



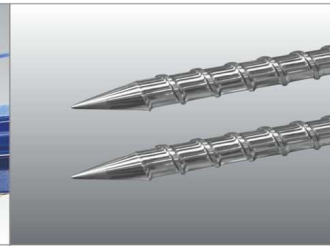
Standard with double core pulling device for Fitting molds.



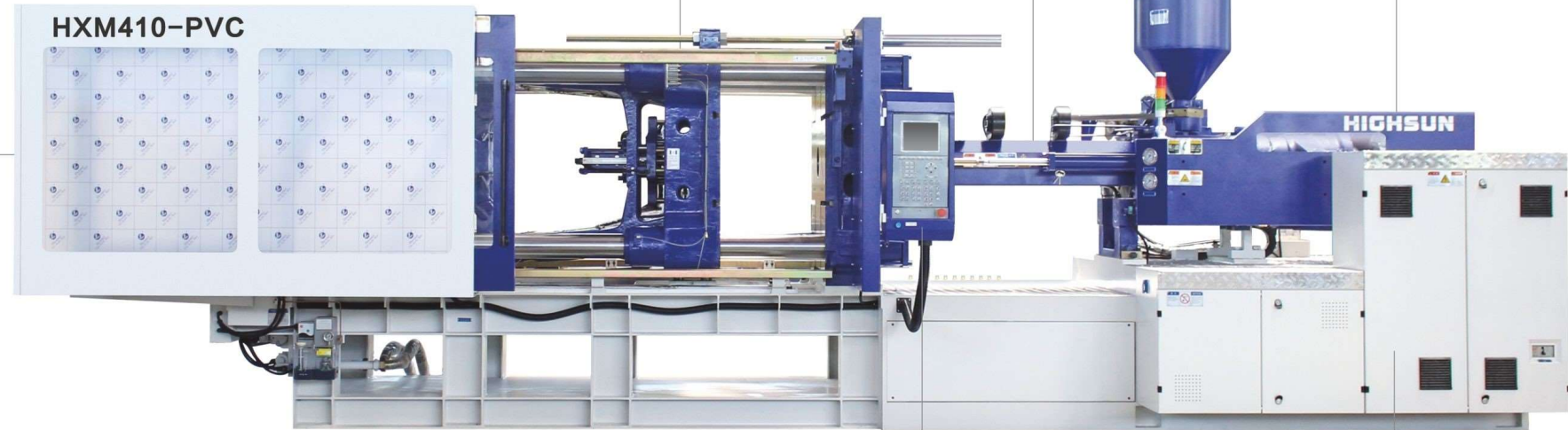
Air fan cooling equipment on the barrel, PID temperature control system.



Special screw and barrel for PVC.



Enlarge the charging motor with high torque force and low speed.



Extended width of safety door for PVC Fitting mold.



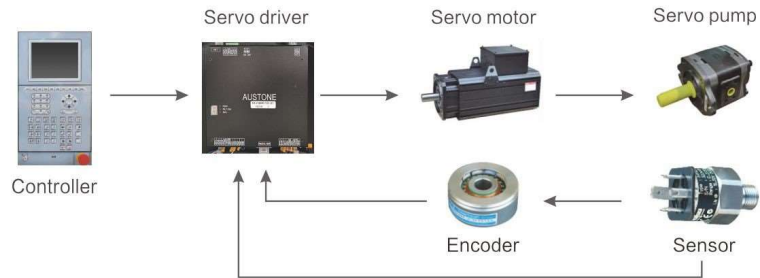
Intelligent control unit, friendly man-machine interface, quick response of system, precise execution of machine.



National level 1 energy conservation certification, European servo system, optimized hydraulic system, adopt international famous electric components.

**UPVC FITTING**  
Injection Molding Machine

## HXM series hydraulic servo control principle



ITEM	BRAND	ORIGINAL
Pump	Eckerle / Settima	Germany / Italy
Motor	Phase	Italy
Driver	Austone	USA
Plasticing Motor	Intermot / Dandun	Italy
Hydraulic Hose	Balflex	Italy
Contacts	Fuji	Japan
Switch	Fuji	Japan
SSR	Omron	Japan

## Fittings

COUPLING	FITTING CLEANOUT ADAPTER	SPIGOT ADAPTER, CAST IRON SOIL PIPE	LONG SWEEP 1/4 BEND	VENT ELL	DOUBLE SANITARY TEE, REDUCING	COMBINATION WYE & 1/8 BEND, REDUCING (TWO PC)	COTTAGE WYE, LH INLET	CLOSET FLANGE W/CO/ONE PC
FEMALE ADAPTER	FITTING CLEANOUT ADAPTER W/CO/PLUG	HUB ADAPTER, CAST IRON SOIL PIPE	LONG SWEEP 1/4 BEND W/LOW HEEL INLET	VENT ELL	DOUBLE SANITARY TEE, STREET	DOUBLE COMBINATION WYE & 1/8 BEND	COTTAGE WYE, RH INLET	CLOSET FLANGE, ADJUSTABLE (W/METAL RING)
REDUCING COUPLING	CLEANOUT PLUG W/RAISED NUT	HUB ADAPTER, CAST IRON SOIL PIPE INCREASER	LONG SWEEP 1/4 BEND	VENT ELL, STREET	DOUBLE SANITARY TEE, W/SIDE INLET	DOUBLE FIXTURE FITTING	RETURN BEND	CLOSET FLANGE, ADJUSTABLE (W/METAL RING)
TRAP ADAPTER- MALE	CLEANOUT PLUG- FLUSH	REPAIR COUPLING	1/8 BEND	SANITARY TEE	DOUBLE SANITARY TEE W/R & L SIDE INLETS	WYE	P-TRAP	CLOSET FLANGE, FLUSH (W/CO)
TRAP ADAPTER- MALE	FLUSH BUSHING	TEST CAP (INSERT TYPE)	1/8 BEND	SANITARY TEE, REDUCING	VENT TE	WYE, REDUCING	P-TRAP LOW PROFILE MH	OFFSET CLOSET FLANGE
TRAP ADAPTER- MALE	FLUSH BUSHING	TEST CAP-PIPE	1/8 BEND, STREET	SANITARY TEE, STREET	CLEANOUT TE W/CO, PLUG	WYE, STREET	P-TRAP W/CLEANOUT	

## UPVC fitting Application Case 1

Material Formula: UPVC + CaCO<sub>3</sub>, Prilling  
 Product Series : 45° WYEE  
 Product Specification: 75  
 Cavity Quantity: One mold two cavities  
 Machine Model: HXM330

Cycle Time: 55 S  
 Clamping: 2.5  
 Injection: 12  
 Holding Pressure: 1  
 Cooling: 35  
 Mold Opening : 2  
 Ejector: 1.5



## UPVC fitting Application Case 2

Material Formula: UPVC Powder  
 Product Series: 90° Elbow  
 Product Specification: 90  
 Quantity of Molding Cavity: One mold two cavities  
 Machine Model: HXM410

Cycle Time: 60 S  
 Clamping: 2.5  
 Injection: 16  
 Holding Pressure: 1  
 Cooling: 37  
 Mold Opening : 2  
 Ejector: 1.5



## UPVC fitting Application Case 3

Material Formula: UPVC  
 Product Series : Plain Tee  
 Product Specification: 250  
 Cavity Quantity: One cavity  
 Machine Model: HXM830

Cycle Time: 70 S  
 Clamping: 2.5  
 Injection: 14  
 Holding Pressure: 1  
 Cooling: 49  
 Mold Opening : 2  
 Ejector: 1.5



### 产品规格 Specifications

	HX(*)218PVC	HX(*)258PVC	HX(*)298PVC	HX(*)330PVC	HX(*)410PVC	HX(*)470PVC	HX(*)530PVC	HX(*)630PVC	HX(*)730PVC	HX(*)830PVC	HX(*)1100PVC	
<b>注射装置 Injection Unit</b>												
螺杆直径 Screw diameter	mm	50	55	60	65	70	75	80	80	90	100	120
螺杆长径比 Screw L/D ratio	L/D	20	20	20.6	21	21	20	20	21.3	21	20.9	20.2
理论注射容积 Injection capacity in theory	cm <sup>3</sup>	431	546	820	1062	1308	1634	1860	2110	2799	4264	6333
注射重量 Injection weight(PVC)	g	517	655	984	1274	1570	1961	2232	2532	3359	5117	7600
注射压力 Injection pressure	MPa	170	169	168	162	157	173	168	168	184	158	150
注射速率 Injection rate	g/s	190	276	324	342	341	474	522	558	564	825	1123
塑化能力 Plasticizing capacity	g/s	30	42	52	58	50	78	69	74	90	108	134
螺杆转速 Screw speed	rpm	170	180	180	160	136	160	150	130	125	110	110
<b>合模装置 Clamping Unit</b>												
合模力 Clamping force	KN	2180	2580	2980	3300	4100	4700	5300	6300	7300	8300	11000
移动模板行程 Moving mould-plate stroke	mm	520	550	600	660	700	780	830	870	950	1080	1220
最大模厚 Max.Mould height	mm	580	600	690	750	800	820	830	900	960	1050	1170
最小模厚 Min.Mould height	mm	200	230	230	250	280	300	330	350	400	400	450
拉杆有效间距 Space between tie-bars	mm	520x520	570x570	605x590	720x670	770 x720	820x770	860x810	900x850	1000x950	1070x970	1160x1160
液压顶出力 Hydraulic ejector force	KN	80	80	80	125	125	120	181	200	200	200	245
液压顶出行程 Hydraulic ejector stroke	mm	150	150	150	180	180	200	230	260	280	300	320
顶出点数 Ejector number	n	9	13	13	13	13	13	17	17	17	13	21
<b>其他 Other</b>												
油泵压力 Pump pressure	MPa	16	16	16	16	16	16	16	16	16	16	16
普通电机驱动功率 Motor/Driving power	KW	23	30	30	37	37	30+23	30x2	30x2	30x2	37x2	30x3
加热功率 Heating capacity	KW	13.55	16.83	18.15	20.35	23.15	23.15	26.45	28.85	42	48.8	68.85
外形尺寸 Machine dimension	m	5.74*1.76*2.12	5.825*2.01*2.17	6.50*2.15*2.08	7.20*2.36*2.18	7.38* 2.36*2.35	7.85*2.5*2.4	8.1*2.54*2.5	9.22*2.87*2.61	9.67*3.05*2.95	11.3*3.25*3.4	12.55*3.25*3.5
机器重量 Machine weight	t	6.8	7.8	8.6	11.2	13.9	16.4	19.9	28.2	33.2	42.3	56.3
油箱容积 Oil tank capacity	L	281	311	415	680	680	687	969	1156	1136	1315	2000