



Di - PVC



TOGGLE INJECTION MOULDING MACHINES

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PARAMETER

ITEM		D100/i380	D130/i510	D160/i600	D 200/i850
Injection Unit					
Screw Diameter	mm	38	42	45	55
Screw L/D Ratio	L/D	20	18.1	18.7	18.2
Theoretical Shot Volume	cm ³	198	242	310	535
Injection Weight (RPVC)	Gms	257	314	403	695
Injection Pressure	MPa	193.3	158.2	165.9	150.2
Injection Rate into air (RPVC)	cm ³ /s	111.8	137.6	160.3	208.8
Injection Stroke	mm	175	175	195	225
Screw Speed	rpm	164	164	186	151
Clamping Force	KN	1000	1300	1600	2000
Clamping Stroke	mm	360	430	480	540
Space Between Tie Bar	mm	360 X 360	420 X 420	470 X 470	530 X 530
Max. Mold Height	mm	380	460	530	560
Min. Mold Height	mm	150	160	200	220
Eject Stroke	mm	120	120	150	150
Eject Force	KN	34	34	34	67
No. Of Ejector Pins	piece	5	5	5	5
Max. Pump Pressure	MPa	17.5	17.5	17.5	17.5
Pump Motor Power	KW	13	16	16	20
Heater Power	KW	5	6.9	6.9	9.7
Oil Tank Capacity	L	150	200	220	300

D 250/i1100		D 300/i1500		D 350/i1900		D 400/i2500		D 450/i3200		D 500/i3800	
55	60	60	65	65	70	70	75	75	80	80	85
20	18.3	20	18.3	20	18.6	20	20.5	20	20.6	22	20.7
601	715	780	916	992	1151	1347	1546	1741	1980	2031	2292
781	929	1014	1191	1289	1496	1751	2009	2263	2574	2640	2979
192.7	159.3	192.5	164	192.8	166.3	191.3	166.6	184.8	162.4	190.3	168.6
224.5	267.2	264.8	310.8	264.4	306.7	318.7	365.9	389.8	443.5	465.9	526
253	253	276	276	299	299	350	350	394	394	404	404
145	145	134	134	106	106	103	103	109	109	134	134
2500		3000		3500		4000		4500		5000	
550		650		750		750		750		840	
580 X 580		630 X 630		680 X 680		730 X 730		780 X 780		820 X 820	
600		650		700		750		780		800	
250		250		280		280		300		320	
160		160		160		200		200		200	
67		67		67		124		124		124	
9		13		13		13		17		17	
17.5		17.5		17.5		17.5		17.5		17.5	
25		31		37		37		43		53	
11.5		13		13		20		21.5		22.5	
350		500		550		740		780		900	

FEATURES

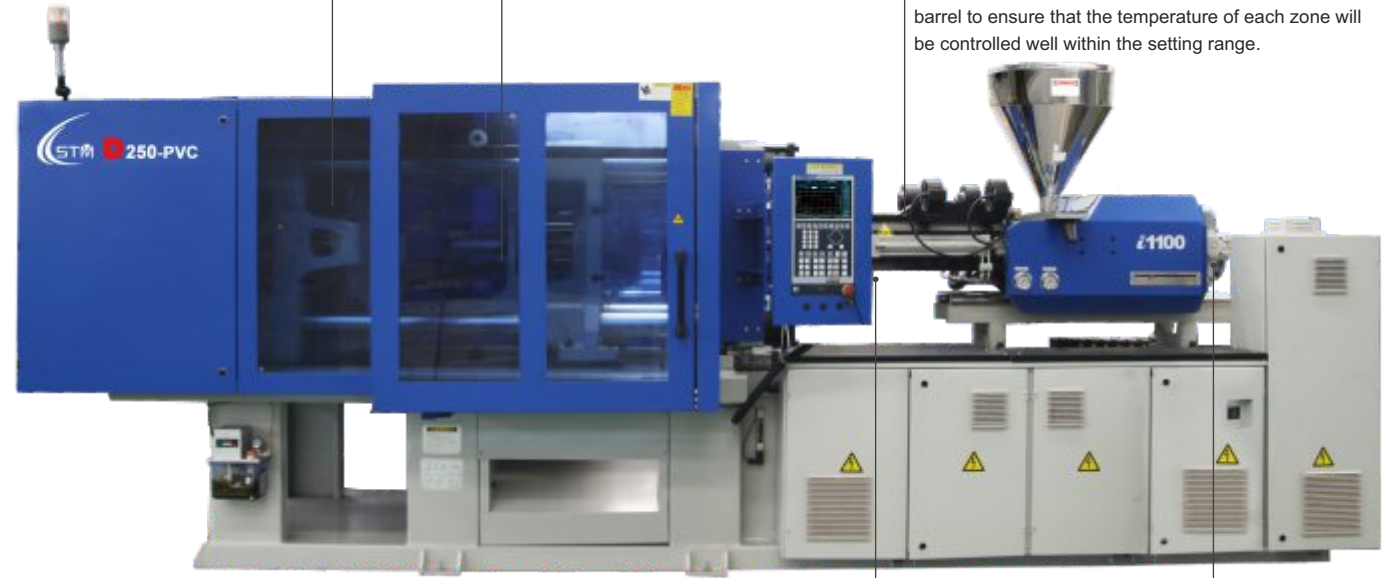
D-iPVC INJECTION MOULDING MACHINE

WIDENED SAFETY DOOR

As PVC IMM is specially used for producing PVC pipe fittings, generally core pulling cylinders are with the molds which need widened doors and windows.

TWO CORE PULLING

For special product requirements, extra one or two sets core pulling can be added.



SPECIAL AIR-COOLING TEMPERATURE CONTROL DEVICE

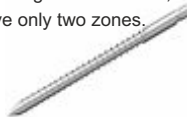
PVC resins is easy to be burned in the barrel due to it's very sensible to the temperature. Under such conditions, the screw has to be pulled out and cleaned with the barrel thoroughly. In order to control the temperature precisely, cooling fans, which is started or stopped by a special program, are installed outside the barrel to ensure that the temperature of each zone will be controlled well within the setting range.

SPECIAL PLASTICIZING UNITS FOR PVC

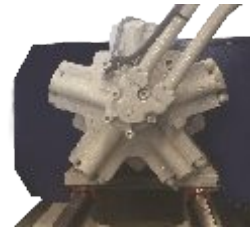
Generally there is no check ring on PVC screw, and its screw compression ratio is small, some of them have only two zones.



The PVC screw with mixing ring is mainly used for PVC powder with large percentage calcium powder.



The PVC screw without mixing ring is mainly used for PVC granulated resin



ENLARGED HYDRAULIC MOTOR FOR PLASTICIZING

Because the flowability of PVC is not so good, the torque of plasticizing hydraulic motor has to be increased but keeping the screw rotating not too fast. Otherwise the material will be easily burnt.



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