**CHINA·HWAMDA**

*THE CRAFTSMANSHIP OF THE WORLD*

中国的华美达,世界的工匠心


**宁波华美达集团有限公司**

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# 多物料注塑机系列

MULTI MATERIAL INJECTION MOLDING MACHINE SERIES

## DP转盘式清双色注塑机

TURNTABLE TWIN-COLOR INJECTION MOLDING MACHINE

## DM混色专用注塑机

SPECIAL MIXED COLOR INJECTION MOLDING MACHINE

2024年4月修订


**宁波华美达集团有限公司**

NINGBO HWAMDA GROUP CO., LTD.

宁波华美达机械制造有限公司地处“中国塑机之都”的浙江省宁波市，是一家专业化生产塑料注射成型机械的高新技术企业，经过不断的技术创新，公司自主研发的系列产品已广泛应用于汽车、电子、医疗、环保、物流、包装等众多注塑生产行业，目前，华美达已经成长为具有雄厚规模实力和创新竞争力的中国注塑机行业前列企业。2021年，成立宁波华美达集团有限公司，以集团化经营服务全球客户。

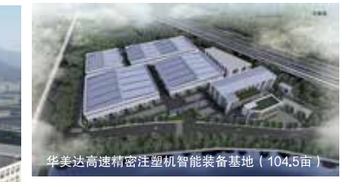
华美达公司现有五大生产制造基地，超过二十万平方米厂房设施，引进各种大型先进精密加工设备，团结了一支高素质的企业管理与技术创新团队。公司一直致力于高效节能型注塑机的开发制造与市场推广，已成功推出有精密伺服注塑机、二板注塑机、全电动注塑机、高速精密注塑机、高性能注塑机、清混多色注塑机、PET专用快速注胚系统等多个系列以及各种行业专用型产品。

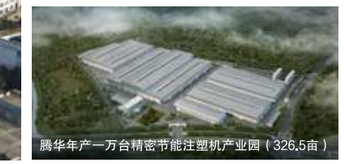
为贴近客户，公司大力开拓国际市场，在国内外建立60余处完善的销售机构及海外服务中心，华美达注塑机受到了北美、中东、南美、东南亚、欧洲及非洲等各个国家和地区客户的使用和欢迎，建立了面向国际市场的营销体系。

公司通过ISO9001、ISO14001、OHSAS18001管理体系认证以及CE、EAC、KCS和“一带一路”等国际认证，所生产的各系列注塑机均配备世界知名品牌的液压、电器及控制系统，引进国际领先设计理念，通过严格的检验、加工、装配、调试，为客户提供优质的产品与服务。

一流的品质，是华美达执着追求的重要目标。尽力满足顾客需求，以精益求精、开拓进取的企业精神缔造辉煌的未来，公司始终坚持“专心专注，做好塑机”的企业理念，为中国注塑机械产业的发展和提高做出自己的贡献。

# 关于华美达
# About US


华美达高速精密注塑机智能装备基地（104.5亩）


腾华年产一万台精密节能注塑机产业园（326.5亩）

Ningbo Hwamda Machinery Manufacturing Co., Ltd. is a new and high technology enterprise devoted to manufacture plastic injection machine, lying in the "City of China plastic molding machine" - Ningbo, Zhejiang.

Now, Hwamda Company owns five factories with more than two hundred thousand square meters. There are over 500 workers and staff members, holding together a high-quality team of managers and technical team. Our company always devoted to R&D for high efficiency and energy-saving injection molding machine. At present, our main products including servo motor energy saving machines, two platen machines, full electric machines, high speed machine for thin-wall products, twin-color machines, special high speed machine for PET preform and other standard or special injection molding machines.
Following the idea of serving customers, we have established more than 60 perfect sales & service branch in China and abroad. Hwamda machine has sold to many countries such as Russia, Poland, Mexico, India, Sri Lanka, Egypt, Brazil, Peru, Colombia, etc. Hwamda has gradually set up a marketing system covering both the domestic and overseas markets.

Hwamda has passed the ISO9001, ISO14001, OHSAS18001 and CE, EAC, KCS certification. All the series of injection machine are equipped with world famous hydraulic & electric elements and control system. Through strict inspection, assembly and test, Hwamda has provided first-class products and services to customers.

"First-class quality" is what we are pursuing the most. We will try our best to meet the requirements of customers and create even better future. Our company firmly sticks to the idea of "With undivided attention to manufacture excellent plastic injection molding machines", and makes our own contribution for the development and improvement of national plastic industry.

# DP

## 转盘式清双色注塑机

TURNTABLE TWIN-COLOR INJECTION MOLDING MACHINE

- 伺服电机控制转盘，高效节能，精确稳定。
  Turntable control by servo motor.

- 单缸注射机构，搭配线性导轨支座设计，更适应高速生产要求。
  Injection unit with single cylinder structure and guide linear.

- 射台机架部分预留前后位置，方便安装小射台或短螺杆。
  Injection unit frame with space can install small unit or short screw.

- 模块化设计，方便不同规格注射机构大小射台互换。
  Modular design, injection unit can exchange.

- 双色机专用高性能电脑控制器，精度高、响应快。
  Optimized control system excellent in response and accuration.

- 射出部分设有两组独立料管组，同步做射出动作，双色一次成型，大幅缩短制品成型周期。

  Injection unit with double separate set of barrel, injection on fly, double color with one shot products, to reduce the cycle time.

- 采用单缸注射机构，注射精度更高。

  Single cylinder of injection structure, more precise for injection.

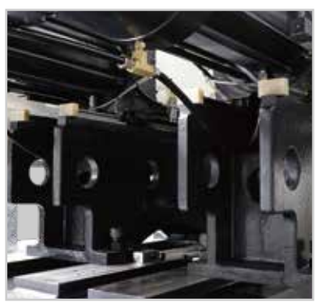
# 注射单元
## INJECTION UNIT

- 整体射台支撑结构配合精密的双线性导轨设计，确保精确、快速的注射启动速度。

  Whole set supporter of injection unit with double precise linear guard, precise and fast speed starter.

- 预留大小射台通配位置，适用于多种双色产品成型要求。

  Injection unit can be with different size, adapt with different double color products.



- 料管采用PID温度控制，误差极低。

  Barrel with PID temperature control.

# 液压单元
## HYDRAULIC UNIT

- 液压换向阀、高压软管等关键配件选取著名品牌，油路运行稳定可靠。

  Hydraulic circuits adopt top brands valve and hose.

- 采用DIN标准锥面带密封圈接头，阀板采用G螺纹密封堵头，以杜绝油质污染。

  Equipped with DIN standard cone with sealing ring joint, manifold with G thread sealing gland.

- 自封式磁性吸油过滤器，油路维护更方便。

  Self-sealing magnetic oil filter convenient to maintenance

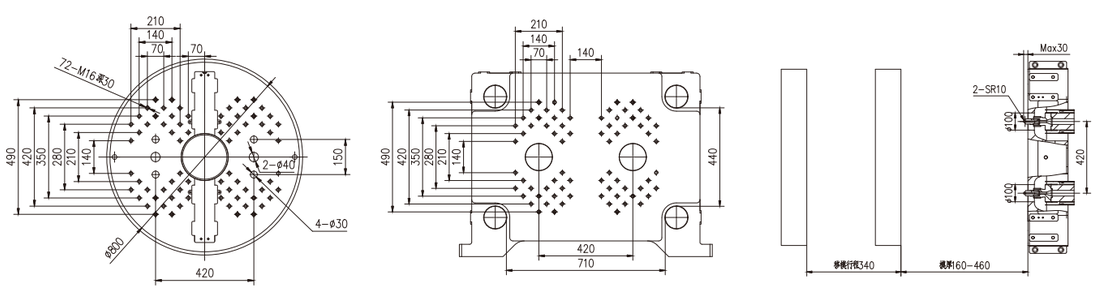
# 电控单元
## CONTROL SYSTEM

选用高性能KEBA双色机专用电脑控制器，大规格彩色显示屏，精度更高。标配三色报警灯带蜂鸣器，机器运行状态一目了然。

Equipped with high-performance KEBA controller, large LCD display and man-machine friendly interface.Equipped with three light alarm with buzzer.

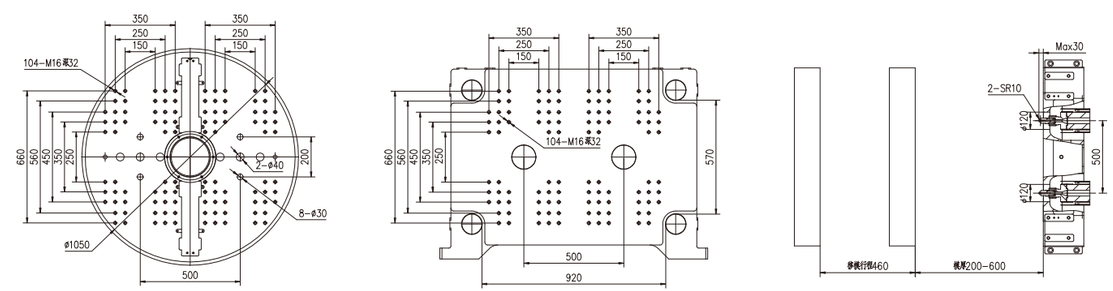
# 清双色技术参数表 *SPECIFICATIONS*

| 参数 | PARAMETER | UNIT | HMD DP160 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 300 | | 300 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 93 | 108 | 124 | 141 |
| 注射重量 | Injection weight (PS) | g (克) | 85 | 98 | 113 | 128 |
| | | oz (盎司) | 3.0 | 3.5 | 4.0 | 4.5 |
| 注射速率 | Injection rate (PS) | g/s | 55 | 63 | 73 | 83 |
| 螺杆直径 | Screw diameter | mm | 26 | 28 | 30 | 32 |
| 注射压力 | Injection pressure | MPa | 342 | 295 | 257 | 226 |
| 螺杆长径比 | Screw L/D ratio | —— | 23 | 21.4 | 22.6 | 21.2 |
| 螺杆行程 | Screw stroke | mm | 175 | 175 | 175 | 175 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 244 | | | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 1600 | | | |
| 移模行程 | Mold opening stroke | mm | 340 | | | |
| 模板尺寸 | Platen size | mm | 960 x 680 | | | |
| 转盘直径 | Rotary table diameter | mm | 800 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 710 x 440 | | | |
| 模板最大距离 | Max.daylight | mm | 800 | | | |
| 容模量 (最小—最大) | Mold thickness(Min–Max) | mm | 160–460 | | | |
| 顶出行程 | Ejector stroke | mm | 140 | | | |
| 顶出力 | Ejector tonnage | kN | 38 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 420 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 18.7 | | 18.7 | |
| 电热功率 | Heater power | kW | 6.8 | | 6.8 | |
| 温度控制区数 | Number of temp control zones | —— | 4 x 2 | | | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L(升) | 330 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 5.2 x 1.76 x 2.1 | | | |
| 机器重量 | Machine weight | Ton | 7.1 | | | |




# 清双色技术参数表 *SPECIFICATIONS*

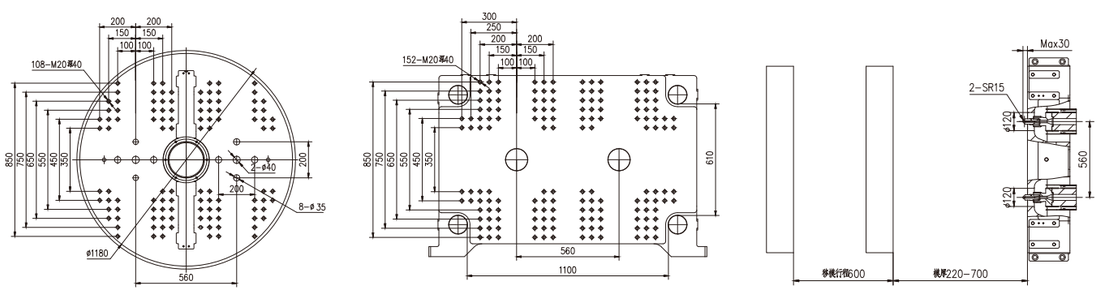
| 参数 | PARAMETER | UNIT | HMD DP270 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 300 | | 600 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 141 | 178 | 283 | 358 |
| 注射重量 | Injection weight (PS) | g (克) | 128 | 162 | 257 | 326 |
| | | oz (盎司) | 4.5 | 5.7 | 9.1 | 11.5 |
| 注射速率 | Injection rate (PS) | g/s | 83 | 105 | 109 | 138 |
| 螺杆直径 | Screw diameter | mm | 32 | 36 | 40 | 45 |
| 注射压力 | Injection pressure | MPa | 226 | 179 | 214 | 169 |
| 螺杆长径比 | Screw L/D ratio | —— | 21.2 | 18.8 | 21.4 | 20.9 |
| 螺杆行程 | Screw stroke | mm | 175 | 175 | 225 | 225 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 244 | | 0 ~ 195 | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 2700 | | | |
| 移模行程 | Mold opening stroke | mm | 460 | | | |
| 模板尺寸 | Platen size | mm | 1240 x 880 | | | |
| 转盘直径 | Rotary table diameter | mm | 1050 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 920 x 570 | | | |
| 模板最大距离 | Max.daylight | mm | 1060 | | | |
| 容模量 (最小—最大) | Mold thickness(Min–Max) | mm | 200–600 | | | |
| 顶出行程 | Ejector stroke | mm | 140 | | | |
| 顶出力 | Ejector tonnage | kN | 45 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 500 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 18.7 | | 18.7 | |
| 电热功率 | Heater power | kW | 6.8 | | 11.2 | |
| 温度控制区数 | Number of temp control zones | —— | 4 x 2 | | | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L ( 升 ) | 400 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 6.0 x 2.05 x 2.3 | | | |
| 机器重量 | Machine weight | Ton | 11 | | | |




说明：由于产品改进，技术参数的变更，恕不另行通知。
Remark:We reserve the right to make any technical improvement without prior notice.

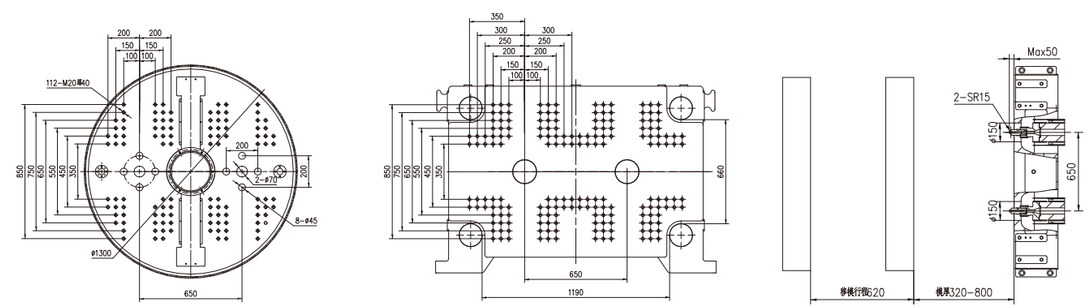
# 清双色技术参数表 *SPECIFICATIONS*

| 参数 | PARAMETER | UNIT | HMD DP410 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 900 | | 900 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 398 | 491 | 398 | 491 |
| 注射重量 | Injection weight (PS) | g (克) | 362 | 447 | 362 | 447 |
| | | oz (盎司) | 12.8 | 15.8 | 12.8 | 15.8 |
| 注射速率 | Injection rate (PS) | g/s | 147 | 182 | 147 | 182 |
| 螺杆直径 | Screw diameter | mm | 45 | 50 | 45 | 50 |
| 注射压力 | Injection pressure | MPa | 250 | 202 | 250 | 202 |
| 螺杆长径比 | Screw L/D ratio | —— | 23.2 | 20.9 | 23.2 | 20.9 |
| 螺杆行程 | Screw stroke | mm | 250 | 250 | 250 | 250 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 231 | | | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 4100 | | | |
| 移模行程 | Mold opening stroke | mm | 600 | | | |
| 模板尺寸 | Platen size | mm | 1480 x 980 | | | |
| 转盘直径 | Rotary table diameter | mm | 1180 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 1100 x 610 | | | |
| 模板最大距离 | Max.daylight | mm | 1300 | | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 220-700 | | | |
| 顶出行程 | Ejector stroke | mm | 140 | | | |
| 顶出力 | Ejector tonnage | kN | 70 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 560 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 31.3 | | 31.3 | |
| 电热功率 | Heater power | kW | 14.3 | | 14.3 | |
| 温度控制区数 | Number of temp control zones | —— | 5 x 2 | | | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L(升) | 650 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 6.8 x 2.2 x 2.3 | | | |
| 机器重量 | Machine weight | Ton | 20.5 | | | |




# 清双色技术参数表 *SPECIFICATIONS*

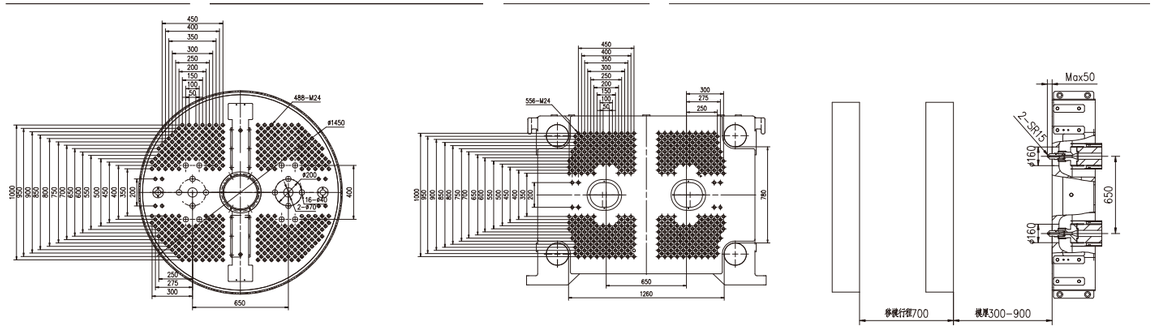
| 参数 | PARAMETER | UNIT | HMD DP550 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 900 | | 1400 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 398 | 491 | 677 | 806 |
| 注射重量 | Injection weight (PS) | g (克) | 362 | 447 | 616 | 733 |
| | | oz (盎司) | 12.8 | 15.8 | 21.7 | 25.9 |
| 注射速率 | Injection rate (PS) | g/s | 147 | 182 | 224 | 266 |
| 螺杆直径 | Screw diameter | mm | 45 | 50 | 55 | 60 |
| 注射压力 | Injection pressure | MPa | 250 | 202 | 209 | 175 |
| 螺杆长径比 | Screw L/D ratio | —— | 23.2 | 20.9 | 21.4 | 19.7 |
| 螺杆行程 | Screw stroke | mm | 250 | 250 | 285 | 285 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 231 | | 0 ~ 220 | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 5500 | | | |
| 移模行程 | Mold opening stroke | mm | 620 | | | |
| 模板尺寸 | Platen size | mm | 1610 x 1080 | | | |
| 转盘直径 | Rotary table diameter | mm | 1300 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 1190 x 660 | | | |
| 模板最大距离 | Max.daylight | mm | 1420 | | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 320-800 | | | |
| 顶出行程 | Ejector stroke | mm | 250 | | | |
| 顶出力 | Ejector tonnage | kN | 110 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 650 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 31.3 | | 36.5 | |
| 电热功率 | Heater power | kW | 14.3 | | 18.2 | |
| 温度控制区数 | Number of temp control zones | —— | 5 | | 6 | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L ( 升 ) | 705 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 8.1 x 2.6 x 2.3 | | | |
| 机器重量 | Machine weight | Ton | 30 | | | |




说明：由于产品改进，技术参数的变更，恕不另行通知。
Remark:We reserve the right to make any technical improvement without prior notice.

# 清双色技术参数表 *SPECIFICATIONS*

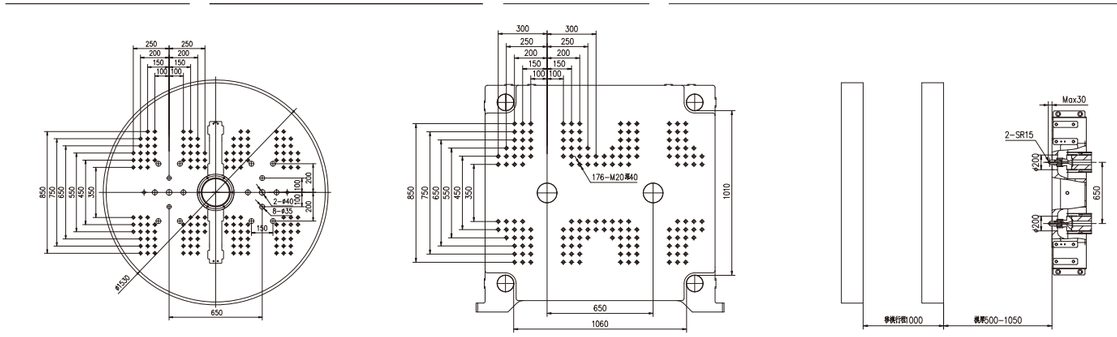
| 参数 | PARAMETER | UNIT | HMD DP800 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 900 | | 1400 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 398 | 491 | 677 | 806 |
| 注射重量 | Injection weight (PS) | g (克) | 362 | 447 | 616 | 733 |
| | | oz (盎司) | 12.8 | 15.8 | 21.7 | 25.9 |
| 注射速率 | Injection rate (PS) | g/s | 147 | 182 | 280 | 333 |
| 螺杆直径 | Screw diameter | mm | 45 | 50 | 55 | 60 |
| 注射压力 | Injection pressure | MPa | 250 | 202 | 209 | 175 |
| 螺杆长径比 | Screw L/D ratio | —— | 23.2 | 20.9 | 21.4 | 19.7 |
| 螺杆行程 | Screw stroke | mm | 250 | 250 | 285 | 285 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 231 | | 0 ~ 275 | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 8000 | | | |
| 移模行程 | Mold opening stroke | mm | 700 | | | |
| 模板尺寸 | Platen size | mm | 1760 x 1260 | | | |
| 转盘直径 | Rotary table diameter | mm | 1450 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 1260 x 780 | | | |
| 模板最大距离 | Max.daylight | mm | 1600 | | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 300-900 | | | |
| 顶出行程 | Ejector stroke | mm | 260 | | | |
| 顶出力 | Ejector tonnage | kN | 110 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 650 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 31.3 | | 50.2 | |
| 电热功率 | Heater power | kW | 14.3 | | 18.2 | |
| 温度控制区数 | Number of temp control zones | —— | 5 | | 6 | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L(升) | 1050 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 9.21 x 2.8 x 2.3 | | | |
| 机器重量 | Machine weight | Ton | 45 | | | |



说明：由于产品改进，技术参数的变更，恕不另行通知。
Remark:We reserve the right to make any technical improvement without prior notice.

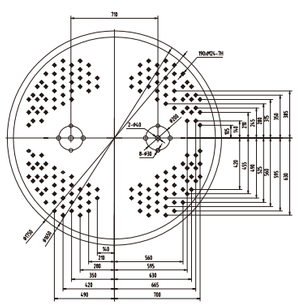
# 清双色技术参数表 *SPECIFICATIONS*

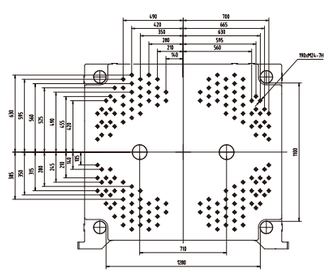
| 参数 | PARAMETER | UNIT | HMD DP850 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 900 | | 1400 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 398 | 491 | 677 | 806 |
| 注射重量 | Injection weight (PS) | g (克) | 362 | 447 | 616 | 733 |
| | | oz (盎司) | 12.8 | 15.8 | 21.7 | 25.9 |
| 注射速率 | Injection rate (PS) | g/s | 187 | 231 | 280 | 333 |
| 螺杆直径 | Screw diameter | mm | 45 | 50 | 55 | 60 |
| 注射压力 | Injection pressure | MPa | 250 | 202 | 209 | 175 |
| 螺杆长径比 | Screw L/D ratio | —— | 23.2 | 20.9 | 21.4 | 19.7 |
| 螺杆行程 | Screw stroke | mm | 250 | 250 | 285 | 285 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 231 | | 0 ~ 250 | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 8500 | | | |
| 移模行程 | Mold opening stroke | mm | 1000 | | | |
| 模板尺寸 | Platen size | mm | 1480 x 1470 | | | |
| 转盘直径 | Rotary table diameter | mm | 1530 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 1060 x 1010 | | | |
| 模板最大距离 | Max.daylight | mm | 2050 | | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 500-1050 | | | |
| 顶出行程 | Ejector stroke | mm | 140 | | | |
| 顶出力 | Ejector tonnage | kN | 70 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 650 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 36.5 | | 50.2 | |
| 电热功率 | Heater power | kW | 14.3 | | 18.2 | |
| 温度控制区数 | Number of temp control zones | —— | 5 | | 6 | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L ( 升 ) | 1100 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 11.2 x 3.05 x 2.75 | | | |
| 机器重量 | Machine weight | Ton | 46 | | | |

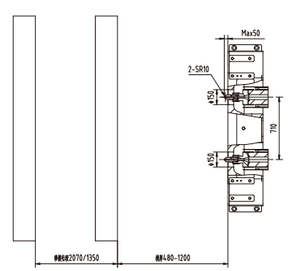


# 清双色技术参数表 *SPECIFICATIONS*

| 参数 | PARAMETER | UNIT | HMD DP1080 | | | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 900 | | 2400 | |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 398 | 491 | 1062 | 1232 |
| 注射重量 | Injection weight (PS) | g (克) | 362 | 447 | 966 | 1121 |
| | | oz (盎司) | 12.8 | 15.8 | 34.1 | 39.5 |
| 注射速率 | Injection rate (PS) | g/s | 308 | 380 | 336 | 390 |
| 螺杆直径 | Screw diameter | mm | 45 | 50 | 65 | 70 |
| 注射压力 | Injection pressure | MPa | 250 | 202 | 229 | 197 |
| 螺杆长径比 | Screw L/D ratio | —— | 23.2 | 20.9 | 21.5 | 20 |
| 螺杆行程 | Screw stroke | mm | 250 | 250 | 320 | 320 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 231 | | 0 ~ 242 | |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 10800 | | | |
| 移模行程 | Mold opening stroke | mm | 1350 | | | |
| 模板尺寸 | Platen size | mm | 1925 x 1745 | | | |
| 转盘直径 | Rotary table diameter | mm | 1650 | | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 1280 x 1100 | | | |
| 模板最大距离 | Max.daylight | mm | 2070 | | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 480 ~ 1200 | | | |
| 顶出行程 | Ejector stroke | mm | 330 | | | |
| 顶出力 | Ejector tonnage | kN | 110 x 2 | | | |
| 料管中心距 | Distance between barrel centers | mm | 710 | | | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | | | |
| 油泵马达 | Pump motor power | kW | 72 | | 72 | |
| 电热功率 | Heater power | kW | 14.3 | | 32 | |
| 温度控制区数 | Number of temp control zones | —— | 5 | | 6 | |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L(升) | 1150 | | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 10.2 x 3.6 x 3.5 | | | |
| 机器重量 | Machine weight | Ton | 50 | | | |







说明：由于产品改进，技术参数的变更，恕不另行通知。
Remark:We reserve the right to make any technical improvement without prior notice.

# DM

# 混色专用注塑机

## SPECIAL MIXED COLOR INJECTION MOLDING MACHINE

## 由于不同颜色组合，赋予产品新生命

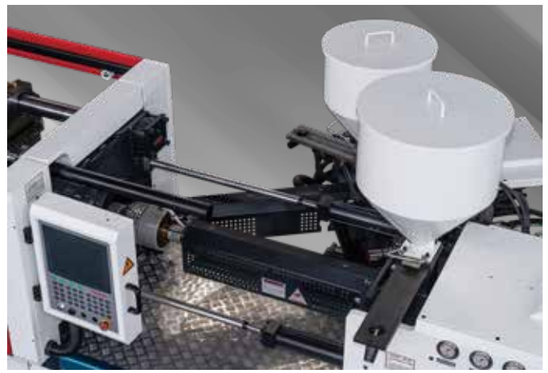
**Different color mixed then new products effect.**

- 对内外层不同塑料产品，可取代两次加工改为一次成型。

  Two layer with different material product, to replace of two times process.

- 在注射过程中可以同时注射或者间隔注射实现渐变效果。

  Simultaneously injection or interval injection to reach gradient effect.



- 本机器也可以生产单色产品，一机两用，提供多元化功能及全方位服务。

  Adapt to also make single color product, to provide mutil-diversity functions and service.

- 优化设计螺杆筒组件，具备更强的塑化能力和更好塑化效果，满足各种特殊产品需求。

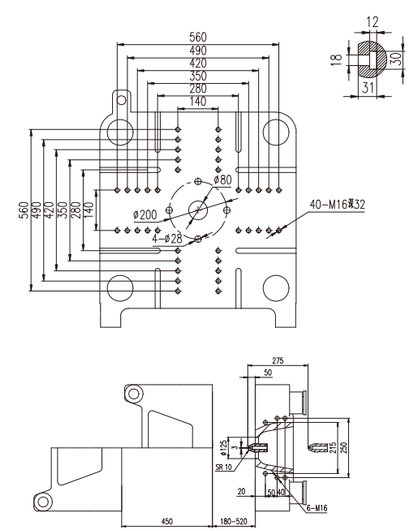
  Optimized design of screw and barrel, with better plasticizing ability and performance.

- 射台使用双层线轨结构。

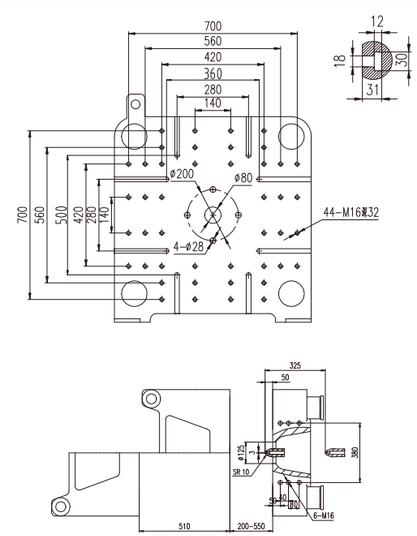
  Two stage guide line structure of injection unit.

# 混双色技术参数表 *SPECIFICATIONS*

| 参数 | PARAMETER | UNIT | HMD 170-DM2 | | HMD 218-DM2 | |
|---|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 282/90 | 587/170 | 445/130 | 876/218 |
| 注射装置 | INJECTION UNIT | | A | B | A | B |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 129 | 276 | 215 | 471 |
| 注射重量 | Injection weight (PS) | g (克) | 117 | 252 | 196 | 423 |
| | | oz (盎司) | 4.1 | 8.9 | 6.9 | 15.1 |
| 注射速率 | Injection rate (PS) | g/s | 98 | 140 | 113 | 192 |
| 螺杆直径 | Screw diameter | mm | 32 | 42 | 38 | 50 |
| 注射压力 | Injection pressure | MPa | 219 | 202 | 207 | 186 |
| 螺杆长径比 | Screw L/D ratio | —— | 22:1 | 21.8:1 | 22：1 | 22.2:1 |
| 螺杆行程 | Screw stroke | mm | 160 | 200 | 190 | 240 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 300 | 0 ~ 243 | 0 ~ 259 | 0 ~ 240 |
| 合模装置 | CLAMPING UNIT | | | | | |
| 锁模力 | Clamping force | kN | 1700 | | 2180 | |
| 移模行程 | Mold opening stroke | mm | 450 | | 510 | |
| 模板尺寸 | Platen size | mm | 710 x 690 | | 780 x 780 | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 480 x 460 | | 530 x 530 | |
| 模板最大距离 | Max.daylight | mm | 970 | | 1060 | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 180 ~ 520 | | 200 ~ 550 | |
| 顶出行程 | Ejector stroke | mm | 140 | | 140 | |
| 顶出力 | Ejector tonnage | kN | 50 | | 50 | |
| 动力/电热 | POWER UNIT | | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 16 | 17.5 | | |
| 油泵马达 | Pump motor power | kW | 18.7 | 23 | 17.5 | 17.5 |
| 电热功率 | Heater power | kW | 8.5 | 17.7 | 18.7 | 31.3 |
| 温度控制区数 | Number of temp control zones | —— | 3 | 5 | 9.6 | 22.6 |
| 其 它 | OTHERS | | | | | |
| 油箱容积 | Oil tank | L(升) | 260 | | 530 | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 4.9 x 2.2 x 2.1 | | 5.5 x 2.1 x 2.1 | |
| 机器重量 | Machine weight | Ton | 6.8 | | 8.9 | |




**HMD 170-DM2**

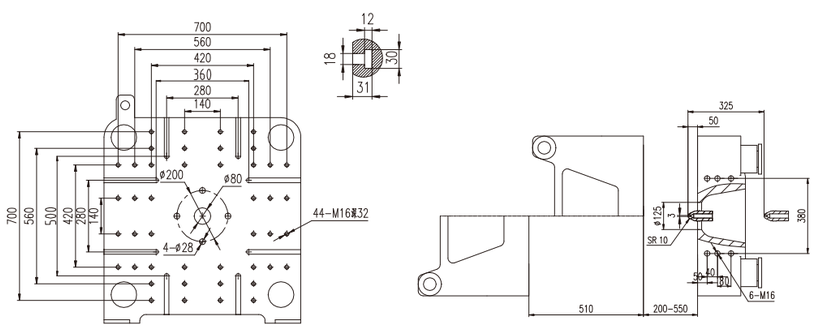



**HMD 218-DM2**

说明：由于产品改进，技术参数的

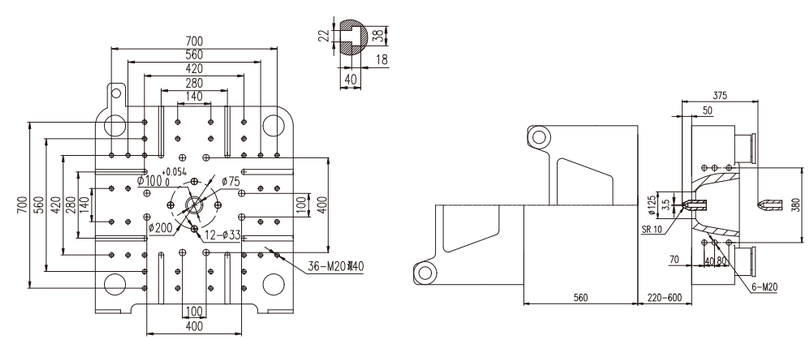
# 混三色技术参数表 *SPECIFICATIONS*

| 参数 | PARAMETER | UNIT | HMD 218-DM3 | | |
|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 445/130 | 876/218 | 445/130 |
| 注射装置 | INJECTION UNIT | | A | B | C |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 215 | 471 | 215 |
| 注射重量 | Injection weight (PS) | g (克) | 196 | 423 | 196 |
| | | oz (盎司) | 6.9 | 15.1 | 6.9 |
| 注射速率 | Injection rate (PS) | g/s | 113 | 192 | 113 |
| 螺杆直径 | Screw diameter | mm | 38 | 50 | 38 |
| 注射压力 | Injection pressure | MPa | 207 | 186 | 207 |
| 螺杆长径比 | Screw L/D ratio | —— | 22:1 | 22.2:1 | 22:1 |
| 螺杆行程 | Screw stroke | mm | 190 | 240 | 190 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 259 | 0 ~ 240 | 0 ~ 259 |
| 合模装置 | CLAMPING UNIT | | | | |
| 锁模力 | Clamping force | kN | 2180 | | |
| 移模行程 | Mold opening stroke | mm | 510 | | |
| 模板尺寸 | Platen size | mm | 780 x 780 | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 530 x 530 | | |
| 模板最大距离 | Max.daylight | mm | 1060 | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 200 ~ 550 | | |
| 顶出行程 | Ejector stroke | mm | 140 | | |
| 顶出力 | Ejector tonnage | kN | 50 | | |
| 动力/电热 | POWER UNIT | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | 17.5 | 17.5 |
| 油泵马达 | Pump motor power | kW | 18.7 | 31.3 | 18.7 |
| 电热功率 | Heater power | kW | 9.3 | 21.3 | 9.3 |
| 温度控制区数 | Number of temp control zones | —— | 3 | 6 | 3 |
| 其 它 | OTHERS | | | | |
| 油箱容积 | Oil tank | L(升) | 580 | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 5.5 x 2.25 x 2.1 | | |
| 机器重量 | Machine weight | Ton | 8.2 | | |




# 混三色技术参数表 *SPECIFICATIONS*

| 参数 | PARAMETER | UNIT | HMD 268-DM3 | | |
|---|---|---|---|---|---|
| 国际公认型号 | International size rating | —— | 445/130 | 876/218 | 445/130 |
| 注射装置 | INJECTION UNIT | | A | B | C |
| 理论注射容量 | Injection volume(theoretical) | $cm^3$ | 215 | 471 | 215 |
| 注射重量 | Injection weight (PS) | g (克) | 196 | 423 | 196 |
| | | oz (盎司) | 6.9 | 15.1 | 6.9 |
| 注射速率 | Injection rate (PS) | g/s | 113 | 192 | 113 |
| 螺杆直径 | Screw diameter | mm | 38 | 50 | 38 |
| 注射压力 | Injection pressure | MPa | 207 | 186 | 207 |
| 螺杆长径比 | Screw L/D ratio | —— | 22:1 | 22.2:1 | 22:1 |
| 螺杆行程 | Screw stroke | mm | 190 | 240 | 190 |
| 螺杆转速 | Screw speed | r/ min | 0 ~ 259 | 0 ~ 240 | 0 ~ 259 |
| 合模装置 | CLAMPING UNIT | | | | |
| 锁模力 | Clamping force | kN | 2680 | | |
| 移模行程 | Mold opening stroke | mm | 560 | | |
| 模板尺寸 | Platen size | mm | 835 x 835 | | |
| 拉杆内间距 | Dist. between tie bars (H × V) | mm | 580 x 580 | | |
| 模板最大距离 | Max.daylight | mm | 1160 | | |
| 容模量 (最小—最大) | Mold thickness(Min-Max) | mm | 220 ~ 600 | | |
| 顶出行程 | Ejector stroke | mm | 160 | | |
| 顶出力 | Ejector tonnage | kN | 77 | | |
| 动力/电热 | POWER UNIT | | | | |
| 油压系统压力 | Hydraulic system pressure | MPa | 17.5 | 17.5 | 17.5 |
| 油泵马达 | Pump motor power | kW | 18.7 | 31.3 | 18.7 |
| 电热功率 | Heater power | kW | 9.3 | 21.3 | 9.3 |
| 温度控制区数 | Number of temp control zones | —— | 3 | 6 | 3 |
| 其 它 | OTHERS | | | | |
| 油箱容积 | Oil tank | L(升) | 650 | | |
| 外形尺寸(L x W x H) | Machine dimension(L x W x H) | m | 6.2 x 2.25 x 2.3 | | |
| 机器重量 | Machine weight | Ton | 11.5 | | |




说明：由于产品改进，技术参数的变更，恕不另行通知。
Remark:We reserve the right to make any technical improvement without prior notice.