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TCS

TWO COLOR MIXING MACHINE

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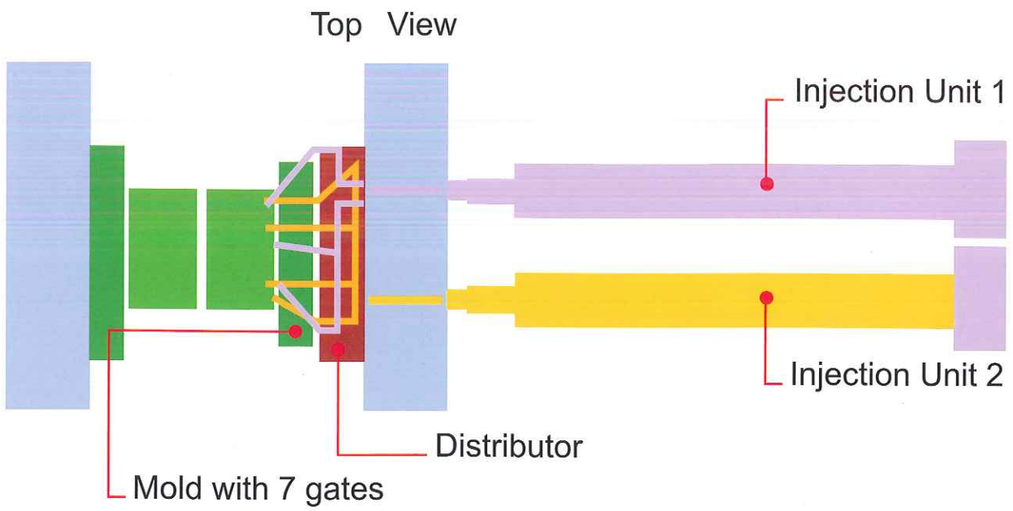
Separate Injection Method for Marble or Wood Texture Effects



If the molding parts is flat shape and customer want to get a wooden pattern or marble effects,the solution is 2 (or 3 or 4) barrel go into a distributor , in the distributor the 2 different colors material convert into several material flow, and then insert to the mold from several gates separately.

These several material flow will bring wooden pattern or marble effects.

(**The mold with many gates in this method.)

(**Distributor is a parts of mold.)

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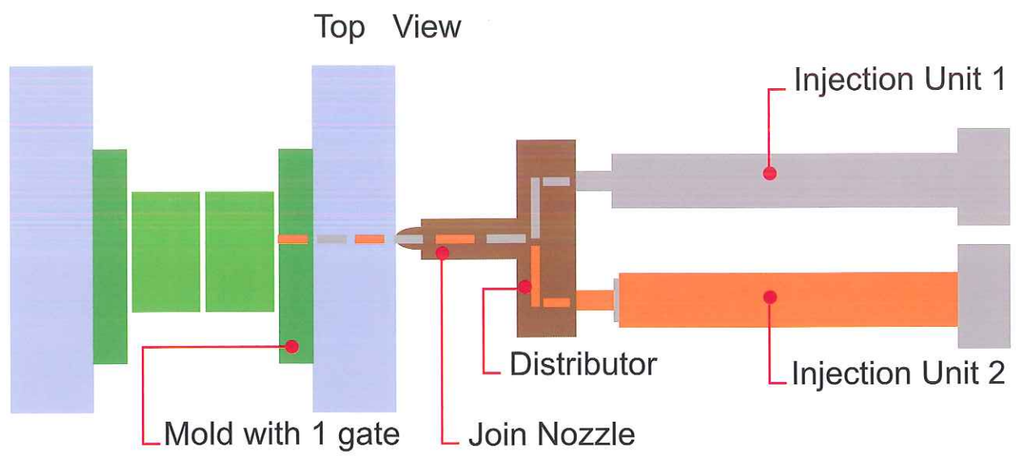
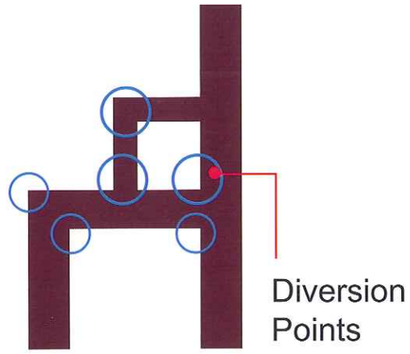
Co-injection method for Marble or Wood Texture Effects



This is the system produced parts as chair or other plastic products,2 (or 3 or 4) different colors of plastic material from separate barrel mixed in a distributor, the mixed material go into the Joint Nozzle, and the mixed material from Joint Nozzle into the mold from one gate. (The mold with only 1 gate / Distributor is a parts of machine.)

To used this method for wooden pattern or marble effects , the molding parts must have diversions points (more diversion bring more perfect pattern) .

In case of no diversion or less diversion, the wooden pattern of marble effects will not clear and not realistic.



If the molding parts is flat shape (as bottom sample , it is a plate.), wooden pattern or marble effects will not occur as no diversion point inside the mold.

The pattern will be more like a regularized radiation shape or regularized geometric figure.

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SPECIFICATION SHEET FOR TWO COLOR MIXING MACHINE

MODELS		JW-120TCS				JW-150TCS				JW-180TCS				JW-220TCS				JW-250TCS				300TCS				400TCS				500TCS			
INJECTION UNIT		I12d			I5h	I15d			I5h	I18d			I5h	I22d			I5h	i25d			I5h	i30d			I5h	i40d			i8h	i50d			i16h
SCREW DIAMETER	mm	38	42	45	32	42	45	50	32	50	55	60	32	55	60	65	32	60	65	70	32	65	70	75	32	70	75	80	36	75	85	95	45
INJECTION CAPACITY	cm3	192	235	270	105	277	318	392	105	471	570	60	105	617	735	862	105	791	929	1077	105	1028	1193	1369	105	1385	1590	1809	153	1811	2326	2906	318
SHOT SIZE(PS)	gr	170	208	238	92.5	244	281	347	92.5	416	503	60	92.5	546	649	730	92.5	699	821	952	92.5	908	1054	1210	92.5	1224	1405	1599	135	1601	2056	2569	281
INJECTION RATE	cm3/sec	90	111	127	67	95	110	135	67	126	152	181	67	178	212	249	59	192	226	262	59	239	277	318	59	254	291	332	94	274	352	439	117
INJECTION PRESSURE(MAX)	kg/cm2	2443	2000	1742	1854	2321	2022	1637	1854	2499	2066	1736	1854	2483	2087	1778	1854	2307	1966	1695	1854	2172	1872	1631	1854	2177	1897	1667	1836	2369	1884	1476	1948
NOZZLE STROKE	mm	325				345				365				395				425				485				525				575			
NOZZLE CONTACT FORCE	tons	4.6				4.6				5.9				5.9				8				8				8				8			
INJECTION SPEED	mm/sec	80			84	69			84	64			84	75			74	68			74	72			74	66			92	62			74
CLAMPING UNIT																																	
CLAMPING FORCE	ton	120				150				180				220				250				300				400				500			
CLAMP STROKE(MAX)	mm	360				400				450				500				550				600				700				800			
MOLD HEIGHT(MIN-MAX)	mm	150~400				150-450				150~550				150-550				220~650				220-700				280-760				300-900			
OPEN DAYLIGHT	mm	510~760				550-850				600~1000				650-1050				770~1200				820-1300				980-1460				1100-1700			
PLATEN SIZE(H*V)	mm	610×610				650×650				720×720				780×780				860×860				940×940				1060×1060				1190×1190			
DISTANCE BETWEEN TIE-RODS	mm	410×410				430×430				480×480				520×520				580×580				630×630				720×720				820×820			
HYDRAULIC EJECTOR FORCE	ton	3.9				4.6				5.3				5.3				7				7				11				11			
HYDRAULIC EJECTOR STROKE	mm	100				110				130				150				160				180				210				210			
HYDRAULICS																																	
PUMP CAPACITY	l/min	95+43				95+43				134+43				189+38				189+38				237+41				237+59				280+79			
SYSTEM PRESSURE	kg/cm2	140				140				140				140				140				140				140				140			
ELECTRICS																																	
POWER SUPPLY(STANDARD)	volt	220				220				220				220				220				220				220				220			
MOTOR RATED	HP	30				30				40				50				50				60				50+15				60+20			
NUMBER OF HEAT CONTROL ZONES	set	4				4				4				5				5				5				5				6			
HEATING WATTAGE	kw	8.29+5.8				9.68+5.8				14.59+5.8				16.42+5.8				18.02+5.8				20.8+5.8				24.10+6.4				31+10.8			

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