



中国营销网络 Domestic sales network

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青岛办	青岛市崂山区东岸风度小区50号楼2单元902户
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大连办	大连市甘井子区市华西路70号A2-701
沈阳办	辽宁省沈阳市皇姑区黄河北大街282-6号1单元9楼1门
长春办	吉林省长春净月开发区花园一期18栋乙单元407室
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中山办	中山市西区翠华路翠景花园翠景湾7幢803房
东莞办	佛山市顺德区大良街道红岗村105型道旁
广西办	柳州市白云小区3村10幢204室
厦门办	厦门市思明区仙岳路580号心树园24A
福州办	福州市晋安区远洋路69号日出东方22#103室
泉州办	福建省泉州市丰泽区少林路东祥景苑2号楼A栋301室
莆田办	福建省莆田市涵江区东港别墅31号二楼
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成都办	成都市青羊区6号土塔花园5幢1单元3楼59号(519)
昆明办	云南省昆明市官渡区海花国际13号地块10栋2806
西安办	陕西省西安市雁塔区公园南路阳光丽都3号楼3单元30402室
重庆办	重庆市九龙坡区云澜路1号光华风和日丽2-41-5
贵州办	贵州省贵阳市金阳新区中天帝景传悦A2-4-1栋2单元201室
武汉办	武汉市沌口经济技术开发区博学路博学华庭4栋2单元1606室
长沙办	湖南省长沙市岳麓区杜陵路99号天骄福邸10栋1单元12楼1203号
南昌办	江西省南昌市南昌县恒大城39栋1单元3202室

6091-1899 印 中 册



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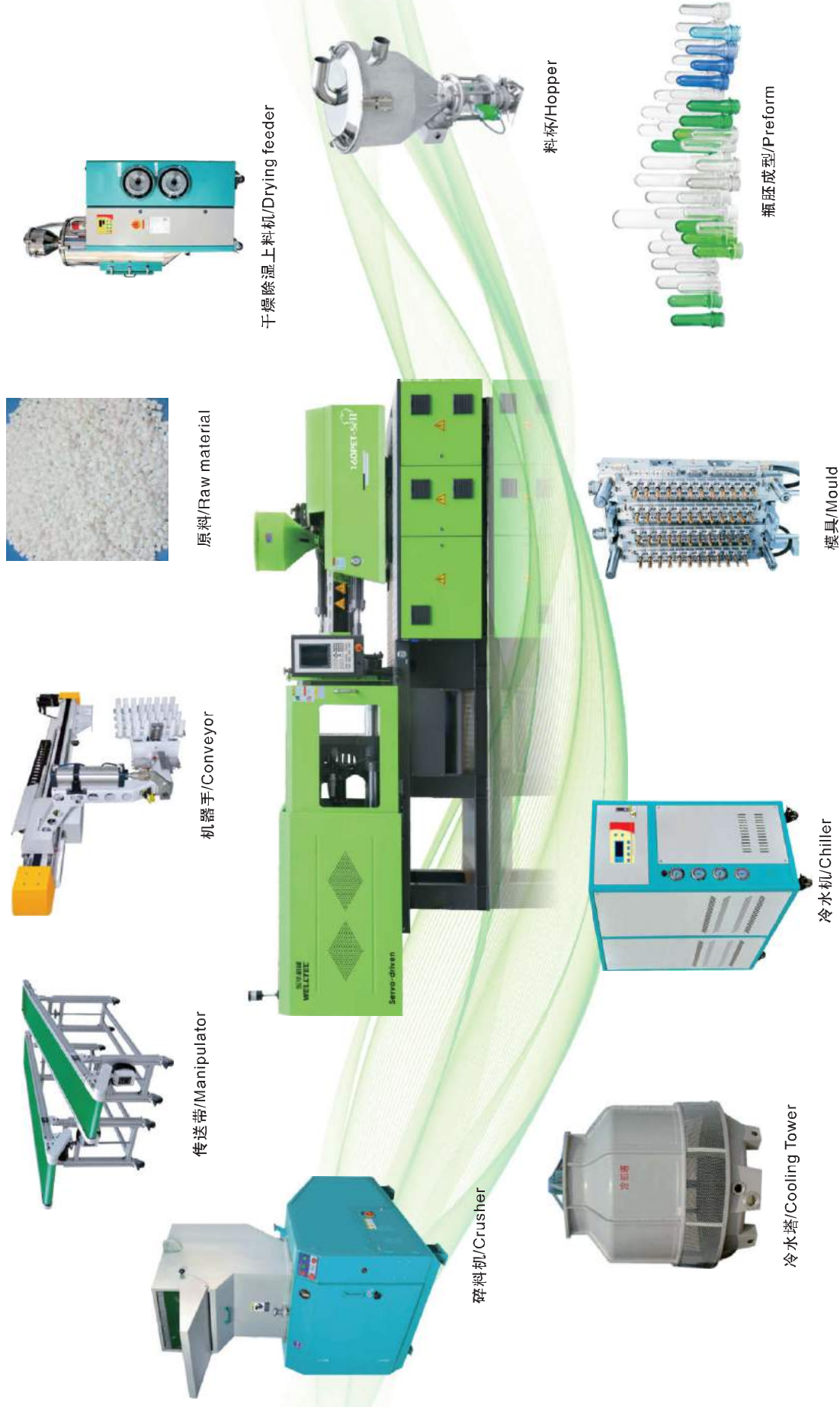
大同机械(东莞)销售有限公司
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为PET注塑而生!

Special inject for PET

PET瓶胚注塑系统 成型工艺示意图

PET Preform Injection Moulding System / Process Diagram



主要特点/Main Features



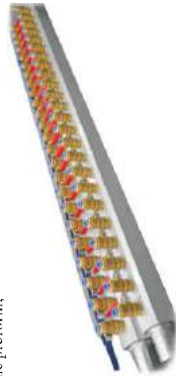
特大射胶量/Large injection volume:
大直径螺杆，加大射胶行程，射胶量较常规机增加约50%；
Large screw with large injection stroke, its injection volume is about 50% larger than the standard model;



高效专业螺杆/Efficient professional screw:
低剪切及大长径比设计，塑化效率提高30%以上，同时有效降低产品AA值；
Low shear, and large length to diameter ratio design. Plasticizing efficiency increased by more than 30%, at the same time reduce the AA value of the product;

大力顶针设计/Strong thimble ejector design:
顶针力较普通机加大约40%，顶针行程较普通机加大10~40mm；
Thimble ejector force is about 40% higher than ordinary standard machine, thimble ejector stroke is 10~40mm larger than ordinary standard machine;

大管多组水排/Large and multi-group water channels:
配备15~23组模具冷却水排，缩短冷却时间，提高瓶胚透明度；
Equipped with 15 to 23 groups of mould cooling water channels, shortening the cooling time and improving the transparency of the preform;



大扭矩马达/High torque oil motor:
持续稳定输出高扭矩，满足PET高速熔胶需要；
Continuously and stably output high torque to meet the needs of PET high-speed plasticizing

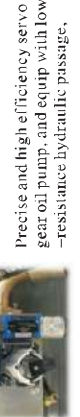
卓越塑化效果/Excellent plasticizing effect:
可确保普通瓶胚的高透明度，原料中添加色母或色粉或色油时可着色均匀，原料中添加较大比例的回料仍能均匀塑化；

It can ensure the high transparency of ordinary preforms. When adding color masterbatch or toner or color oil to raw materials, the color can be mixed evenly. Uniform plasticization, even with a comparatively large proportion of recycled materials in the raw material.

稳定精密注射/Stable precise injection:
耐磨精密三小件，搭配原装进口精密电子尺；
Wear-resistant precision components, with imported precision ruler precise transducer;

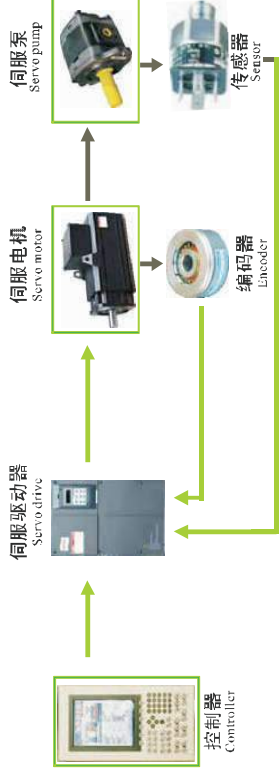


优异节能效果
Excellent energy-saving effect:
精密高效伺服齿轮油泵，匹配低阻力液压通路，较传统机型省电25~60%，同时减低液压系统发热；
Precise and high efficiency servo gear oil pump, and equip with low resistance hydraulic passage, saving 25 to 60% energy compared with traditional models, and reducing heat generating in hydraulic system;



Se II 系列伺服液压控制原理

Se II series hydraulic servo control principle



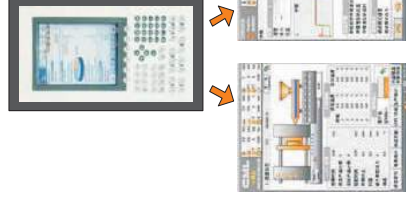
S09 精明控制系统

S09 Smart Control System

软件及功能 Software & Functions

欧洲进口贝加莱专业注塑机控制系统
European imported from Beck Automation, professional control system for injection moulding machine

- 10.4" TFT彩色液晶显示屏
- 参数更改记录，客户可以在界中知道谁人更改参数及参数改变的数值
- 品质管理统计参数记录，确认机器的稳定性
- 自动调节温度PID参数
- 模具参数可记录于U盘处，并可在其它机台使用
- 使用MODEM或以太网远程控制机台参数及程序
- 多种语言文字显示
- 10.4" TFT colour LCD display
- Parameter change logging, user can know who change the data and the scope of data changed
- Quality control statistical process data, proves the stability of machine
- Auto-tune temperature control PID value
- Mould data can save on USB memory and copy to another injection machine
- Utilize MODEM or Ethernet to remote monitor the moulding data and sequence
- Multi-languages text display



iSe II 远程监控软件允许客户自由的在任意地区及任何时间观察机器的画面显示，查询机器的状态及获得机器的质量报告，显示内容与亲身在车间现场查看的相同。(可选)

iSe II facilitates the customer to see exactly the instant status of machine and get the quality report from the machine from any place at any time. (Optional)

PET伺服泵参数

PET servo pump parameters

项目	Item	单位	160PET-Se II	190PET-Se II	260PET-Se II	260PET-Se II
国际标准规格	International specification	UNIT	1600-720	1900-980	2600-1280	2600-1660
注射单元 INJECTION UNIT					标准/Standard	大注射量/Large
螺杆直径	Screw diameter	mm	55	60	65	75
理论射胶容积	Theoretical shot volume	cc	594	783	995	1458
射胶量(PET)	Shot weight (PET)	g	583	901	1145	1677
射胶量(PET)	Shot weight (PET)	oz	24.1	31.8	40.4	59.1
螺杆长径比	Length/Diameter ratio	L/D	24	24	24	24
射胶压力	Injection pressure	MPa	121	126	129	114
射胶速率(PET)	Injection rate(PET)	g/s	295	360	405	502
射胶行程	Injection stroke	mm	250	277	300	330
螺杆转速	Max. screw speed	rpm	185	177	163	127
熔胶率(PET)	Plasticizing capacity (PET)	g/s	54.7	65.9	72.6	108.6
锁模单元 CLAMPING UNIT						
锁模力	Clamping force	Ton	160	190	260	260
模板最大间距	Max. daylight	mm	1006	1100	1130	1130
锁模行程	Clamping stroke	mm	446	490	550	550
四柱间距	Distance btwn. Tie bars	mm	460X460	510X510	580X580	580X580
最小模具尺寸	Min mould dimension	mm	320x320	350x350	400X400	400X400
套筒量	Mould thickness range	mm	150-560	175-610	200-580	200-580
顶针力	Ejector force	ton	6.5	8.5	10.8	10.8
顶针行程	Ejector stroke	mm	140	150	175	175
顶针数	No. of ejector pins	unit	5	5	9	9
动力/电热 POWER UNIT						
主马达功率	Major motor	kW	23	31.4	32	32
系统压力	System pressure	MPa	17	17	17	17
加热区	No. of heater zones	unit	4+1+1	5+1+1	5+1+1	5+1+1
电热功率	Heater input power	kW	18.94	22.54	24.54	34.93
总功率	Ultimate capacity	kW	42.94	54.94	57.54	67.93
总电流	Current	A	58.7	75.1	78.7	92.9
其他 GENERAL DATA						
外形尺寸(长宽高)	Machine dimensions(LxWxH)	m	5.3x1.4x1.8	5.6x1.5x1.8	6.0x1.6x2.0	6.6x1.6x2.0
机器重量	Net weight	ton	5.5	6.8	8.6	8.8
注油量	Oil filling capacity	L	300	330	450	450

320PET-Se II	320PET-Se II	380PET-Se II	380PET-Se II	450PET-Se II	500PET-Se II	660PET-Se II	260PET-Se II	380PET-Se II
3200-1660	3200-2780	3800-2780	3800-3700	4500-3700	5000-4620	6600-4620	2600-1080	3800-2280
标准/Standard	大注射量/Large	标准/Standard	大注射量/Large				薄壁PET专用/Thin-wall PET Products	
75	85	85	94	94	105	110	55	70
1458	2270	2270	3019	3019	3810	4181	603	1262
1677	2610	2610	3472	3472	4381	4809	694	1452
59.1	92.1	92.1	122.5	122.5	154.5	169.6	24.5	51.2
24	24	24	24	24	24	24	24	24
114	122	122	123	123	121	111	180	180
627	732	732	730	730	1210	1328	498	497
330	400	400	435	435	440	440	254	328
133	122	122	102	102	127	124	260	167
114.1	140.0	140.0	139.4	139.4	207.6	247.9	69.8	83.6
薄壁PET专用/Thin-wall PET Products								
320	320	380	380	450	500	660	260	380
1275	1275	1450	1450	1560	1640	1830	1130	1450
615	615	710	710	740	820	910	550	710
660X660	660X660	740X740	740X740	825X825	920X920	920X920	580X580	740X740
460X460	460X460	510X510	510X510	540X540	570X570	645X645	400X400	510X510
250-660	250-660	250-740	250-740	300-820	300-820	350-920	200-580	250-740
13.4	13.4	16.2	16.2	19.2	19.2	22.6	10.8	16.2
200	200	212	212	260	260	300	175	212
13	13	13	13	13	13	21	9	13
薄壁PET专用/Thin-wall PET Products								
45	56.5	56.5	56.5	56.5	94.2	94.2	56.5	56.5
17	17	17	17	17	17	17	17	17
5+1+1	5+1+1	5+1+1	5+1+1	5+1+1	5+1+1	5+1+1	5+1+1	5+1+1
84.93	45.93	45.93	45.85	45.85	57.93	61.73	19.52	31.53
80.93	103.43	103.43	103.35	103.35	153.13	156.93	77.02	89.03
110.7	141.4	141.4	141.3	141.3	209.4	214.6	105.3	121.7
薄壁PET专用/Thin-wall PET Products								
6.9x1.7x2.0	7.6x1.7x2.0	8.2x1.8x2.1	8.6x1.9x2.1	8.9x1.9x2.1	9.6x2.1x2.2	10.0x2.1x2.3	5.9x1.6x2.0	7.7x1.8x2.1
11	11.5	15	15.4	18	20.5	27	8.5	15
550	550	600	600	620	900	1100	500	570

注1: 以上PET伺服泵成PET瓶坯产品外, 也非常适用于生产PP, PE及PPR原料的厚壁制品;
Note 1: Above model apply to PET, PP, PE, PPR material of thick wall products.
注2: 260吨薄壁PET伺服泵主要用于生产医疗血液管等380吨薄壁PET伺服泵主要用于生产薄壁输液包袋等;
Note 2: 260T thin-wall machine mainly for medical blood collection tube production; 380T thin-wall machine mainly for thin-wall vial/infusion box production;
注3: 薄壁PET伺服泵也适用于生产PP, PE及PPS等原料的薄壁产品;
Note 3: Thin-wall PET machine apply to thin-wall production of PP, PE, PPS material ether.

PET 变量泵参数

PET variable pump parameters

项目	Item	单位	160PET	190PET	260PET	320PET	380PET	450PET
国际标准规格	International specification	UNIT	1600-720	1900-980	2600-1280	3200-1680	3800-2780	4500-3700
注射单元 INJECTION UNIT								
螺杆直径	Screw diameter	mm	55	60	65	75	85	94
理论射胶容积	Theoretical shot volume	cc	594	783	995	1458	2270	3019
射胶量(PET)	Shot weight (PET)	g	683	901	1145	1677	2610	3472
	Shot weight (PET)	oz	24.1	31.8	40.4	59.1	92.1	122.5
螺杆长径比	Length/Diameter ratio	L/D	24	24	24	24	24	24
射胶压力	Injection pressure	MPa	121	126	129	114	122	123
射胶速率(PET)	Injection rate(PET)	g/s	272	339	367	538	718	808
射胶行程	Injection stroke	mm	250	277	300	330	400	435
螺杆转速	Max. screw speed	rpm	171	166	148	114	120	113
熔胶率(PET)	Plasticizing capacity (PET)	g/s	50.5	62.0	65.8	97.7	137.3	141.5
锁模单元 CLAMPING UNIT								
锁模力	Clamping force	Ton	160	190	260	320	380	450
模板最大间距	Max. daylight	mm	1006	1100	1130	1275	1450	1560
锁模行程	Clamping stroke	mm	446	490	550	615	710	740
四柱间距	Distance btwn. Tie bars	mm	460X460	510X510	580X580	660X660	740X740	780X780
最小模具尺寸	Min mould dimension	mm	320X320	350X350	400X400	460X460	510X510	540X540
容模量	Mould thickness range	mm	150-560	175-610	200-580	250-660	250-740	300-820
顶针力	Ejector force	ton	6.5	8.5	10.8	13.4	16.2	19.2
顶针行程	Ejector stroke	mm	140	150	175	200	212	260
顶针数	No. of ejector pins	unit	5	5	9	13	13	13
动力电热 POWER UNIT								
主马达功率	Major motor	kW	18.5	22	25.3	34.5	45	55
系统压力	System pressure	MPa	17	17	17	17	17	17
加热区	No. of heater zones	unit	4+1+1	5+1+1	5+1+1	5+1+1	5+1+1	5+1+1
电热功率	Heater input power	kW	18.94	22.54	24.54	34.93	45.93	45.85
总功率	Ultimate capacity	kW	38.4	45.5	50.84	70.43	91.93	101.85
总电流	Current	A	58.4	69.2	77.2	107.0	139.7	154.7
其他 GENERAL DATA								
外形尺寸(长宽高)	Machine dimensions(LxWxH)	m	5.3x1.4x1.8	5.6x1.5x1.8	6.0x1.6x2.0	6.9x1.7x2.0	8.2x1.8x2.1	8.9x1.9x2.1
机器重量	Net weight	ton	5.5	6.8	8.6	11	15	18
注油量	Oil filling capacity	L	300	330	450	550	600	620

注1: 以上PET机器能成型PET瓶胚产品外, 也非常适用于生产PP、PE及PPR等原料的厚壁制品;
Note 1: Above model apply to PET, PP, PE, PPR material of thick-wall products."

行业案例/Case Studies (案例分享)

1. 矿泉水瓶胚/Preform of mineral water bottle

- 一模48腔, 产品单重17g, 总重816g;
- 生产周期约17.5s;
- 机型320PET-SEII(大注射扁), 螺杆直径85mm;
- One mould with 48 cavities, 17g per product, 816g in total
- Production cycle: Around 17.5s;
- Machine model 320PET-SEII(Large), screw diameter 85mm.



2. 食用油瓶胚(20L)/Preform of edible oil bottle

- 一模12腔, 产品单重275g, 总重3300g;
- 生产周期约50s;
- 机型500PET-SEII, 螺杆直径105mm;
- 机械手取出
- One mould with 12 cavities, 275g per product, 3300g in total
- Production cycle: Around 50s
- Machine model 500PET-SEII, screw diameter 105mm
- Taken out by manipulator



3. 薄壁酒盒包装/Thin wall packaging box for wine

- 壁厚1.5mm, 高度310mm;
- 一模2腔, 产品单重350g;
- 生产周期约35s;
- 机型380PET-SEII (薄壁PET专用), 螺杆直径70mm;
- 机器人取出
- Wall thickness 1.5mm, height 310mm
- One mould with 2 cavity, 350g per product
- Production cycle: Around 35s
- Machine model 380PET-SEII(Thin wall PET dedicated), screw diameter 70mm.
- Taken out by manipulator



4. 医疗采血管/Medical blood collection tube

- 长度75mm, 直径φ12.4mm, 壁厚约1mm;
- 一模48腔, 产品单重3.6g, 总重173g;
- 生产周期约11s
- 机型260PET-SEII (薄壁PET专用), 螺杆直径55mm
- Length 75mm, diameter 12.4mm, wall thickness 1mm
- One mould with 48 cavity, 3.6g per product, 173g in total
- Production cycle: Around 11s
- Machine model 260PET-SEII(special for Thin wall PET dedicated), screw diameter 55mm



