每組注射系統的注射次序、次數、膠量、溫度、壓力等、再經過預先電腦輸入混色程序的混色器注射入模腔內。由于混色器與模具水口極近，在注射混合過程容易獲得預期的效果。使用本功能時無須轉盤旋轉，祇須在電腦屏幕上設置“轉盤使用方式”為“使用混色”，再配備可調混合程式的混色器即可。

## Two Colour Mixing Device

*By incorporating two injection units together with a colour mixing device into a plastic injection moulding machine, plastic products with two colours can be mixed in a single injection process. In this design, two injection units are connected to the device with a common nozzle. The injection parameters such as sequence, quantity, volume, temperature and pressure of each colour are controlled. As the distance between the colour mixer device and mould entrance is small, the colour mixing effect is predictable.*

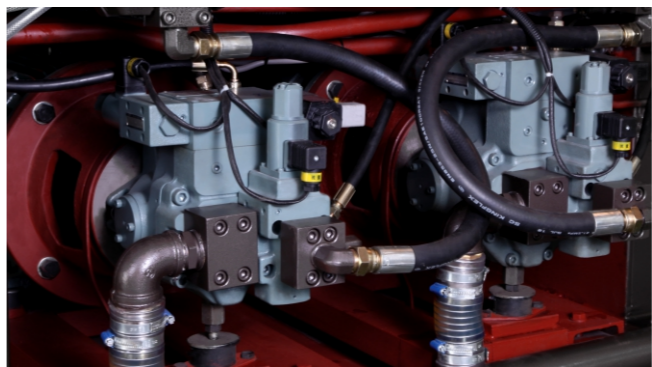
*No rotation movement is involved in this colour mixing mechanism. Users can select this mode directly on the LCD screen and input the required parameters. The "MM Series Multi-mould Master" Plastics Injections Moulding Machine is the result of the combination of manufacturing techniques and experiences. It comprises a computer-optimized modular structural design, closed loop control servo motor drive and high responsive energy saving pump. Users can satisfy different needs of multi-material injection moulding craft, such as coating with turntable positioning system, over moulding with core rotation system, marble effect moulding with colour mixer and simultaneous moulding with two moulds. The MM Series is a multi-craft machine.*

## 一、動力系統

- 1、帶比例壓力及比例流量的變量泵搭配注塑機專用的低噪音電馬達組成的動力系統為本機提供了準確、快捷、高壓、高節能及低噪音的動力。
- 2、模塊式設計的注射系統提供相適應功率的多組動力源。
- 3、多組獨立油路分別控制每一組注射系統及兩組頂出機構，為多種工藝的實現奠定了基礎

### Drive System

1. The machine is equipped with a highly accurate, responsive, dynamic, energy saving, and low-noise drive system as a result of the collocation of proportional variable displacement pump and low noise electric motor.
2. The design of modular injection system provides the source of multi-adaptive power drive.
3. Independent hydraulic circuit for the control of individual injection and ejection units establishes the foundation of multi-mould technology.



## 二、開合模系統

- 1、採用了電腦優化設計的五點式垂直機紋及箱式結構的模板，與高拉力合金鋼哥林柱組成高強度、高剛性、活動穩定快捷兼容的鎖模機構。
- 2、特別寬闊的模板方便安裝多工位模具。
- 3、活動模板裝在特別設計的滑行機構，確保在負載重型模具仍能穩定地滑。
- 4、兩工位雙向180度及特大直徑的裝模轉盤已預留裝大模的空間，由優質進口開環控制伺服馬達驅動實現了快捷輕盈的轉動，合模達到準確定位的效果。
- 5、配置獨立的電器，液壓及機械三級安全門設計，為安全合模操作提供了保障。
- 6、轉盤上提供兩組冷却水源接頭，可直接供冷却模具用。
- 7、兩套獨立的頂針和一套智慧型的轉盤定位機構為選擇不同工藝時搭配使用，既可防止錯誤動作亦可休護模具。
- 8、提供自動調模功能可縮短裝模高置時間。

## Mould System

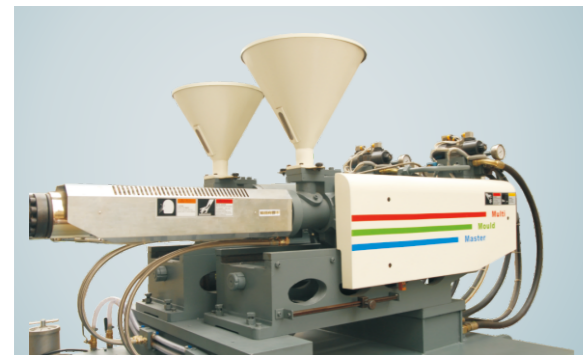
1. Five-point vertical toggles, box platens, chrome-plated high tensile tie-bars through CAD and CAE finite element analysis ensure strong, rigid, steady and efficient clamping.
2. Broad platen dimensions increase the ease for multi-station mould installation.
3. Movable platen is seated on the specially designed sliders which gives stable movement of heavy mould.
4. Large diameter turntable allows more room for the multi work station moulds. The use of high quality servo-control motor ensures smooth rotary motion and precise positioning.
5. The three independent electrical, hydraulic and mechanical safety devices guarantee safe operation.
6. Two sets of cooling water supply are provided directly on the turntable for mould cooling.
7. The function of two independent ejection systems and turntable positioning lock mechanism accomplishes different craft processes. Proper sequence of operations is ensured in order to protect the mould from being damaged.
8. Automated mould thickness adjustment shortens the mould set-up time.

### 三、注射系統

- 1、模塊式設計的注射系統可按工藝要求搭配兩組或以上的射膠模塊，本系列亦有多款的射膠模塊供選擇。
- 2、注射機構採用單油缸設計，較傳統的雙油缸更穩定且控制更準確。
- 3、每組注射系統的熔膠背壓數據，在電腦屏幕上直接輸入，亦配有背壓表顯示實際的熔膠背壓值，為精密注塑提供必要的條件。

### Injection System

1. Two or more modular injection units with various specifications can be selected to execute the multi-mould operation according to craft requirements.
2. The design of single injection cylinder provides a more stable and precise performance than the commonly used double injection cylinder.
3. The plasticizing pressure settings for each injection unit can be individually set on LCD monitor and the readings are displayed by pressure gauges.



### 四、控制系統配置了 T88專業型電腦

- 1、該系統提供126套數據記憶及顯示操作參數，且具備錯誤操作提示功能。
- 2、超大的26厘米LCD彩色屏幕顯示，清晰顯示參數及方便輸入數據。
- 3、可直接在電腦鍵盤上輸入壓力、速度、位置、時間及熔膠溫度等參數。每組注射機構可預設六段射膠壓力，射膠速度和射膠位置、四段保壓壓力的時間、三段螺旋對應軸向位置轉動的壓力及轉速、六段預高熔膠溫度等。
- 4、開合模行程、射膠行程及頂出行程均採用高精度電子尺以準確地測量及顯示行程位置。
- 5、該系統具有射膠量檢測功能及螺杆防冷啓動裝置，方便工藝管理及保護螺杆。
- 6、本系統採用PID溫度控制配合半導體繼電器，可準確控制溫度及減少接觸點損耗從而延長電器件工作壽命。
- 7、該系統已內置了蓄能器、兩組獨立抽芯、兩組專賣店膠針、螺旋脫牙、吹風、轉盤、轉芯、混色及機械臂驅動程式
- 8、注塑參數、射膠量、熔膠溫度、生產統計圖表等均可于屏幕顯示及儲存。

### T88 Professional Micro-computer equipped Control System

1. The system allows memory storage of 126 moulding data sets and shows all operation parameters. It also gives warning messages in case of malfunction.
2. 26cm LCD color monitor for displaying parameters and inputting figures.
3. Direct input of pressure, speed, position, time, plasticizing temperature settings. Each injection unit can operate at 6-stage setting of injection pressure, speed and position; 4-stage setting of injection holding pressure and time; 3-stage setting of screw axis rotational pressure and speed; and 6-stage barrel temperature setting.
4. The mould, injection and ejection operations are monitored by potentiometers for accurate measure of transition.
5. The system has injection cushion detection and screw cold-start prevention for quality control management and screw protection.
6. Built-in PID temperature control program and semiconductor relays in heater circuit give high accuracy of moulding temperature and durability of contact points.
7. Built-in operation program for accumulator device, two independent core operations, two independent anti-drooling devices, unscrewing function, air ejection, rotary table, core ejecting rotating shaft, colour mixing and product transfer mechanism.
8. Injection parameters such as shot volume, plasticizing temperature, production statistics, etc. can be displayed and stored.



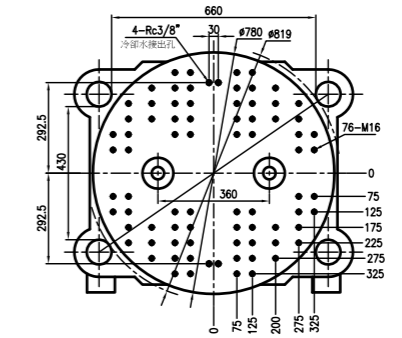
### 五、超强的特别功能

在多物料注塑的工藝裏，大概分轉盤式、轉軸式、共射式、混合式等等，每一種工藝都需要專用的注塑機來實現。而MM系列全自動注塑機在一機基礎上添加相關構件之後，便可以實現上棕的三種功能，特別適用於一些不時轉換多物料注塑工藝的情況，例如注塑包膠類，穿透注射類或雲彩效果類的工藝，省去再多購其他機種的費用，實現一機多能！

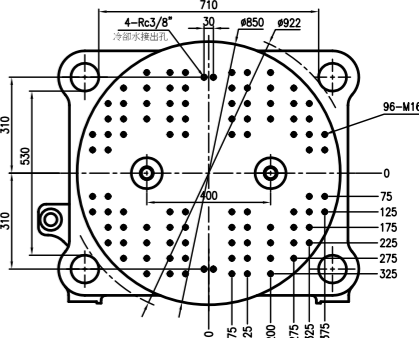
### Special Features (Multi Features in One Machine)

Multi-Mould Function can be achieved by using rotary table, ejected and rotated core shaft and colour mixing. Each of these features is manufactured by specialize plastic injection moulding machines. With one MM Series machine and the installation of necessary auxiliary devices, one can produce a multi-material product with any one of the three features mentioned above. This is particularly efficient in cases when multi materials are used. The MM Series can save the cost to purchase different injection moulding machines. It accomplishes 'Multi Features in One Machine'!

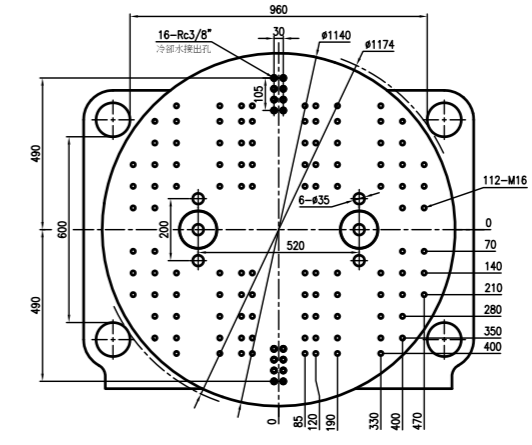
MM130 模板尺寸 (MM130 Platen Size)



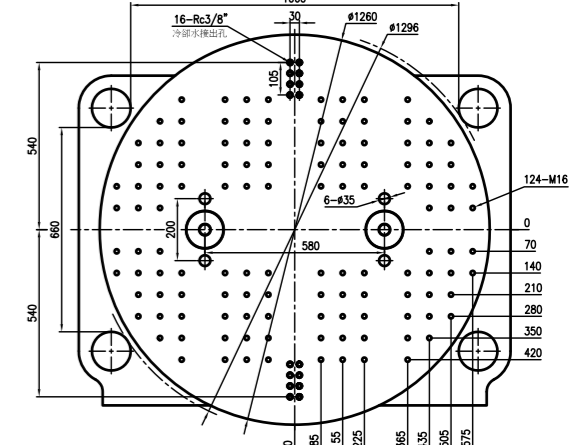
MM200 模板尺寸 (MM200 Platen Size)



MM300 模板尺寸 (MM300 Platen Size)



MM400 模板尺寸 (MM400 Platen Size)



MM 雙色成型注塑機系列規格表

項目	單位	MM130						MM200						MM300						MM400					
		五點式機鉸						五點式機鉸						五點式機鉸						五點式機鉸					
鎖模系統類別		五點式機鉸						五點式機鉸						五點式機鉸						五點式機鉸					
射臺型號		ST330		ST330				ST470		ST330				ST920		ST470				ST1200		ST640			
鎖模力	Tons	130						200						300						400					
模板最大開距	mm	950						1230						1360						1570					
鎖模行程	mm	440						530						600						720					
容模厚度	mm	250-510						300-700						300-760						350-850					
四柱內距	mm	660x430						710x530						960x600						1060x660					
定位孔直徑	mm	Φ100H8x2						Φ120H8x2						Φ120H8x2						Φ120H8x2					
轉盤直徑	mm	Φ780						Φ850						Φ1140						Φ1260					
頂針數量	pcs	1+1						1+1						3+3						3+3					
頂針推力	ton	3.3						3.3						4.8						6.5					
頂針行程	mm	120						120						140						160					
螺絲編號		A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C
螺絲直徑	mm	32	36	40	32	36	40	36	40	45	32	36	40	45	50	55	36	40	45	50	55	60	40	45	50
注射量(硬膠)	g	108	137	169	108	137	169	154	190	241	108	137	169	301	372	450	154	190	241	413	500	595	211	268	330
	oz	3.8	4.8	6.0	3.8	4.8	6.0	5.4	6.7	8.5	3.8	4.8	6.0	10.6	13.1	15.9	5.4	6.7	8.5	14.6	17.7	21.0	7.5	9.5	11.7
注射容積	cc	129	163	201	129	163	201	183	226	286	129	163	201	358	442	535	183	226	286	491	594	707	251	318	393
注射行程	mm	160	160	160	160	160	160	180	180	180	160	160	160	225	225	225	180	180	180	250	250	250	200	200	200
注射壓力	kg/cm <sup>2</sup>	2594	2050	1660	2594	2050	1660	2571	2083	1645	2594	2050	1660	2571	2083	1721	2571	2083	1645	2455	2029	1705	2553	2017	1634
射出率	cc / sec	65	82	101	65	82	101	81	100	127	65	82	101	130	161	195	81	100	127	152	184	218	102	129	160
塑化能力(PS)	kg/h	35	49	64	35	49	64	61	80	109	35	49	64	85	109	142	46	60	83	95	124	158	64	87	111
螺絲轉速	r.p.m	208	208	208	208	208	208	259	259	259	208	208	208	202	202	202	197	197	197	177	177	177	207	207	207
射咀接觸力	Tons	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	5.4	5.4	5.4	4.0	4.0	4.0	6.9	6.9	6.9	5.4	5.4	5.4
油泵電機功率	kW	11			11			15			11			22			15			22			15		
電熱功率	kW	6.55			6.55			8.25			6.55			13.00			8.25			15.60			10.40		
系統壓力	kg/cm <sup>2</sup>	170						170						170						170					
油箱容積	L	360						430						630						750					
機器重量	Tons	7.5						10.0						14						20					
外形尺寸(LxWxH)	mxxm	5.6x1.4x1.84						5.91x1.63x2.01						7.48x1.62x2.15						8.76x2.0x2.25					

◆ 本公司可隨時修改以上規格而無須預先通知。

MM Multi-Mould Master Plastics Injection Moulding Machine Specification

Item	Unit	MM130						MM200						MM300						MM400					
		Toggle Type						Toggle Type						Toggle Type						Toggle Type					
Clamping Type		Toggle Type						Toggle Type						Toggle Type						Toggle Type					
Injection Model		ST330		ST330				ST470		ST330				ST920		ST470				ST1200		ST640			
Clamping Force	Tons	130						200						300						400					
Max Daylight Opening	mm	950						1230						1360						1570					
Opening Stroke	mm	440						530						600						720					
Mould Height(Min-Max)	mm	250-510						300-700						300-760						350-850					
Space BetweenTie-bars	mm	660x430						710x530						960x600						1060x660					
Mould Locator Diameter	mm	Φ100H8x2						Φ120H8x2						Φ120H8x2						Φ120H8x2					
Rotary Table Diameter	mm	Φ780						Φ850						Φ1140						Φ1260					
Number of Ejectors	pcs	1+1						1+1						3+3						3+3					
Ejector Force	ton	3.3						3.3						4.8						6.5					
Ejector Stroke	mm	120						120						140						160					
Injection Unit Model		A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C
Screw Diameter	mm	32	36	40	32	36	40	36	40	45	32	36	40	45	50	55	36	40	45	50	55	60	40	45	50
Shot Weight(PS)	g	108	137	169	108	137	169	154	190	241	108	137	169	301	372	450	154	190	241	413	500	595	211	268	330
	oz	3.8	4.8	6.0	3.8	4.8	6.0	5.4	6.7	8.5	3.8	4.8	6.0	10.6	13.1	15.9	5.4	6.7	8.5	14.6	17.7	21.0	7.5	9.5	11.7
Shot Volume	cc	129	163	201	129	163	201	183	226	286	129	163	201	358	442	535	183	226	286	491	594	707	251	318	393
Screw Stroke	mm	160	160	160	160	160	160	180	180	180	160	160	160	225	225	225	180	180	180	250	250	250	200	200	200
Injection Pressure	kg/cm <sup>2</sup>	2594	2050	1660	2594	2050	1660	2571	2083	1645	2594	2050	1660	2571	2083	1721	2571	2083	1645	2455	2029	1705	2553	2017	1634
Injection Rate	cc / sec	65	82	101	65	82	101	81	100	127	65	82	101	130	161	195	81	100	127	152	184	218	102	129	160
Plasticizing Capacity	kg/h	35	49	64	35	49	64	61	80	109	35	49	64	85	109	142	46	60	83	95	124	158	64	87	111
Screw Speed	r.p.m	208	208	208	208	208	208	259	259	259	208	208	208	202	202	202	197	197	197	177	177	177	207	207	207
Nozzle Contact Force	Tons	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	5.4	5.4	5.4	4.0	4.0	4.0	6.9	6.9	6.9	5.4	5.4	5.4
Electric Motor Power	kW	11			11			15			11			22			15			22			15		
Heating Power	kW	6.55			6.55			8.25			6.55			13.00			8.25			15.60			10.40		
System Pressure	kg/cm <sup>2</sup>	170						170						170						170					
Oil Tank Capacity	L	360						430						630						750					
Machine Weight	Tons	7.5						10.0						14						20					
Machine Dimension(LxWxH)	mxxm	5.6x1.4x1.84						5.91x1.63x2.01						7.48x1.62x2.15						8.76x2.0x2.25					

◆ The above specifications can be altered without prior notice.

MM 雙色成型注塑機系列規格表 (EcoPow伺服系統)

項目	單位	MM130						MM200						MM300						MM400												
		五點式機鉸						五點式機鉸						五點式機鉸						五點式機鉸												
鎖模系統類別		五點式機鉸						五點式機鉸						五點式機鉸						五點式機鉸												
射臺型號		ST330		ST330				ST470		ST330				ST920		ST470				ST1200		ST640										
鎖模力	Tons	130						200						300						400												
模板最大開距	mm	950						1230						1360						1570												
鎖模行程	mm	440						530						600						720												
容模厚度	mm	250-510						300-700						300-760						350-850												
四柱內距	mm	660x430						710x530						960x600						1060x660												
定位孔直徑	mm	Φ 100H8x2						Φ 120H8x2						Φ 120H8x2						Φ 120H8x2												
轉盤直徑	mm	Φ 780						Φ 850						Φ 1140						Φ 1260												
頂針數量	pcs	1+1						1+1						3+3						3+3												
頂針推力	ton	3.3						3.3						4.8						6.5												
頂針行程	mm	120						120						140						160												
螺桿編號		A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	
螺桿直徑	mm	32	36	40	32	36	40	36	40	45	32	36	40	45	50	55	36	40	45	50	55	60	40	45	50	55	60	60	40	45	50	
注射量(硬膠)	g	108	137	169	108	137	169	154	190	241	108	137	169	301	372	450	154	190	241	413	500	595	211	268	330	413	500	595	211	268	330	
	oz	3.8	4.8	6.0	3.8	4.8	6.0	5.4	6.7	8.5	3.8	4.8	6.0	10.6	13.1	15.9	5.4	6.7	8.5	14.6	17.7	21.0	7.5	9.5	11.7	14.6	17.7	21.0	7.5	9.5	11.7	
注射容積	cc	129	163	201	129	163	201	183	226	286	129	163	201	358	442	535	183	226	286	491	594	707	251	318	393	491	594	707	251	318	393	
注射行程	mm	160	160	160	160	160	160	180	180	180	160	160	160	225	225	225	180	180	180	250	250	250	200	200	200	250	250	250	200	200	200	
注射壓力	kg/cm <sup>2</sup>	2594	2050	1660	2594	2050	1660	2571	2083	1645	2594	2050	1660	2571	2083	1721	2571	2083	1645	2455	2029	1705	2553	2017	1634	1645	2455	2029	1705	2553	2017	1634
射出率	cc / sec	63	80	99	63	80	99	87	108	137	63	80	99	145	179	216	87	108	137	152	184	218	108	137	169	152	184	218	108	137	169	
塑化能力(PS)	kg/h	34	48	63	34	48	63	66	86	118	34	48	63	95	121	158	50	65	89	95	124	158	67	92	118	95	124	158	67	92	118	
螺桿轉速	r.p.m	204	204	204	204	204	204	279	279	279	204	204	204	225	225	225	212	212	212	177	177	177	219	219	219	177	177	177	219	219	219	
射咀接觸力	Tons	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	5.4	5.4	5.4	4.0	4.0	4.0	6.9	6.9	6.9	5.4	5.4	5.4	6.9	6.9	6.9	5.4	5.4	5.4	
油泵電機功率	kW	12			12			14			12			23			14			23			18									
電熱功率	kW	6.55			6.55			8.25			6.55			13.00			8.25			15.60			10.40									
系統壓力	kg/cm <sup>2</sup>	170						170						170						170												
油箱容積	L	360						430						630						750												
機器重量	Tons	7.5						10.0						14						20												
外形尺寸(LxWxH)	mxmxm	5.6x1.4x1.84						5.91x1.63x2.01						7.48x1.62x2.15						8.76x2.0x2.25												

◆ 本公司可隨時修改以上規格而無須預先通知。

MM Multi-Mould Master Plastics Injection Moulding Machine Specification (EcoPow Servo System)

Item	Unit	MM130						MM200						MM300						MM400												
		Toggle Type						Toggle Type						Toggle Type						Toggle Type												
Clamping Type		Toggle Type						Toggle Type						Toggle Type						Toggle Type												
Injection Model		ST330		ST330				ST470		ST330				ST920		ST470				ST1200		ST640										
Clamping Force	Tons	130						200						300						400												
Max Daylight Opening	mm	950						1230						1360						1570												
Opening Stroke	mm	440						530						600						720												
Mould Height(Min-Max)	mm	250-510						300-700						300-760						350-850												
Space BetweenTie-bars	mm	660x430						710x530						960x600						1060x660												
Mould Locator Diameter	mm	Φ 100H8x2						Φ 120H8x2						Φ 120H8x2						Φ 120H8x2												
Rotary Table Diameter	mm	Φ 780						Φ 850						Φ 1140						Φ 1260												
Number of Ejectors	pcs	1+1						1+1						3+3						3+3												
Ejector Force	ton	3.3						3.3						4.8						6.5												
Ejector Stroke	mm	120						120						140						160												
Injection Unit Model		A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	
Screw Diameter	mm	32	36	40	32	36	40	36	40	45	32	36	40	45	50	55	36	40	45	50	55	60	40	45	50	55	60	60	40	45	50	
Shot Weight(PS)	g	108	137	169	108	137	169	154	190	241	108	137	169	301	372	450	154	190	241	413	500	595	211	268	330	413	500	595	211	268	330	
	oz	3.8	4.8	6.0	3.8	4.8	6.0	5.4	6.7	8.5	3.8	4.8	6.0	10.6	13.1	15.9	5.4	6.7	8.5	14.6	17.7	21.0	7.5	9.5	11.7	14.6	17.7	21.0	7.5	9.5	11.7	
Shot Volume	cc	129	163	201	129	163	201	183	226	286	129	163	201	358	442	535	183	226	286	491	594	707	251	318	393	491	594	707	251	318	393	
Screw Stroke	mm	160	160	160	160	160	160	180	180	180	160	160	160	225	225	225	180	180	180	250	250	250	200	200	200	250	250	250	200	200	200	
Injection Pressure	kg/cm <sup>2</sup>	2594	2050	1660	2594	2050	1660	2571	2083	1645	2594	2050	1660	2571	2083	1721	2571	2083	1645	2455	2029	1705	2553	2017	1634	1645	2455	2029	1705	2553	2017	1634
Injection Rate	cc / sec	63	80	99	63	80	99	87	108	137	63	80	99	145	179	216	87	108	137	152	184	218	108	137	169	152	184	218	108	137	169	
Plasticizing Capacity	kg/h	34	48	63	34	48	63	66	86	118	34	48	63	95	121	158	50	65	89	95	124	158	67	92	118	95	124	158	67	92	118	
Screw Speed	r.p.m	204	204	204	204	204	204	279	279	279	204	204	204	225	225	225	212	212	212	177	177	177	219	219	219	177	177	177	219	219	219	
Nozzle Contact Force	Tons	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	5.4	5.4	5.4	4.0	4.0	4.0	6.9	6.9	6.9	5.4	5.4	5.4	6.9	6.9	6.9	5.4	5.4	5.4	
Electric Motor Power	kW	12			12			14			12			23			14			23			18									
Heating Power	kW	6.55			6.55			8.25			6.55			13.00			8.25			15.60			10.40									
System Pressure	kg/cm <sup>2</sup>	170						170						170						170												
Oil Tank Capacity	L	360						430						630						750												
Machine Weight	Tons	7.5						10.0						14						20												
Machine Dimension(LxWxH)	mxmxm	5.6x1.4x1.84						5.91x1.63x2.01						7.48x1.62x2.15						8.76x2.0x2.25												

◆ The above specifications can be altered without prior notice.