

www.china-rijin.com



热固性注塑
THERMOSETTING INJECTION
MOLDING MACHINE



宁波日进机械有限公司
NINGBO RIJIN MACHINERY CO., LTD

地址:中国浙江省宁波市, 庄市工业B区, 庄市大道288号
Add:NO.288 Zhuangshi Road,Zhuangshi Industrial
DistrictB, Ningbo,Zhejiang,China .

电话 (Tel): +86-574-55336212
传真 (Fax) +86-574-55336218
邮编 (P.C): 315212
邮箱 (E-mail) : sales@china-rijin.com

RT系列
热固性射出成型机

RT SERIES
THERMOSETTING INJECTION
MOLDING MACHINE

热固性注塑技术

THERMOSETTING INJECTION MOLDING TECHNOLOGY

热固性注塑，其实与热塑性成型工艺基本相同，但是参数和成型条件不同，注塑单元基本上完全算是计量单元，主要因素是热固性塑料本身的特性决定的，热固性塑料最大的特点是不可逆性，因为热固性塑料是网状分子结构，这种结构可以说是永久性结合，如果分子结构破坏，不可逆性结合不会断开，所以热固性塑料，不能热变形，仅有弹性，不能熔解，不易反应。这种特性，也导致很多热固性产品的不可替代，但目前随着环保、能源的大环境要求，各国也在努力寻找新型材料，替代不可逆。

Thermosetting, in fact, and thermal plastic molding process is basically the same, but different parameters and molding conditions, injection unit only the unit of measurement, the main factors are determined properties of thermosetting plastics. thermosetting plastics biggest characteristics is irreversible, because for thermosetting plastic mesh molecular structure, this structure is in permanent connection. If the molecule structure destruction, irreversible binding does not disconnect, so the thermosetting plastic, not hot deformation, only elastic, not melting, easy response. This feature, also led to a lot of thermosetting products can not be replaced, but at present with the environmental protection, energy and environment requirements, the country is also trying to find new materials, alternative irreversible.



日进热固性成型机，主要有电木和BMC两个产品系列。与传统热固性注塑机相比，日进热固性成型机的注塑产品具有高致密度，废品少等优点。

适用范围，日常生活耐热、耐腐蚀用品、电讯、电器绝缘零件、汽车车灯等。

R ijin thermosetting injection molding machine, mainly has bakelite and BMC two series. Compared with the traditional thermosetting injection molding machine, the Rijin injection molding products has the advantages of high density, less waste and soon.

Scope of application, daily life heat, corrosion products, telecommunications, electrical insulation parts, car lights, etc..

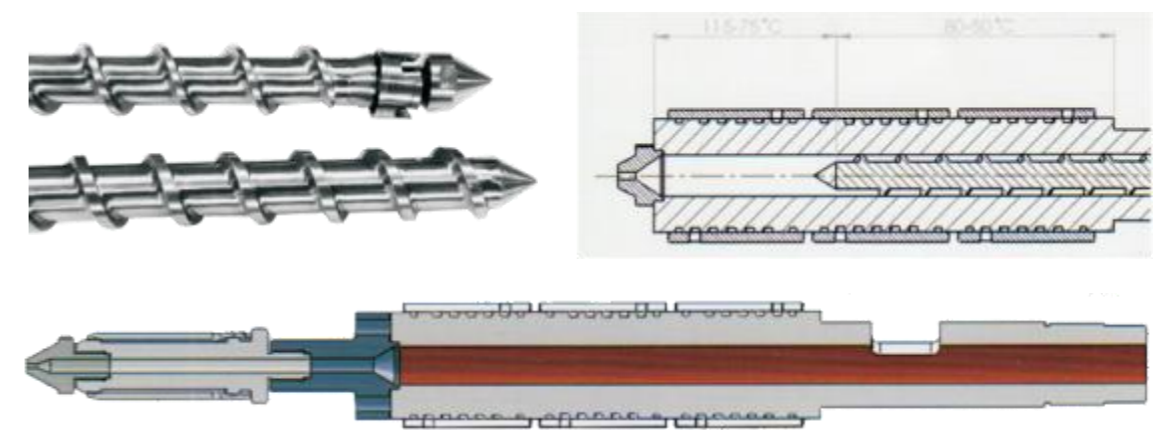
主要技术特性:

专业的料筒螺杆组模块，双金属材质，电木专用合金射嘴和BMC加长专用冷却射嘴。
液体恒温控制和独立的射嘴温控。

Main technical characteristics:

Barrel and screw module professional, double metal, alloy special bakelite nozzle and BMC special cooling nozzle extension.

Liquid temperature control and independent nozzle temperature control.



自动送料系统(无损输送)，专用的电木和BMC自动无损送料，实现自动化，特别是BMC的湿式团状材料的无损送料，可以便于清料，以及在送料过程中的最佳预压缩，利于成型，减少纤维损伤。
排气，专业的排气控制，可以选择多种排气方式，简化生产过程，降低能耗。

Automatic feeding system (lossless transmission), dedicated bakelite and BMC automatic nondestructive feeding, automation, especially the BMC wet dough material nondestructive feeding, easy to clean material, and in the feeding process and the optimum pre compression, for molding, reduce fiber damage.

Exhaust, professional exhaust control, you can choose a variety of exhaust, simplify the production process, reduce energy consumption.

热固性注塑技术-电木

THERMOSETTING INJECTION MOLDING TECHNOLOGY- BAKELITE

电木专业料筒螺杆组，采用双金属材料，持久耐用;良好的塑化设计，和专业的注射系统，电木产品高致密度，高强度。

电木专用程序，如专业排气设计，射后锁模，定时加热等。料筒专用的独立温控装置。温度准确，温控迅速，效率高。

独立的热模温控盒，方便接线，和维护，也可以定制独立的温控柜。耐高温高压的隔热板设计，强度高，隔热好。



Specialized in bakelite barrel screw group, using double metal material, durable ; good plasticizing design, professional and injection system , bakelite products high density and high strength .

Bakelite special procedures, such as professional exhaust design, after injection mould clamping, timing heating etc..

The independent temperature control device, which is specially used in the barrel , is accurate in temperature, quick in temperature control and high in efficiency .

Independent thermal mold temperature control box, convenient connection, and maintenance, can also be customized independent temperature control cabinet .

Heat-resisting and high pressure resistant insulating board design, high strength, good thermal insulation.



RJ 系列电木机参数

技术规格参数表 SPECIFICATIONS

说明	DESCRIPTION	单位	RJ140U	RJ170U	RJ200U	RJ240U	RJ280U	RJ360U	RJ400U	RJ450U	RJ530U
螺杆直径	Screw Diameter	mm	40	48	50	60	65	75	75	80	90
理论射胶容积	Theoretical shot volume	cm ³	262	407	471	763	915	1415	1723	1965	2487
注射重量	Shot weight	g	285	448	518	839	1007	1557	1895	2250	2750
注射压力	Injection Pressure	Mpa	179	177	160	168	172	160	152	168	158
锁模系统			CLAMPING UNIT								
锁模力	Clamping Force	kN	1400	1700	2000	2400	2800	3600	4000	4500	5300
开模行程	Opening Stroke	mm	380	435	440	475	550	670	725	740	850
拉杆内间距	Space between tie bars	mm	420 × 420	470 × 470	480 × 480	520 × 505	580 × 580	730 × 670	730 × 730	770 × 770	870 × 820
最大模厚	Max. mold Height	mm	450	520	525	530	580	680	740	780	830
最小模厚	Min. mold Height	mm	160	180	180	200	200	250	320	320	330
顶出行程	Ejector Stroke	mm	120	135	140	140	150	160	160	200	200
顶出力	Ejector Force	kN	46	46	62	62	62	70	79	110	150
其他			GENERAL								
系统压力	System Pressure	Mpa	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5
电机功率	Pump Motor	kW	13	15	18.5	18.5	22	30	37	45	55
电热功率	Heating Capacity	kW	6	12	12	12	12	12	12	12	12
外形尺寸	Machine Dimension	m	4.65 × 1.26 × 1.92	5.18 × 1.35 × 2.1	5.3 × 1.56 × 2.26	5.7 × 1.52 × 2.3	6.2 × 1.68 × 2.3	7.3 × 1.8 × 2.5	7.4 × 1.9 × 2.5	8.3 × 1.9 × 2.5	8.8 × 2.2 × 2.6
油箱容积	Hopper Capacity	L	160	185	225	225	265	550	550	650	800
机器重量	Machine Weight	t	4.4	5.6	6.5	7	8.5	14	15	18	26

本公司保留修改技术参数的权利，如有更改，恕不另行通知。
We reserve the right to make changes as a result of further technical advantages.

RS 系列电木机参数

技术规格参数表 SPECIFICATIONS

RS110U	RS150U	RS200U	RS250U	RS300U	RS320U
35	48	55	65	65	70
155	397	546	996	996	1154
170	433	595	1085	1085	1258
185	173	153	165	165	178
CLAMPING UNIT					
1100	1500	2000	2500	3000	3200
345	380	460	520	550	600
370 × 370	420 × 380	520 × 470	570 × 520	630 × 580	660 × 630
380	450	550	550	650	650
150	150	180	200	230	280
110	120	140	145	150	180
38	38	58	77	77	77
GENERAL					
17.5	17.5	17.5	17.5	17.5	17.5
11	15	22	22	22	30
6	12	12	12	12	12
4.2 × 1.26 × 1.92	4.65 × 1.26 × 2	5.18 × 1.4 × 2	5.7 × 1.52 × 2.3	6.3 × 1.8 × 2.3	6.4 × 1.9 × 2.5
135	170	215	215	350	450
3	4	5.2	7.5	12	12

热固性注塑技术——BMC THERMOSETTING INJECTION MOLDING TECHNOLOGY- BMC

BMC专用料筒螺杆组设计，耐腐蚀，耐磨，专业的塑化段设计，加料顺畅，计量准确，易清料，减少对玻纤的损害。

自动填料装置，快速，准确。

大机器配备填料平台楼梯，方便加料。

专用的独立温控系统，温控准确，高效。

耐高温高压的隔热板设计，强度高，隔热好。

BMC special barrel and screw group design, corrosion resistance, abrasion resistance, plasticizing design, professional feeding smooth, accurate measurement, easy to clean material, reduce the damage of glass fiber.

Automatic packing device, fast and accurate .

Large machine with charging platform, convenient feeding .

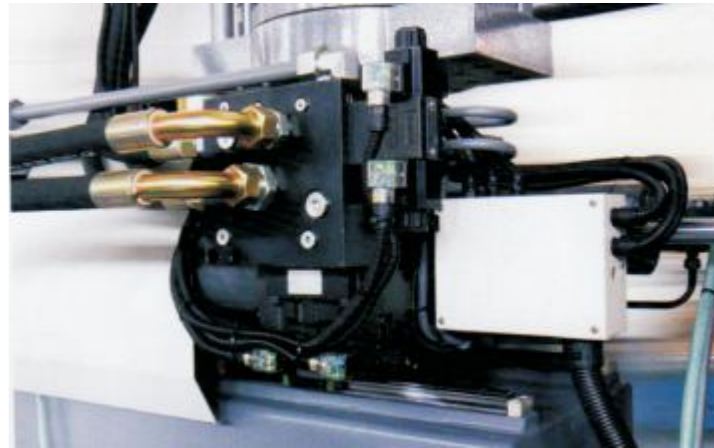
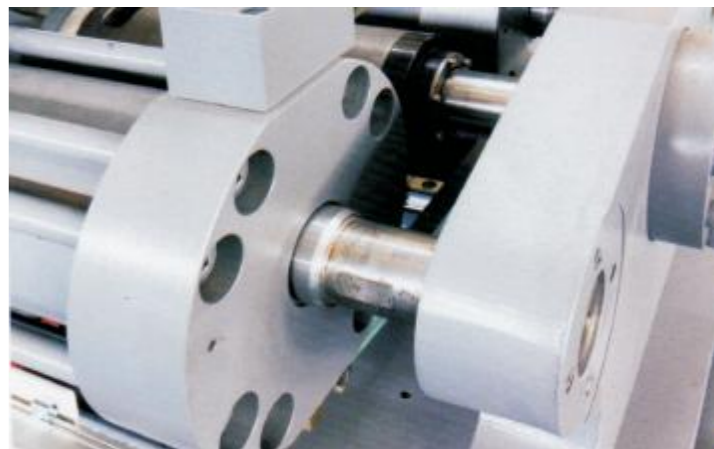
Independent temperature control system for temperature control, accurate, efficient .



RJ 系列BMC机射出机参数

技术规格参数表 SPECIFICATIONS

说明	DESCRIPTION	单位	RJ140BMC	RJ170BMC	RJ200BMC	RJ240BMC	RJ280BMC	RJ330BMC	RJ380BMC	RJ470BMC	RJ530BMC
注射装置	INJECTION UNIT										
螺杆直径	Screw Diameter	mm	42	48	50	60	65	70	75	75	80
注射容积	Shot volume	cm ³	291	434	471	763	1028	1346	1722	1722	1959
注射重量	Shot weight	g	494	738	801	1297	1748	2289	2928	2928	3331
注射压力	Injection Pressure	Mpa	177	157	160	168	172	160	162	162	168
锁模系统	CLAMPING UNIT										
锁模力	Clamping Force	kN	1400	1700	2000	2400	2800	3300	3800	4700	5300
开模行程	Opening Stroke	mm	380	435	440	475	550	660	700	740	770
拉杆内间距	Space between tie bars	mm	420 × 420	470 × 470	480 × 480	520 × 505	580 × 580	660 × 660	720 × 700	770 × 770	820 × 780
最大模厚	Max. mold Height	mm	450	520	525	530	580	680	780	780	810
最小模厚	Min. mold Height	mm	160	180	180	200	200	240	250	250	330
顶出行程	Ejector Stroke	mm	120	135	140	140	150	160	160	200	200
顶出力	Ejector Force	kN	46	46	62	62	62	62	79	110	150
其他	GENERAL										
系统压力	System Pressure	Mpa	16	16	16	16	16	16	16	16	16
电机功率	Pump Motor	kW	13	15	18.5	22	22	37	45	45	55
外形尺寸	Machine Dimension	m	4.65 × 1.26 × 2.5	5.18 × 1.35 × 2.6	5.3 × 1.56 × 2.62	5.7 × 1.53 × 2.6	6.2 × 1.68 × 2.6	6.92 × 1.9 × 2.8	7.4 × 1.9 × 2.8	8.1 × 2.05 × 2.8	8.1 × 2.05 × 2.8
油箱容积	Hopper Capacity	L	160	185	225	225	265	500	540	640	800
机器重量	Machine Weight	t	5.4	6.3	7.3	8.5	9.5	13.2	16	18	23



如有高强度BMC注射要求，请向公司索取资料。

本公司保留修改技术参数的权利，如有更改，恕不另行通知。

We reserve the right to make changes as a result of further technical advantages.