



聚本机械制造（深圳）有限公司

Juben Machinery Manufacturing (Shengzhen) Co./Ltd

双色注塑方案

Two color injection solution



副射台
Injection Unit

+



转盘
turntable

=



双色注塑机
Two-color equipment

多色成型工艺: Polychrome forming process:

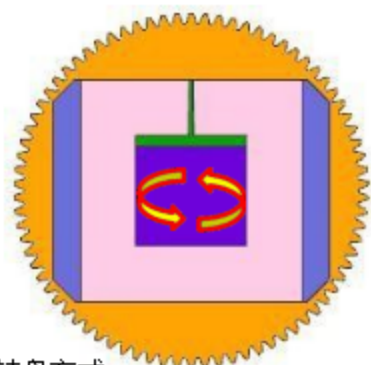
通过增加副射台实现多色成型射出: Multi - color injection molding is realized by adding a secondary ejector.

(注: 射台的射胶顺序可根据实际使用作调整)

(note: the injection sequence of the ejector can be adjusted according to the actual use)

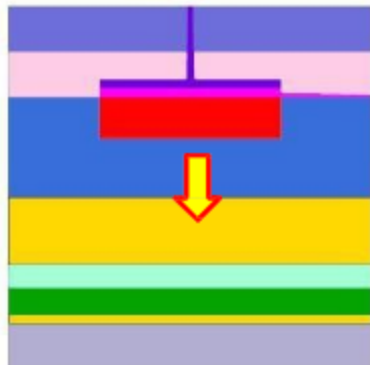


多色成型方式: Multi-color forming method:



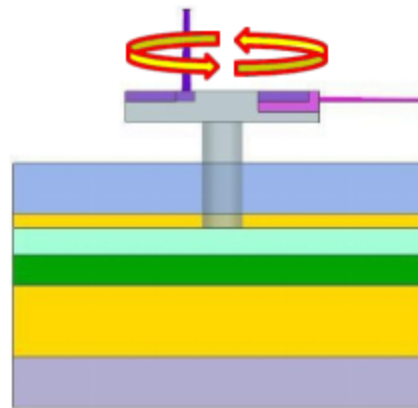
转盘方式:
啤机动模侧增加转盘, 动模整体旋转; 实现双色、多色成型

Turntable mode:
Add turnplate to injection molding machine side,
Integral rotation of moving die; Double - color, multi - color forming



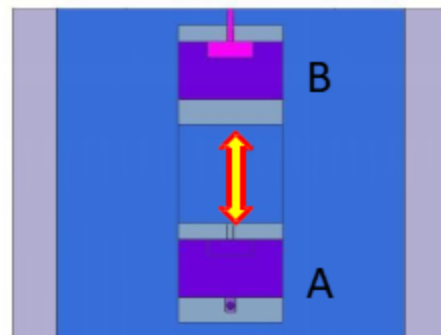
抽芯方式:
模具设计抽芯结构, 一射完成后抽芯再进行第二射; 实现双色、多色成型

Core pulling mode:
Die design core pulling structure, one shot after the core pulling and the second shot; Double - color, multi - color forming



托转方式:
模具设计托转结构, 一射完成后开模托转再进行第二射; 实现双色、多色成型

Transfer mode:
Mould design supporting structure, after the first shot is completed, the second shot is carried out. Double - color, multi - color forming



滑板方式:
模具设计滑板结构, 一射完成后开型腔由A区滑动到B区再进行第二射; 实现双色、多色成型

Skateboarding mode:
Die design skateboard structure, after the first shot is completed, the cavity slides from zone A to zone B for a second shot. Double - color, multi - color forming

电动副射台 Injection unit

电动副射台：根据生需求定制合适的射胶量，最大射胶量约为245g；副射台配备独立的控制系统；可与任何注塑机连接，主机无须作出改造，只需提供一组中子信号即可，使用灵活、简单。

由于射台的锁定设计不同；在订购时请确定副射台的安装方向（天侧或反操作侧）；

操作系统摆放在相近的地面，配备了活动轮子，移动时更加方便；

控制单元配备5米长电缆，方便在任何位置摆 放。

Injection unit: Originated from European and American design technology; Customize the appropriate amount of injection according to the production demand, the maximum amount of injection is about 245g; The auxiliary firing platform is equipped with independent control system. Can be connected with any injection molding machine, the main machine does not need to be modified, only to provide a set of neutron signals can be used flexibly and simply.

Locking design of the firing platform is different. Please confirm the installation direction of the auxiliary firing platform (day side or opposite side) when ordering; The power system is placed on similar ground, equipped with moving wheels, which makes it more convenient to move.

Control unit is equipped with a 5m-long cable for easy placement in any location.



标准型电动副射台技术参数表

Technical parameters of standard electric injection unit

型号Model	单位/unit	TB-18		TB-24			TB-30		
螺杆直径Screw diameter	mm	18	20	22	24	26	28	30	32
理论注射压力Injection pressure	bar	2306	2300	2300	2300	2160	2100	2000	1950
注射行程Injection stroke	mm	60		100			130		
理论注射速度Injection speed	mm/s	300		300			300		
最大注射容量Injection volume	g	16	20	40	48	57	85	98	110
螺杆转速范围Screw speed	rpm	1-500		1-500			1-500		
射嘴接触力Nozzle contact force	KN	90		90			90		
安装总功率Power	KW	23kw		23kw			23kw		
机器重量Weight	KG	约900		约1000			约1200		
型号Model	TB-36			TB-40			TB-45		
螺杆直径Screw diameter	mm	34	36	38	38	40	42	42	45
理论注射压力Injection pressure	bar	1950	1860	1860	1860	1800	1690	1690	1600
注射行程Injection stroke	mm	130			150			150	
理论注射速度Injection speed	mm/s	250			230			230	
最大注射容量Injection volume	g	120	135	150	174	193	213	213	245
螺杆转速范围Screw speed	rpm	1-300			1-300			1-300	
射嘴接触力Nozzle contact force	KN	90			90			90	
安装总功率Power	KW	30kw			30kw			30kw	
机器重量Weight	KG	约1300			约1500			约1500	

电动副射台 Injection unit

技术特征 Technical features

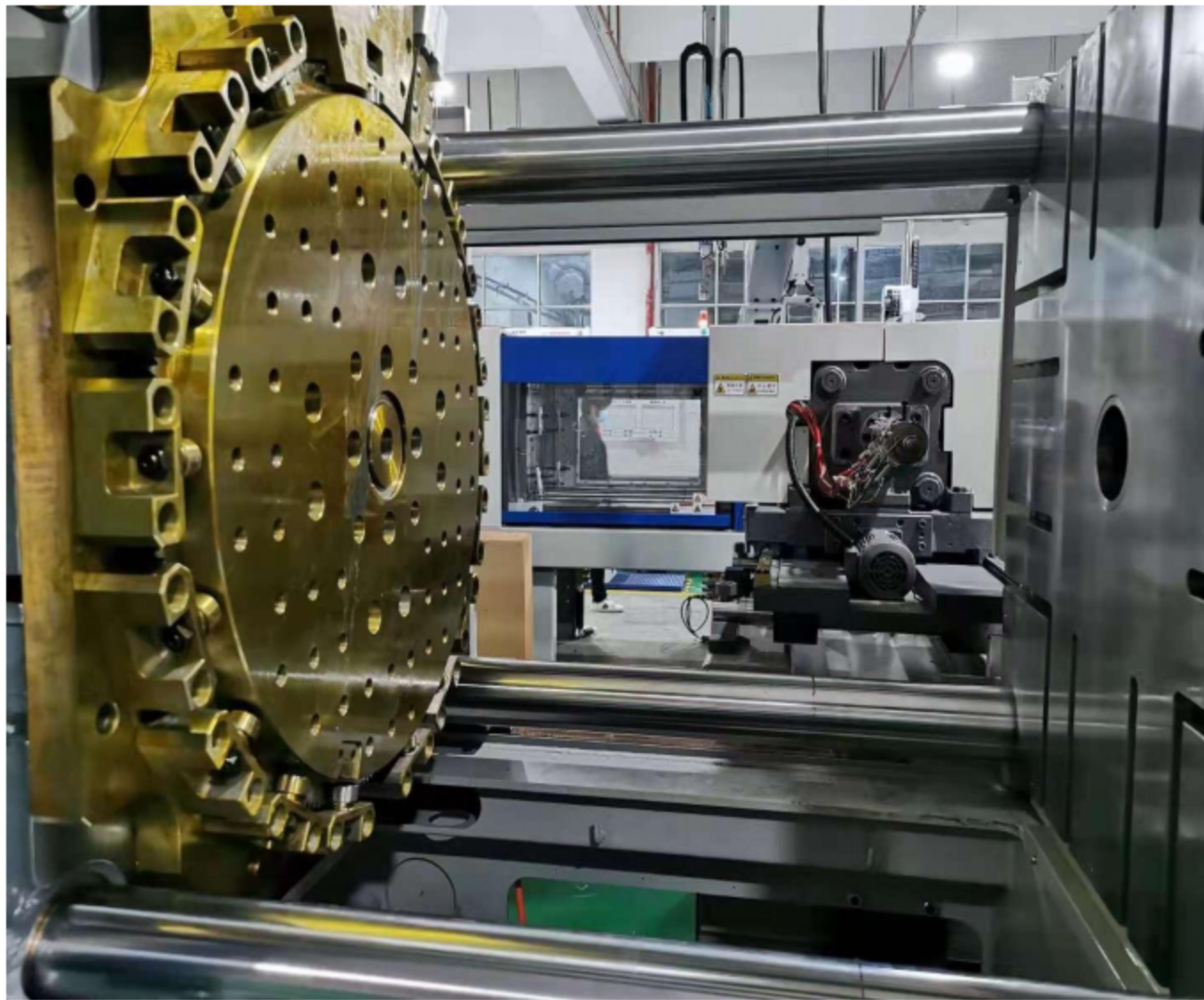
- 闭环注射的速度和压力控制
Closed loop injection speed & pressure control;
- 闭环背压控制
Closed loop back pressure control
- 3段保压功能控制
3 pack/hold pressures;
- 保压转换可选时间/位置//压力等模式
Pressure maintaining transfer to an optional time/position/pressure mode
- 可根据客户的需要配备料筒螺杆
Screw barrel can be customized
- 标准Euromap67接口或Euromap12接口
Standard Euromap67 interface or Euromap12 interface
- 温度PID控制
Temperature PID control
- 人性化多功能人机界面，操控方便
Humanized multifunctional human - machine interface, easy to operate
- 可选进口电子配件及动力系统
Optional import of electronic accessories and power systems
- 可快速与任何品牌注塑机连接
Quick connection to any brand injection molding machine
- 成本低、高灵活性的双色多色成型方案
Low cost, high flexibility of the two-color polychromatic molding scheme



副射台样式
Sup-shot style



使用案例：
成型机+TB-24副
射台=双色机



使用案例：
副射台使用中 In use of the projectile



伺服转盘Hydraulic/servo turntable

转盘通过安装在单色成型机上，帮助模具动模侧旋转；

turntable is installed on the monochrome forming machine to help the die rotate on the dynamic die side.

伺服马达驱动（特定配置） Servomotor drive (select configuration)

旋转方向Rotation direction:两工位two working $0^{\circ}\sim 180^{\circ}\sim 0^{\circ}$

三工位Three working $0^{\circ}\sim 120^{\circ}\sim 240^{\circ}\sim 360^{\circ}$

四工位Four working $0^{\circ}\sim 90^{\circ}\sim 180^{\circ}\sim 270^{\circ}\sim 360^{\circ}$

我们将为您提供标准的选型（如下页所示）；同时，我们也可以根据您机台的实际参数作出定制，更贴合您的实际使用；

We will provide you with a standard selection (as shown on the following page). At the same time, we can also customize it according to the actual parameters of your machine, which is more suitable for your actual use.

转盘的优点Advantages of turntable:

节省管理成本Save management costs

安装费用低Low installation cost

增加了设备的灵活性

Increased flexibility of equipment

提高设备的生产效率Improve the production efficiency of equipment

维护成本低Low maintenance cost

安装、使用简易Easy to install and use

独立运水装置Independent water transport device:

水轴芯无载重设计，避免密封件产生泄漏Water shaft core has no load design to avoid leakage of seals

分体式镶件设计，便于拆装和保养Split type insert design, easy to disassemble and maintain

十分低的摩擦系数有利于减少磨损Very low friction coefficient is beneficial to reduce wear

低磨损长寿命密封圈Low wear and long life sealing ring

优良的抗腐蚀材料Excellent corrosion resistant material

按机型适配伺服ic/servo turntable
驱动转盘Hydraul



双色成型成功案例的部分产品

Dual color molding, successful case product display

主机+副射台+转盘；
实现后模整体旋转，
双色成型Main engine +
auxiliary platform + turntable
Realize the overall
rotation of the
back mold, two- color
forming



主机+副射台
+转盘；
实现后模整体旋转，双
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主机+副射台+
模芯托转；实
现双色成型
Main engine +
auxiliary ejector +
die core
support, Double
color forming is
realized



主机+副射台+
后模抽芯；实
现双色成型
Main engine +
auxiliary ejector +
core pulling of rear
die; Double color
forming is realized

双色成型成功案例的部分产品

Dual color molding, successful case product display



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