Part V Technical Parameters & Machine Outline

Chapter 1 Machine Parameters

	Machine Type		ZE600-80		
INJECTION	Screw Type		A	B	C
	Screw Diameter	mm	19	22	26
	Screw L/D Ratio		20	20	17
	Injection Distance	mm	75	95	
	CalculatedInjectionVolume	cm^3	21	36	50
	Injection Capacity(PS)	g	19.1	32.8	45.5
	Injection Speed	mm/s	200		
	Injection Pressure	Mpa	260	220	157
		Kgf/cm^2	2650	2240	1600
	Holding Pressure	Mpa	208	175	125
		Kgf/cm^2	2120	1780	1270
	Screw Speed	RPM	400		
	Nozzle Touch Force	KN(tf)	14.7（1.5）		
	Nozzle In Size	mm	50		
	Heating Input Power	KW	4.1	5.0	
MOLD	Clamping Force	KN	600		
	Toggle Stroke mm		270		
	Space Between Tie-Bars H*V	mm	370*320		
	Minimal Mould Size H*V	mm	240*205		
	Mould Height	mm	150-370		
	Ejector Stroke	mm	70		
	Ejector Force	KN(tf)	19.6（2.0）		
OTHER	Hopper Capacity	L	15		
	Machine Dimension L*W*H	m	3.97*1.22*1.81		
	Machine Weight	tf	3.3		

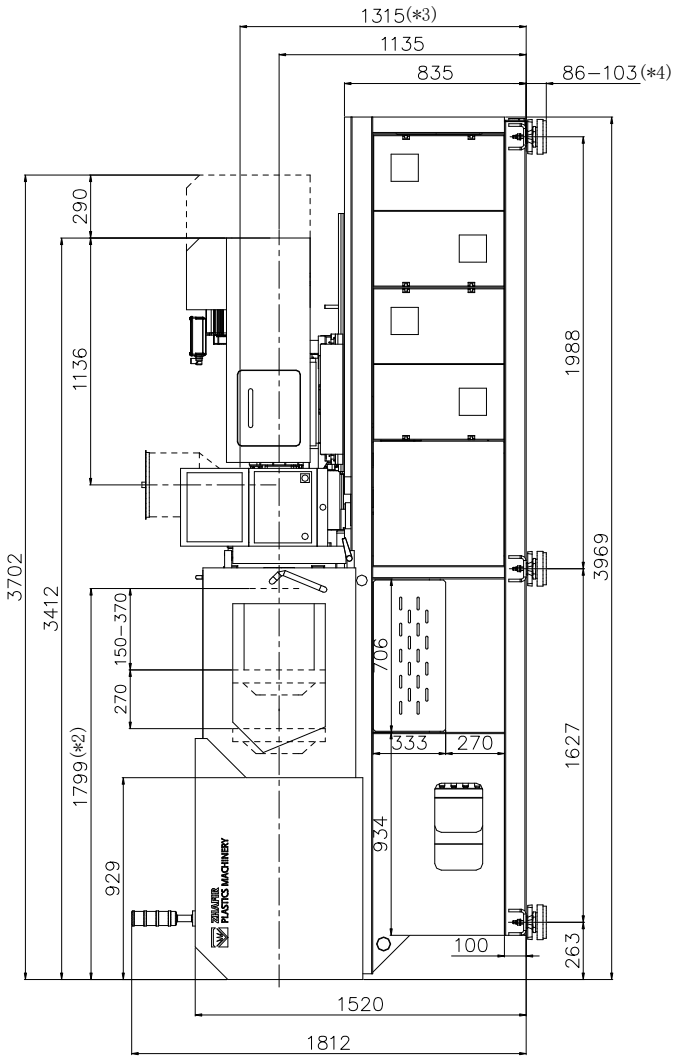
Notes：

1. The above data will be changed when design improves or with other reasons.
2. The maximum injection pressure and holding pressure are limited by different injection molding conditions.
3. The maximum injection capacity is [screw barrel cross-sectional area] × [injection stroke].
4. The injection quality is calculated by polystyrene (PS). There will be different situations because of different material grades, injection conditions, molds and so on.
5. Numerical values in the parentheses are reference values.
   1MPa=10.2kgf/cm^2，1KN=0.102tf

Chapter 2 Structure of the Device Parameters

Machine dimensions

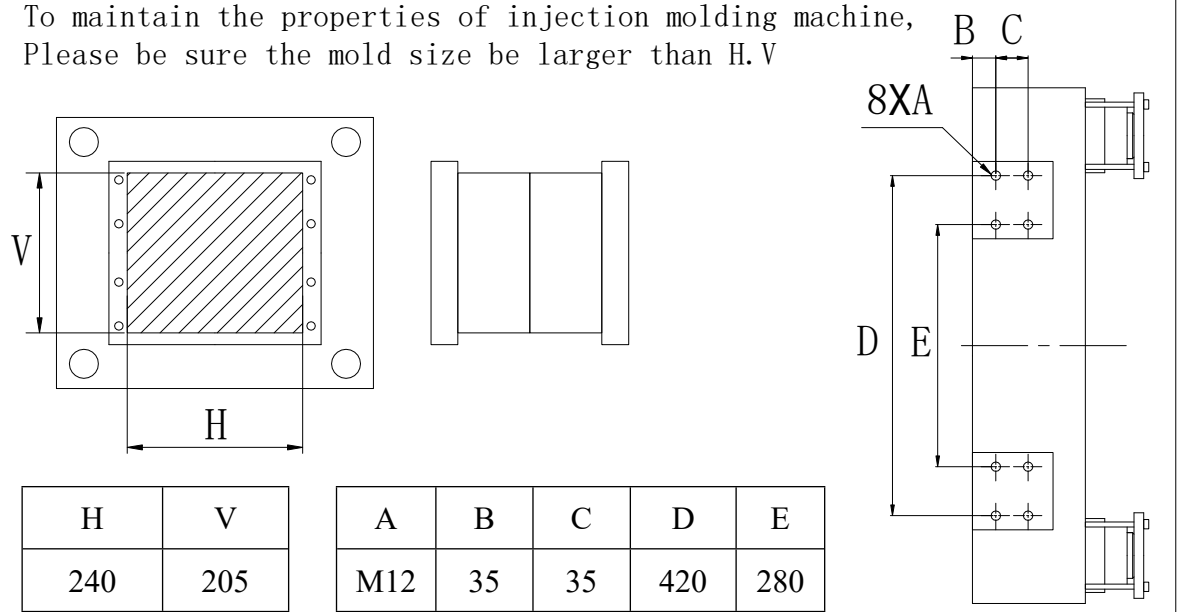
Machine Outline



*1 Power supply
*2 To the mounting face of the fixed platen
*3 To the top of fixed platen
*4 Vibration dumping support
*5 Cooling water connector Rc1

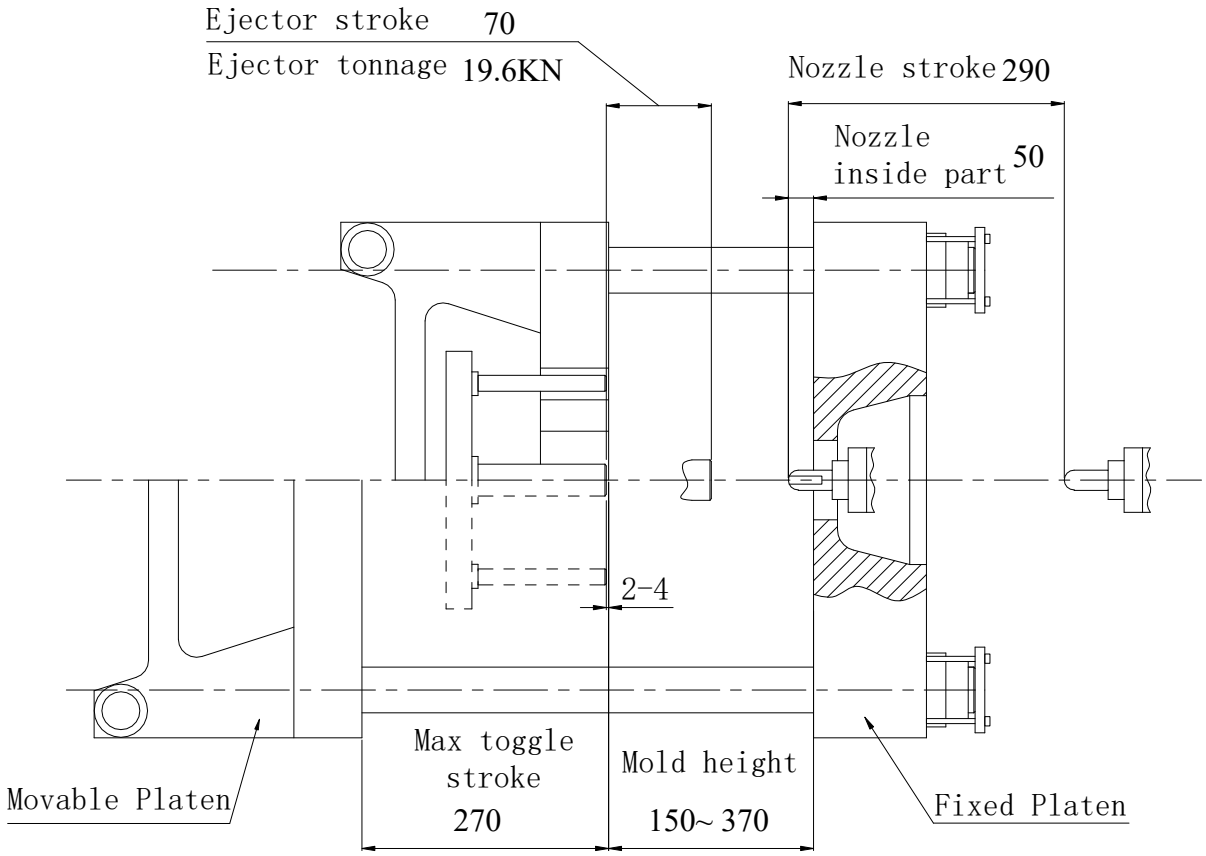
Clamping Unit Mold size parameters

To maintain the properties of injection molding machine,
Please be sure the mold size be larger than H.V



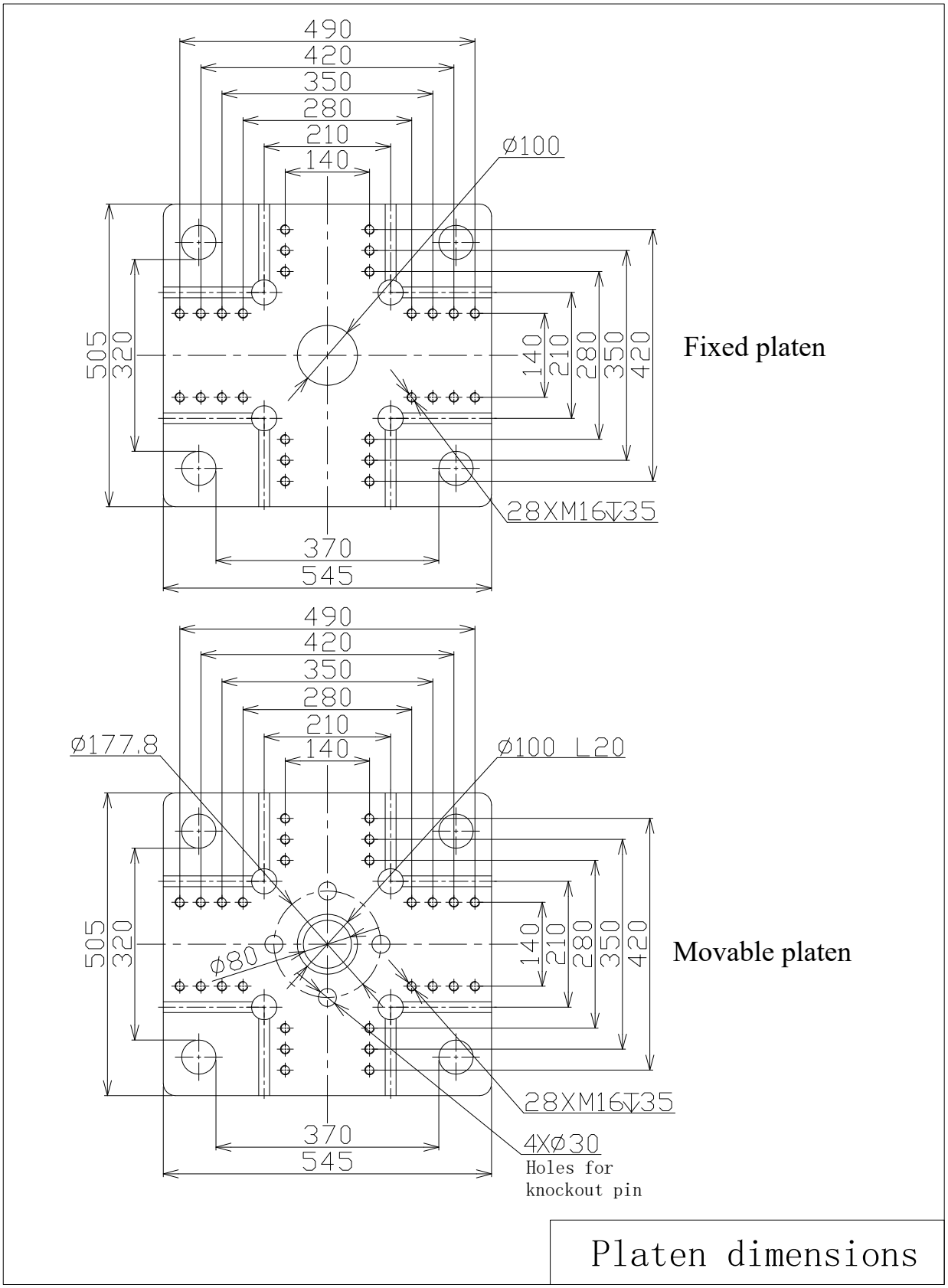
H	V
240	205

A	B	C	D	E
M12	35	35	420	280



Mold size parameters

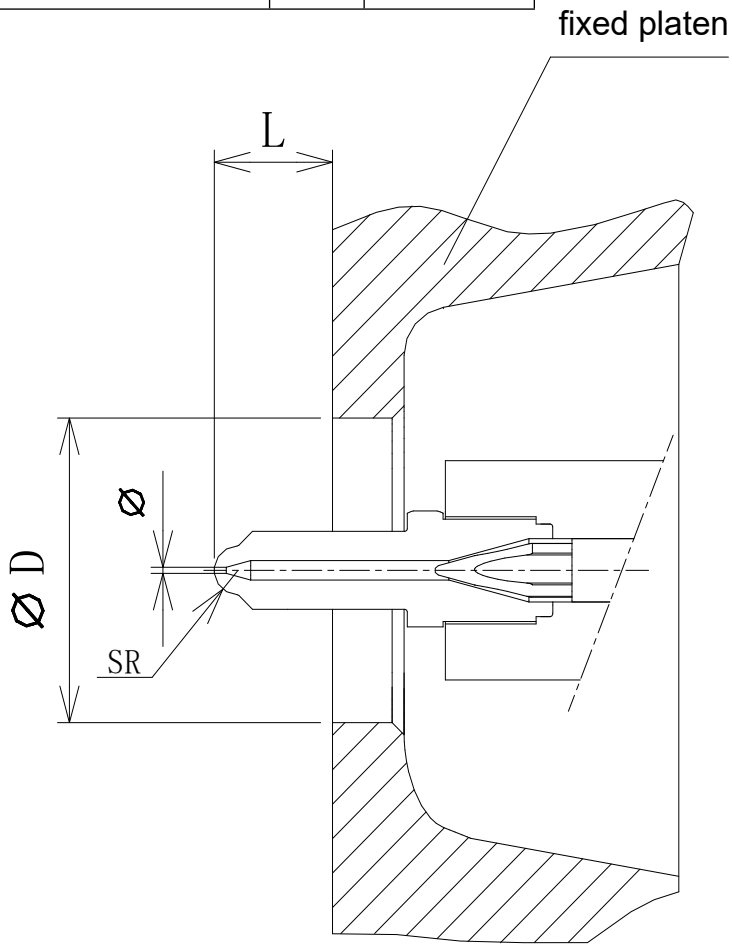
Clamping Unit Platen dimensions



Injection Unit Nozzle size parameters

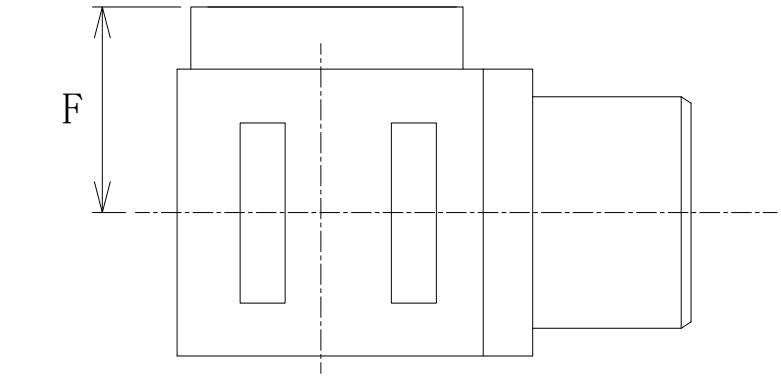
80

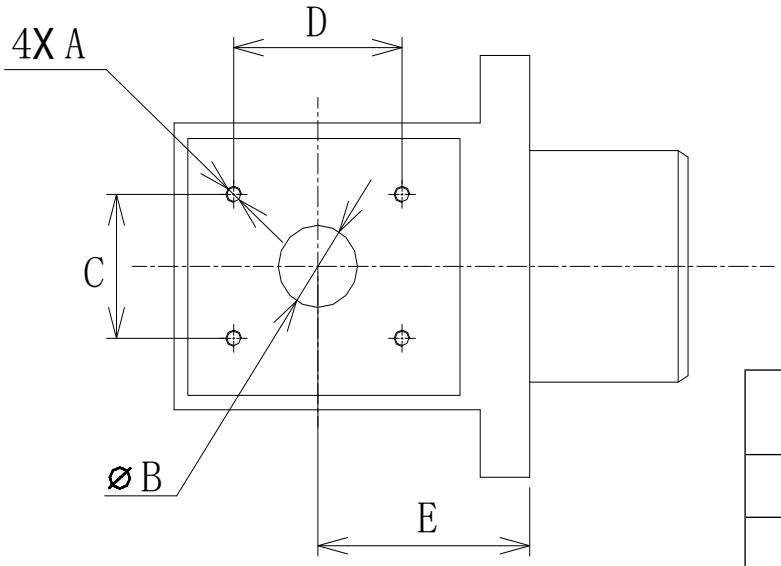
Nozzle hole diameter	Ø	2.2
Sphere diameter of nozzle	SR	10
Hole diameter	D	$\varnothing 100_{0}^{+0.035}$
Injection protrusion	L	50



Nozzle size parameters

Injection Unit Barrel seat dimension

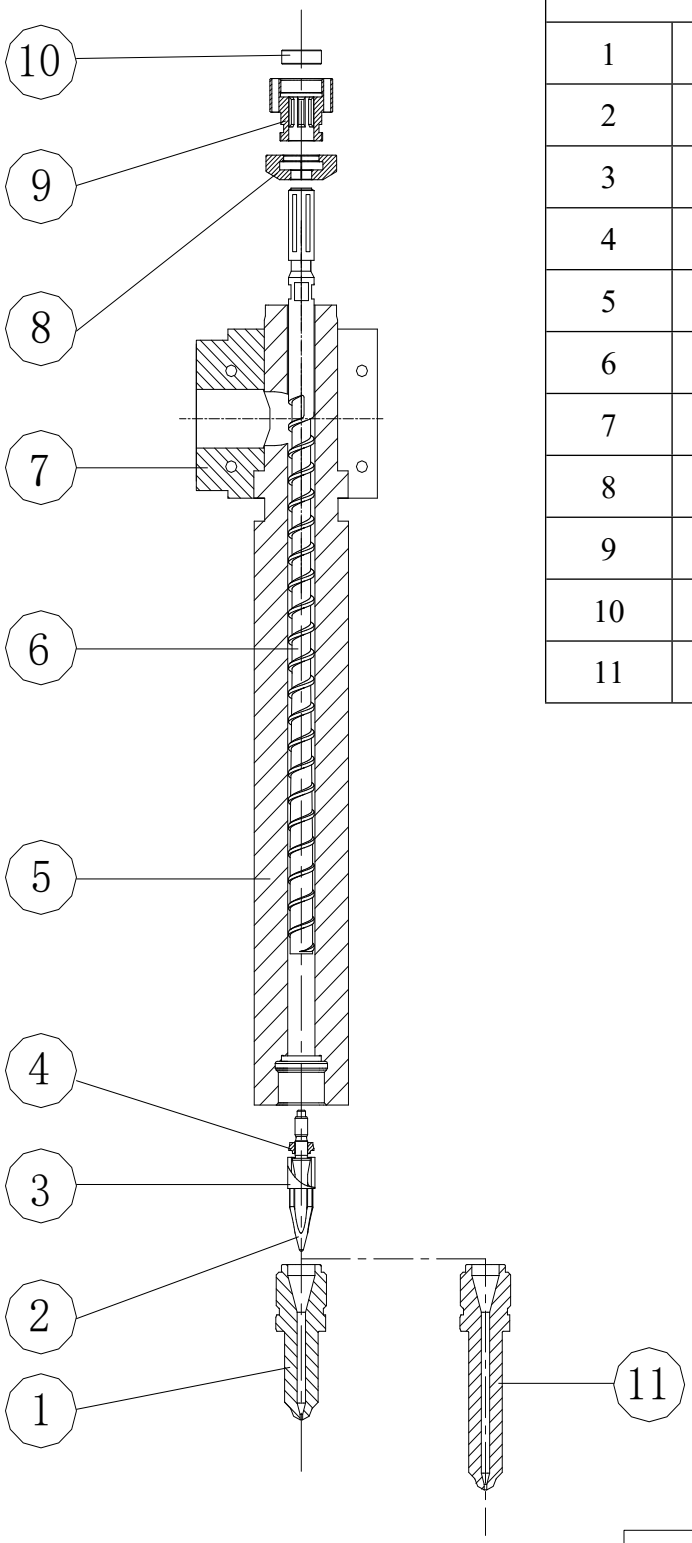




80	
A	M8
B	30
C	70
D	85
E	87
F	95

Barrel seat dimension

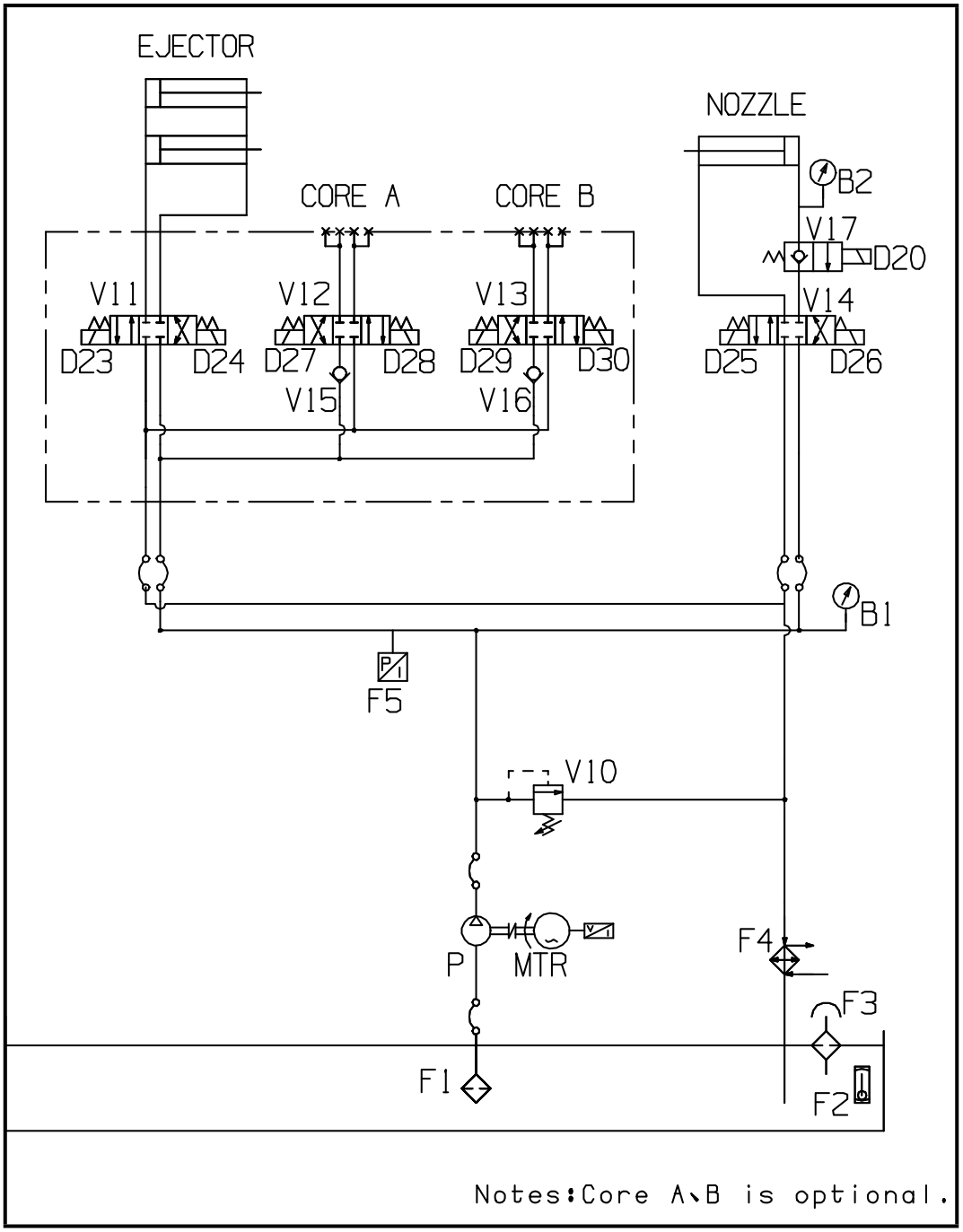
Injection Unit The screw cylinder struction



80	
1	nozzle
2	Screw tip
3	Collar seat
4	Screw collar
5	screw barrel
6	Screw
7	Barrel seat
8	Split collar
9	Spline Connector
10	Heel block
11	extended nozzle

The screw cylinder struction

Hydraulic Schematic



■ The Adjustment Of The Hydraulic System

The machine's hydraulic system uses the electro-hydraulic proportional control technology which makes the system pressure and speed control more precise

The factory has been finished the debugging of the machine's hydraulic system and the flow linear, so the customer only need according to each pressure of the actions (Top die, core, whole shift) which have been set in computer parameters to meet the technological requirements of the products. Also other hydraulic valve is adjusted to the optimum state in factory, the customer do not need further adjustment.

Electromagnet Action Figure

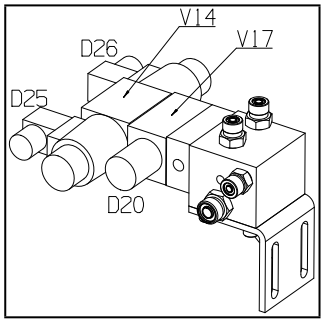
Remark：

1．"+" is a standard of normal function when power on.
"◎" is a standard of optional function when power on.

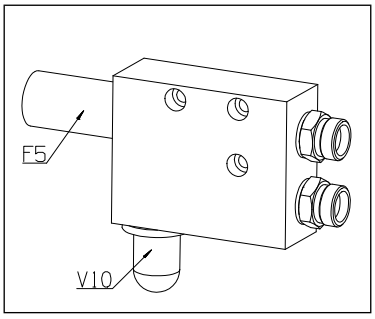
2．D27、D28、D29、D30 is be long to core A 、core B,the function is optional.

electromagnet code	nozzle			ejector		core		core	
	nozzle forward	nozzle retract	release pressure	ejector forward	ejector retract	core A in	core A out	core B in	core B out
D23					+				
D24				+					
D25	+		+						
D26		+							
D27							◎		
D28						◎			
D29									◎
D30								◎	
D20		+	+						

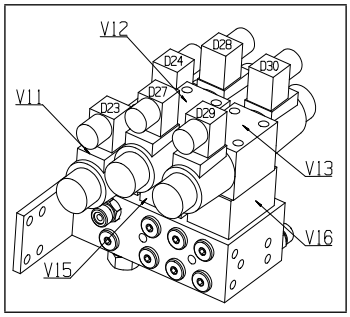
Nozzle block

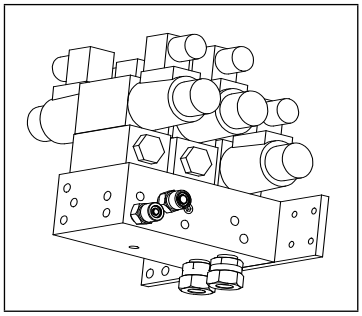


Pressure block



Ejector block





V12、V13、V15、V16 is Core A、Core B（optional）
Core connector :M14X1.5

Hydraulic Components Table

NO	Code	Item
1.	MTR/P	pump motor
2.	F1	Suction filter
3.	F2	Level gauge
4.	F3	Breather filter
5.	F4	Oil cooler
6.	F5	Pressure transducer
7.	V10	Overflow valve
8	V11	Directional Valve
9	V12	Directional Valve
10	V13	Directional Valve
11	V14	Directional Valve
12	V15	Angle check valve
13	V16	Angle check valve
14	V17	Electrically controlled check valve
15	B1	manometer
16	B2	manometer

Chapter 3 Electrical Drawings

ZE600-80 Electrical Drawings

Chapter 4 Standard Introduction Appendix of Optional Function

Chapter 5 Special Introduction Appendix of Optional Function