SHANGHAI LISONG INDUSTRIAL TECHNOLOGY CO., LTD		LS 220/530 GT	LS 290/580 GT	LS 328/630 GT	LS 458/720 GT	LS 550/770 GT	LS 650/900	LS 650/900 GTe	LS 700/910 GTe		LS 800/1000 GTe	LS 800/1000 GTHe	LS1000/1090 GTe	LS1000/1090 GTHe
Model description	型号	220/530-770	290/580-900	328/630-1100	458/720-2500	550/77-3900	650/900-5000	650/900-5000	700/910-5000	700/910-7600	800/1000-7600	800/1000-8800	1000/1090-8800	1000/1090-11500
International size description	国际标准尺寸	2200-770	2900-900	3280-1100	4580-2500	5500-3900	6500-5000	6500-5000	7000-5000	7000-7600	8000-7600	8000-8800	10000-8800	10000-11500

Clamping unit	**合模装置**		**220/530**	**290/580**	**328/630**	**458/720**	**550/770**	**650/900**	**650/900**	**700/910**	**800/1000**	**1000/1090**
Clamping force	合模力	[KN]	2200	2900	3280	4580	5500	6500	6500	7000	8000	10000
Locking force	锁模力	[KN]	2420	3190	3608	5038	6050	7150	7150	7700	8800	11000
Max.mould opening stroke	最大开模行程	[mm]	500	550	640	750	830	900	930	1000	1100	1300
Min.mould height	最小模厚	[mm]	200	220	220	280	300	410	410	400	450	500
Max.mould height	最大模厚	[mm]	550	580	610	730	800	1000	1000	1000	1000	1000
Max.daylight	最大模板间距	[mm]	1050	1130	1250	1480	1630	1900	1930	2000	2100	2300
Mould platen(h×v)	模板尺寸(水平×垂直)	[mm]	800x800	875x875	940x900	1090x1090	1175x1120	1310x1310	1310x1310	1320x1320	1410x1280	1540x1400
Distance between tie bars(h×v)	拉杆间距(水平×垂直)	[mm]	530x470	580x515	630x585	720x720	770x720	900x810	900x810	910x820	1000x870	1090x950
Ejection stroke	顶出行程	[mm]	135	140	140	140	145	175	175	175	230	270
Ejection force	顶出力	[KN]	67	88	88	88	130	130	130	130	250	250

Injection unit	**注射装置**		**770**	**900**	**1100**	**2500**	**3900**	**5000**	**5000**	**7600**	**8800**	**11500**
Screw diameter	螺杆直径	[mm]	50	55	60	70	80	90	90	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
L / D ratio	长径比		26	24	22	24	24	24	24	23	22	22
Spec.inj.Press. (up to 400 ℃)	注射压力(至400℃)	[bar]	1710	1655	1736	1736	1750	1762	1762	1764	1692	1704
Max. cylinder head volume	理论注射容积	[cm^3]	452	546	650	1443	2262	2863	2863	4320	5227	6786
Max. shot weight (PS)	最大注射量	[g]	411	497	592	1313	2058	2605	2605	3931	4757	6175
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]	389	530	478	793	1030	827	1126	1343	1549	1742
Injection speed (Under 1000bar injection pressure)	**注射速度** (在1000bar的注射压力下)											
> without accumulator	>无蓄能器	[mm/s]	198	223	169	206	205	130	177	171	163	154
Max. screw stroke	最大螺杆行程	[mm]	230	230	230	375	450	450	450	550	550	600
Max. nozzle dipping depth(SVO)	最大喷嘴伸出模板长度(SVO)	[mm]	80	80	80	80	80	80	80	80	80	80
Nozzle sealing force	喷嘴接触力	[kN]	80	110	110	110	110	110	110	110	110	110
Number of heating zones	加热段数量		5	5	5	6	7	7	7	7	7	7
Hopper capacity	料斗容积	[ltr.]	35	35	35	35	70	70	70	70	70	70

General data	**综合数据**		**220/530-770**	**290/580-900**	**328/630-1100**	**458/720-2500**	**550/770-3900**	**650/900-5000**	**650/900-5000**	**700/910-5000**	**700/910-7600**	**800/1000-7600**	**800/1000-8800**	**1000/1090-8800**	**1000/1090-11500**
Oil tank capacity	油箱容量	[ltr.]	420	500	500	580	580	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	55+45	45+45	55+55	55+55	55+45+45	55+45+45	55+55+37	55+55+37	55+55+55
> electric screw drive	>电动螺杆	[≈kW]							75	75	90	90	110	110	130
> heating capacity of screw cylinder	>料筒加热功率	[≈kW]	20.4	29.2	32.6	34.5	42	51.4	51.4	51.4	57.1	57.1	61.8	61.8	64.4
> capacity with electr drive [2]	>电器总功率 [2]	[≈kW]	57.4	74.2	77.6	116.5	142	141.4	236.4	236.4	292.1	292.1	318.8	318.8	359.4
Net weight (without oil) [5]	机器净重(不含油) [5]	[≈kg]	10800	11000	12800	17800	20300	27100	27200	28600	29000	40000	41000	48200	49000
Machine dimensions(l×w×h)	机器尺寸(l×w×h)	[≈m]	6.32x1.55x2.1	6.57x1.62x2.1	6.95x1.71x2.1	7.85x1.95x2.2	8.25x2.03x2.4	9.5x2.22x2.85	9.6x2.22x2.85	9.65x2.22x2.85	9.7x2.22x2.85	9.75x2.4x2.85	10.1x2.4x2.85	11.2x2.8x3.0	11.8x2.8x3.0

LISONG力松®

上海力松工业科技有限公司

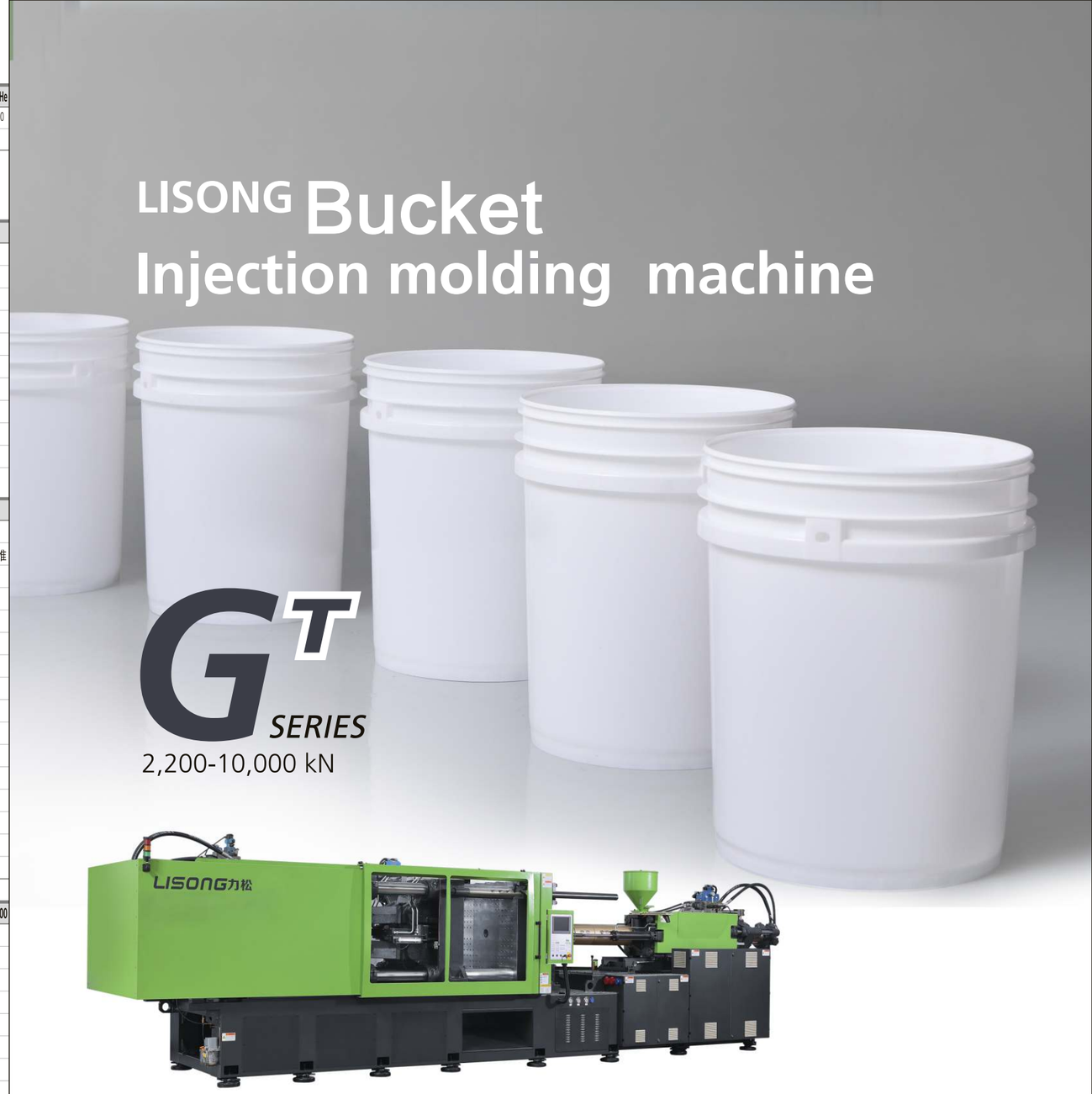
地址：上海市浦东新区川宏路365号
圣御工业园8栋
电话：+86-21-5821 1911
邮箱：info@lisonginc.com

SHANGHAI LISONG INDUSTRIAL TECHNOLOGY CO., LTD

ADD: No.8 Building, Shengyu Industry Center, No.365 Chuanhong Road, Pudong, Shanghai, China
TEL:+86-21-5821 1911
EMAIL:info@lisonginc.com



LISONG Bucket Injection molding machine



桶专用注塑机

LISONG力松®
力松，高速注塑机制造专家！

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	LS700/910GTe
		2		1600	K8003	21.9	LS1000/1090GTe
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	LS290/580GT
20L	ø325	1	2	245	20.2	LS290/580GT
		2		456	21.3	LS328/630GT
33L	ø385	1	2.15	296	23	LS290/580GT

桶机专用注塑机 结构优势

Advantages

- Close the mold, the template deformation is small, be easier to be formed.
- React quickly
- Low Oil leakage probability





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 larDedicated screw with large L/D ratio and high plasticization.ge 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.
- Famous brand hydraulic accessories which is more stable and efficient.





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.标配KEBA控制器。
- 2.软件优化，操作界面人性化。
- 3.MES联网（可选）。
- **Standard KEBA controller.**
- **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.