

Ningbo LiSong Injection Technology Co.,Ltd.		LS220/530 GT	LS270/580GT	LS290/630GT	LS400/670GT	LS458/720GT	LS550/770GT	LS650/900GTe		LS780/960GTe		LS800/1000GTe	LS800/1000GTHe	LS1000/1120GTe	LS1000/1120GTHe
Model description	型号	220/530-870	270/580-1030	290/630-1030	400/670-2500	458/720-2500	550/770-4200	650/900-5000	650/900-4850	780/960-4850	780/960-8000	800/1000-8000	800/1000-10000	1000/1120-10000	1000/1120-11900
International size description	国际标准尺寸	2200-870	2700-1030	2900-1030	400-2500	4580-2500	5500-4200	6500-5000	6500-4850	7800-4850	7800-8000	8000-8000	8000-10000	10000-10000	10000-11900

www.chinalisong.com
www.injectionmachine.net

LISONG Bucket Injection molding machine

Clamping unit	合模装置		220/530	270/580	290/630	400/670	458/720	550/770	650/900	780/960	800/1000	1000/1120
Clamping force	合模力	[kN]	2200	2700	2900	4000	4580	5500	6500	7800	8000	10000
Locking force	锁模力	[kN]	2420	2970	3190	4400	5038	6050	7150	8580	8800	11000
Max.mould opening stroke	最大开模行程	[mm]	500	500	640	730	750	830	930	1050	1100	1300
Min.mould height	最小模厚	[mm]	200	200	220	250	280	300	420	450	450	500
Max.mould height	最大模厚	[mm]	610	610	610	730	730	800	1000	1000	1000	1000
Max.daylight	最大模板间距	[mm]	1110	1110	1250	1460	1480	1630	1930	2050	2100	2300
Mould platen(h×v)	模板尺寸(水平×垂直)	[mm]	800x800	830x830	920x920	1000x970	1090x1090	1175x1120	1310x1310	1390x1390	1470x1340	1630x1510
Distance between tie bars(h×v)	拉杆间距(水平×垂直)	[mm]	530x470	580x580	630x630	670x640	720x720	770x720	900x810	960x810	1000x870	1120x1000
Ejection stroke	顶出行程	[mm]	160	160	160	160	160	160	175	175	280	320
Ejection force	顶出力	[kN]	89	89	110	158	158	158	158	158	200	200

Injection unit	注射装置		870	1030	1030	2500	2500	4200	5000	4850	4850	8000	8000	1000	11900
Screw diameter	螺杆直径	[mm]	50	55	55	70	70	80	90	100	100	100	100	110	120
Screw geometry	螺杆形状		standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准	standard 标准
L / D ratio	长径比		26	24	24	24	24	24	24	24	24	21.6	21.6	22	22
										85	85				
Spec.inj.Press. (up to 400 ℃)	注射压力(至400℃)	[bar]	1932	1866	1866	1866	1866	1866	1762	1899	1899	1852	1852	1944	1926
Max. cylinder head volume	理论注射容积	[cm ³]	452	546	546	1366	1366	2262	2863	2554	2554	4320	4320	5227	6220
Max. shot weight (PS)	最大注射量	[g]	411	497	497	1243	1243	2058	2605	2324	2324	3931	3931	4757	5660
Max. Rate of injection ¹⁾	最大注射速率 ¹⁾	[cm ³ /s]													
> without accumulator ²⁾	> 无蓄能器 ²⁾	[cm ³ /s]	332	421	421	774	774	890	1139	1461	1461	1288	1288	1340	1459
Injection speed	注射速度														
(Under 1000bar injection pressure)	(在1000bar的注射压力下)														
> without accumulator	> 无蓄能器	[mm/s]	169	181	181	201	201	177	179	186	186	164	164	141	129
Max. screw stroke	最大螺杆行程	[mm]	230	230	230	355	355	450	450	450	450	550	550	550	550
Max. nozzle dipping depth(SVO)	最大喷嘴伸入模板长度	[mm]	80	80	80	80	80	80	80	80	80	80	80	80	80
Number of heating zones	加热段数量		5	5	5	6	6	6	7	12	12	7	7	7	7
Hopper capacity	料斗容积	[ltr.]	35	35	35	35	35	70	70	70	70	70	70	70	70

General data	综合数据		220/530-870	270/580-1030	290/630-1030	400/670-2500	458/720-2500	500/770-4200	650/900-5000	650/900-4850	780/960-4850	780/960-8000	800/1000-8000	800/1000-10000	1000/1120-10000	1000/1120-11900
Oil tank capacity	油箱容量	[ltr.]	250	540	540	600	820	820	880	880	880	880	960	960	1050	1050
Installed electrical rating	额定电气功率															
> capacity with hydraulic drive	> 液压驱动功率	[≈kW]	37	45	45	45+37	45+37	55+45	45+45+22	45+45+22	45+45+22	55+45+45	55+45+45	55+55+54	55+55+54	55+55+55
> electric screw drive	> 电动螺杆	[≈kW]							75	90	90	90	90	110	110	130
> heating capacity of screw cylinder	> 料筒加热功率	[≈kW]	25.9	29.2	29.2	31.6	31.6	42.5	52.3	71.5	71.5	53.3	53.3	61.8	61.8	68
> capacity with electr drive ²⁾	> 电器总功率 ²⁾	[≈kW]	62.9	74.2	74.2	113.6	113.6	142.5	239.3	273.5	273.5	288.3	288.3	326.8	326.8	363
Net weight (without oil) ³⁾	机器净重(不含油) ³⁾	[≈kg]	9100	10700	11000	15000	17800	22500	27200	27400	28800	29100	38000	39000	48200	50000
Machine dimensions(l×w×h)	机器尺寸(l×w×h)	[≈m]	6.32x1.55x2.1	6.2x1.69x2.2	6.65x1.69x2.2	7.25x1.8x2.35	7.85x2.0x2.4	9.0x2.03x2.5	9.48x2.24x3.0	9.5x2.24x3.3	9.6x2.24x3.3	9.6x2.24x3.0	10.4x2.32x3.0	10.7x2.32x3.0	11.3x2.5x3.0	11.8x2.5x3.0

LISONG力松®

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桶体经典应用
Application of chemical barrel

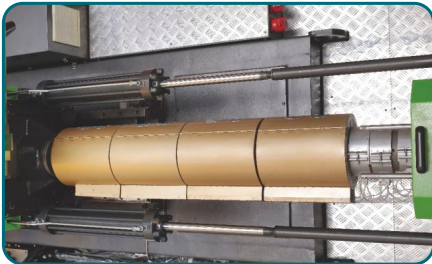


品名 Item	规格 (口*底*高) size	腔数 Cavity number	壁厚 Wall thickness	克重 weight	材料 Material Science	成型周期 Inj. Molding Cycle	适配机型 Model description
	[mm]	No.	[mm]	[g]		[s]	
10L	258*228*265	1	1.5	400	K8003	14.3	LS458/720GT
		2		800	K8009	15	LS550/770GT
		2		800	K8003	15.8	LS800/1000GTHe
20L	305*270*365	1	1.85	800	K8009	22	LS550/770GT
		1		800	K8003	19.7	LS650/900GTe
		1		800	K8003	18	LS780/960GTe
		2		1600	K8003	21.9	LS1000/1120GTe
33L	350*310*400	1	2	1020	K8003	22.5	LS800/1000GTe

桶盖应用
Application of chemical barrel cover



品名 Item	规格 size	腔数 Cavity number	壁厚 Wall thickness	克重 weight	成型周期 Inj. Molding Cycle	适配机型 Model description
	[mm]	No.	[mm]	[g]	[s]	
10L	ø280	1	1.6	140	14.8	LS220/530GT
		2		280	15.6	LS290/630GT
20L	ø325	1	2	245	20.2	LS290/630GT
		2		456	21.3	LS290/630GT
33L	ø385	1	2.15	296	23	LS290/630GT



注塑 Injection Unit

- 1.专用大L/D比高塑化螺杆。
 - 2.起速快，精度高，射速高。
 - 3.模块化设计，直驱电熔胶（节能，高效）高速伺服比例阀及氮气辅助注塑，均可自由选配。
- Dedicated screw with large L/D ratio and high plasticization.
 - Dedicated screw with large L/D ratio and high plasticization.
 - Modular design, direct drive electro-melt (energy-saving, high-efficiency) high-speed servo proportional valve and nitrogen-assisted injection molding, which can be freely optional selected.



油路 Oil Path Structure

- 1.零渗油设计，油制块工艺孔采取平面螺堵密封，外置管路无焊接联接。
 - 2.大品牌油压配件，稳定高效。
 - 3.多组伺服动力配置，适应多组同步运行，高效，节能，油泵内置，恒温运行寿命更长且低噪音。
- Zero oil leakage design, the process hole of the oil block is sealed with a plane screw plug, and the external pipeline has no welding connection.
 - Famous brand hydraulic accessories which is more stable and efficient.
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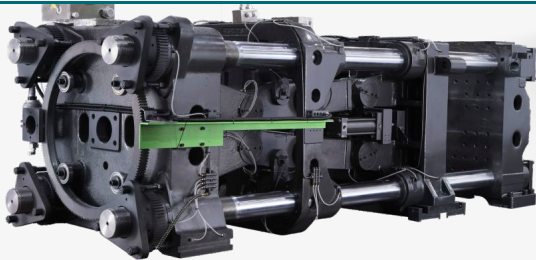


New
servo
motor

桶机专用注塑机 结构优势

Advantages

- ✓ 合模，模板变形小，更易成型
- ✓ 反应敏捷
- ✓ 低漏油概率



锁模 Clamping Unit ★★★★★

- 1.高刚性机械直锁结构，成型锁模力更低，使模具使用寿命更长，能耗更低。
 - 2. 开合模标配高速伺服比例阀，定位准，效率高。
 - 3. 双缸顶出，脱模稳定高效。
- High-rigidity mechanical direct-locking structure, molding clamping force becomes less, longer mold service life and lower energy consumption.
 - The opening and closing molds are equipped with high-speed servo proportional valves as standard, with which accurate positioning and high efficiency.
 - Double cylinder ejection, stable and efficient demolding.



控制器 Controller

- 1.软件优化，操作界面人性化。
 - 2.MES联网（可选）。
- Software optimization and humanized operation interface.
 - MES networking (optional).

机架 Framework ★★★★★

- 1.高刚性设计，回火，表面喷塑处理。
 - 2.加大落料口，适应制品直接脱落捡取。
- High rigidity design, tempering, surface plastic spray treatment.
 - To be enlarged the blanking opening to adapt to the direct fall off and picking of products.