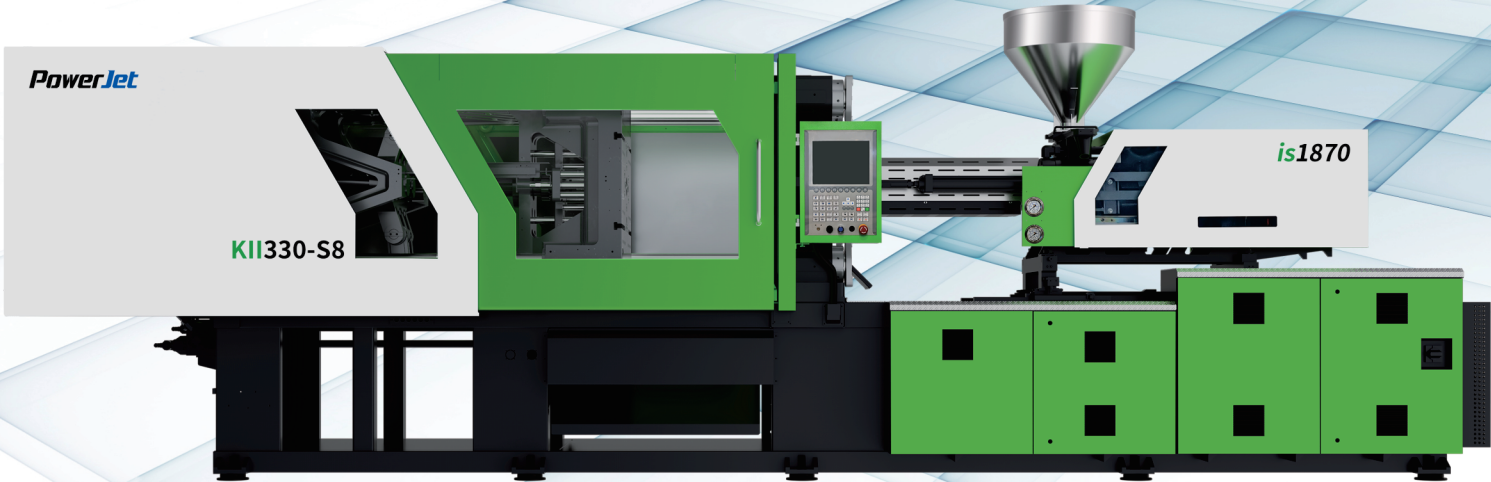


PowerJet

KII

900-13800kN
KII标准型高精密注塑机
KII Precision Injection Molding
Machine



佛山市宝捷精密机械有限公司
POWERJET PLASTIC MACHINERY CO.,LTD.

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宝捷公众号



宝捷官方网址

KII-S8 标准型节能注塑机

KII standard energy-saving injection molding machine



更高效节能



更精密稳定



适用范围更广



机台及模具
寿命更长

1 钣金造型

SHEET METAL MODELING

符合国标强制安全防护，具有液压安全阀安全继电器，双重连锁保护

In line with the national standard mandatory safety protection, with safety valves, safety renewing appliances, double chain protection

2 锁模结构

CLAMPING STRUCTURE

中心压力锁模结构，稳定快速

Center-press toggle system designed, fast and stable

3 注射系统

INJECTION SYSTEM

升级双层线轨注射系统，射速更快、更精密、更稳定

Upgraded double-layer linear guide injection system, enhanced for higher injection speed, precision, greater stability, and electric charging unit for better energy-saving efficiency.

4 加强机架

REINFORCED RACKS

加强刚性机架，减震更明显、生产更稳定

Strengthen rigid frame, better damping performance, production more stable

5 伺服系统

SERVO SYSTEM

搭载全新伺服系统，响应快、精度高

New servo motor system, high response and high precision

6 控制面板

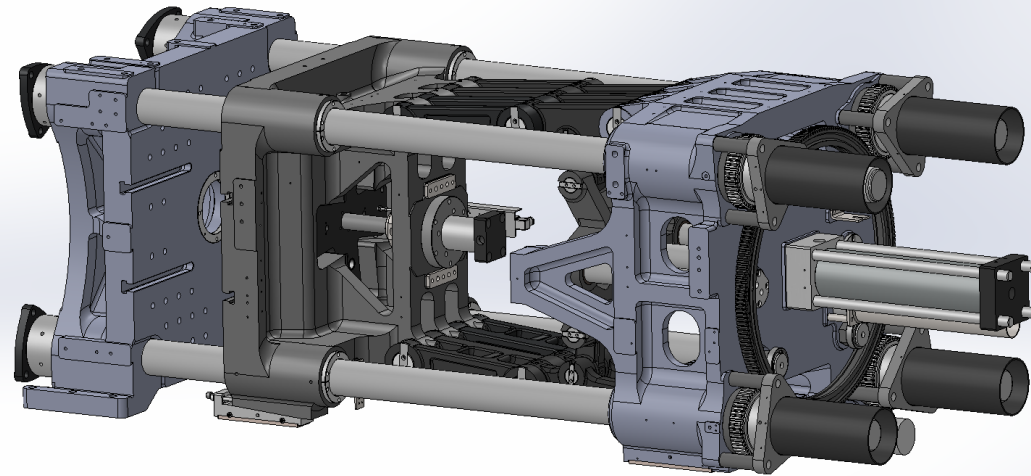
CONTROL PANEL

采用12寸彩显大屏，CPU处理周期提升到最快100μs，响应速度快、控制精度高

12" color display, CPU is increased to fastest 100μs, fast response, high control accuracy.

锁模单元

CLAMPING UNIT



- 锁模油缸平衡导向加长油缸到位缓冲设计，智能开合模控制，动作平稳快速，开模定位更精准
- 全系列标配新型欧式顶针结构
- 头板模板有限元分析优化低应力设计，锁模力保证，可靠耐用
- 头板模板高刚性，有限元分析优化低变形，码模面少变形，成型产品精密
- 二板压中心模板结构设计，有限元分析优化低应力，码模面少变形，成型产品精密
- 尾板高刚性低应力设计，成型产品更精密
- 加长导向低应力高寿命导柱结构;独特的导柱卸荷槽及导柱螺母，大幅降低应力集中,实现导柱及导柱螺母抗疲劳增长

- The clamping cylinder is balanced, guided, and the extended cylinder is cushioned in place, and the intelligent mold opening and closing control makes the action stable and fast, and the mold opening and positioning are more accurate
- The whole series is equipped with a new European-style ejector pin structure as standard
- The finite element analysis of the template optimizes the low-stress design, and the clamping force is guaranteed, which is reliable and durable
- The template has high rigidity, finite element analysis optimizes low deformation, and the code die surface is less deformed, and the molded product is precise
- The structure design of the pressure center template, finite element analysis optimizes low stress, less deformation of the code die surface, and the molding product is precise
- High rigidity and low stress design, molding products are more precise
- Lengthened tie bar with low stress and long lifetime; The unique unloading groove and nut of the tie bar, it could greatly decrease the stress concentration and enhance the fatigue resistance of the tie bar and nut.

高刚性中心压力锁模机构

High Rigidity Central Pressure Clamping Mechanism



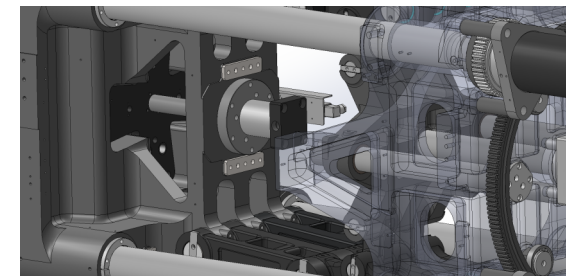
高刚性中心压力锁模机构安全平稳可靠
The high-rigidity central pressure clamping mechanism is safe, stable and reliable



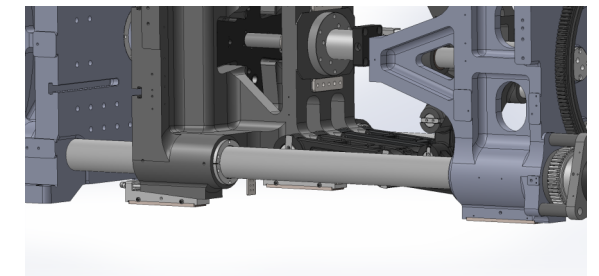
减少模腔尺寸形变，提高成型尺寸精度
Reduce the dimensional deformation of the mold cavity and improve the dimensional accuracy of molding



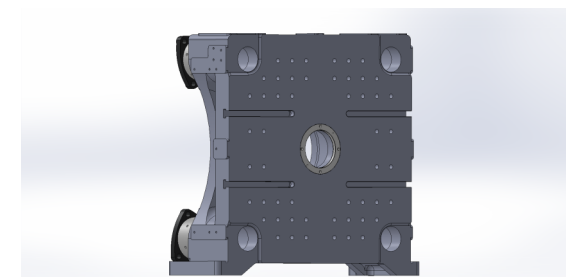
标配T型槽、码模孔复合模板，全系列标配可调模具定位环
It is equipped with T-slot, code die hole composite template as standard, and the whole series is equipped with adjustable mold positioning ring as standard



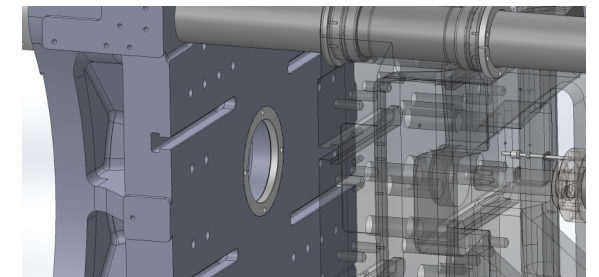
整体拆装顶出油缸部件结构
Integral structure of removable ejector cylinder components



锁模二板超长底脚滑板
The second platen with long foot skateboard



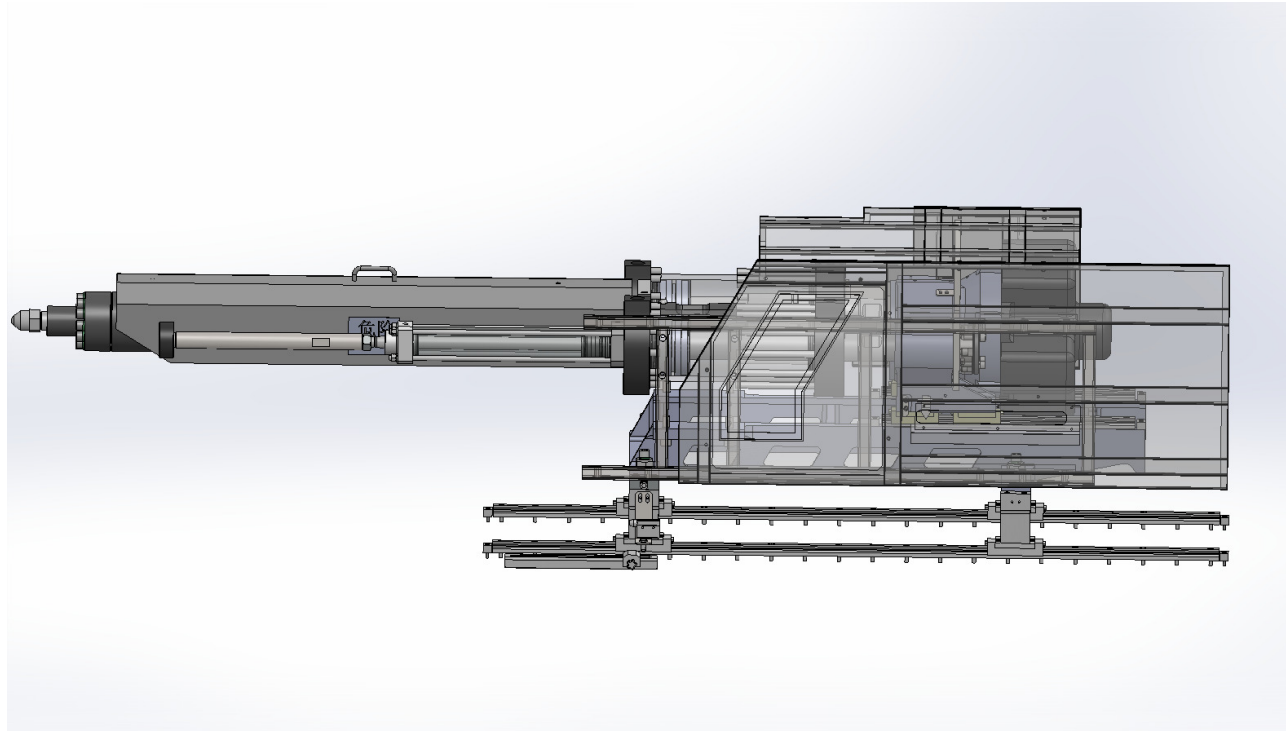
全系标配T型槽、码模孔复合模板
All are equipped with T-slot and mounting hole platen



全系标配模具定位环
All are equipped with mold locating ring

注射单元

INJECTION UNIT



精密、稳定、
节能、塑化效果好

Precision, Stability, Energy-saving
Good Plasticization



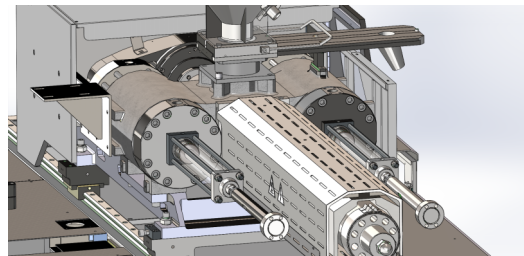
高精度
high precision



高响应
high response

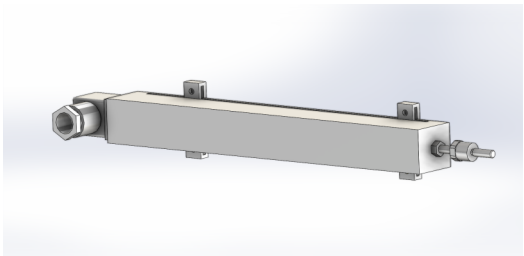


低摩擦
Low friction



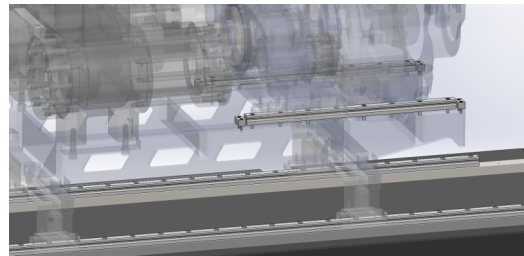
双缸平衡式射胶机构，提供更高的射胶压力，机构更简单稳定，故障率更低维修更方便，同时又节省空间

Double cylinder balance injection mechanism provides high-pressure injection, easy maintenance and saves space,



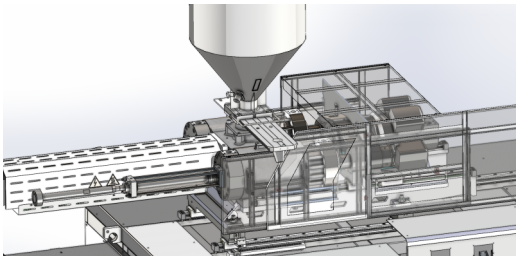
精密电子尺控制射胶、熔胶行程

Precision electronic meter control on material injection, molten stroke.



双射移油缸驱动，双射胶油缸配合加长导向，双层射台结构，射胶动力强劲平稳配合高射速

Driven by double-shot moving cylinders, double-shot rubber cylinders with extended guides, and double-moving linear rail sliders, the injection power is strong and stable with high injection rate.



标配高射速100mm/s 以上，更有利于成型高质量高精密度产品，高节能效果配合快速成型，将提供给您创造高效率低成本生产成型的高效方案

The standard high injection rate is more than 100mm/s, which is more conducive to molding high-quality and high-precision products

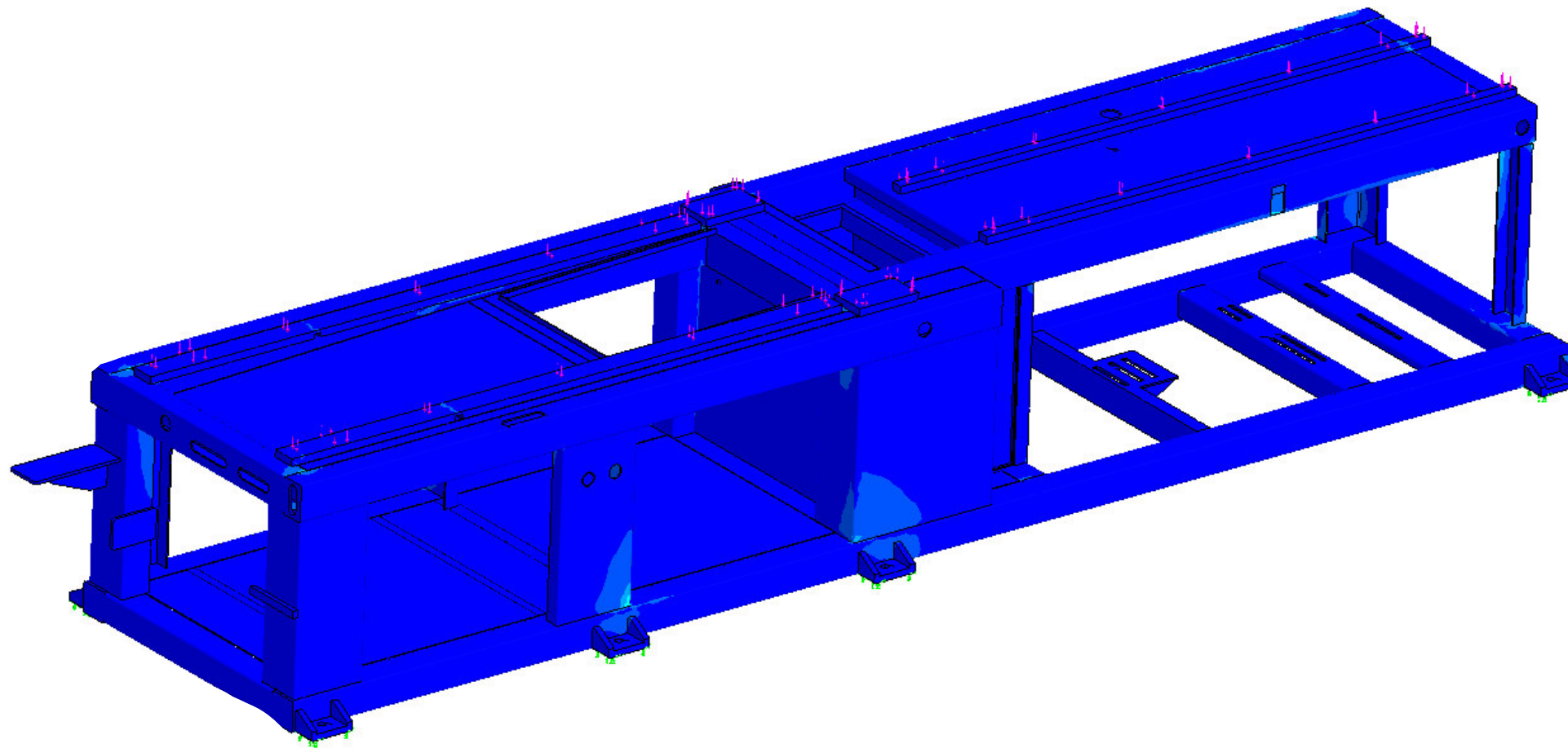
机架部分

RACK SECTION

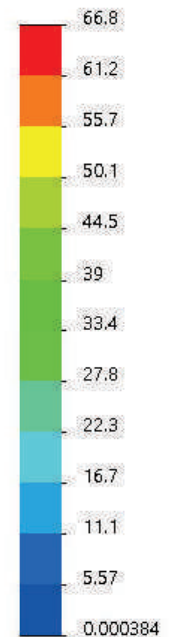
高精密
high precision

高响应
high response

低摩擦
Low friction



von Mises (N/mm² (MPa))



屈服力: 221

- 小机型油箱内置冷却器，散热度效果提升30%以上

The fuel tank of the small model has a built-in cooler, and the heat dissipation effect is increased by more than 30%

- 开锁模单独回油，开合模更易控制高速运行平稳，位置精度更准

The opening and locking of the mold is separated from the oil return, which makes the opening and closing of the mold master to control, the high-speed operation is stable, and the position accuracy is more accurate

- 杂质过滤防气泡油箱结构;旁路滤油，高效过滤液压油

Impurity filtration, anti-bubble fuel tank structure; Bypass oil filtration, hydraulic oil is cleaner and more durable

- 电脑十二寸彩显大屏，可转动设计，人性化设计，操作舒适度更优

The computer has a large 12-inch color display screen, rotatable design, humanized design, and better operation comfort

- 加强受力支撑，有限元受力分析优化，高刚性设计，整机支撑平稳适用高速运行

Strengthen the force support, finite element force analysis and optimization, high rigidity design, the whole machine support is stable and suitable for high-speed operation

- 外挂电箱强弱电分开，减少控制信号干扰

The external electrical box separates the strong and weak currents to reduce the interference of control signals

- 电箱空间大散热效果更好

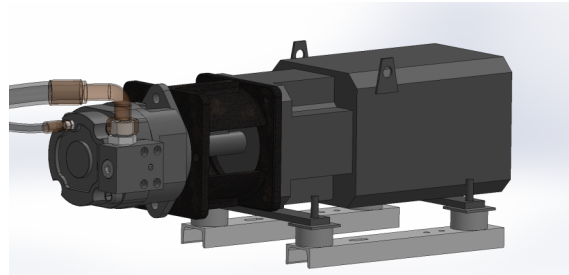
The power box has a larger space and good heat dissipation performance.

- 符合安全标准设计，前安全门III型保护，后安全门II型保护，前后急停，电脑复位

Designed in line with safety standards, front safety door type III protection, rear safety door type II protection, front and rear emergency stop, computer reset

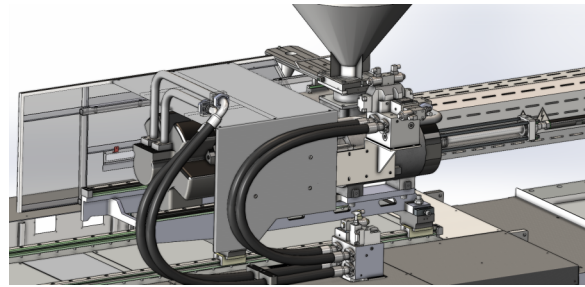
液压系统

HYDRAULIC SYSTEM



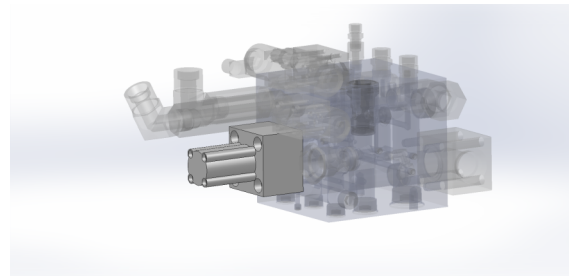
伺服电机

高性能伺服电机，配高性能低噪音油泵，效率高耐用性强
High-performance servo system, equipped with high-performance and lownoise oil pump, high efficiency and strong durability



射台部分

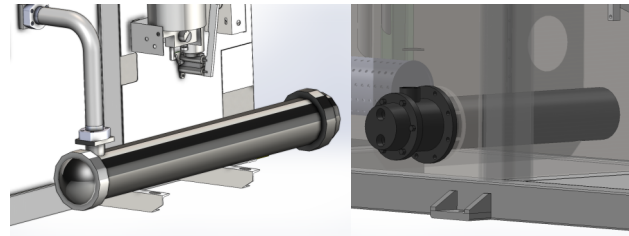
射胶阀的选型及油路设计确保射胶进回油流动顺畅，阻力小
The selection of the injection valve and the design of the oil circuit ensure the smooth flow of the injection into and return oil and the resistance is small



锁模部分

全系列机型标配主动型安全阀锁模差动开模缓冲功能：
90-160锁模油制板集成配置锁模差动，锁模低压，开模缓冲，开模快速功能

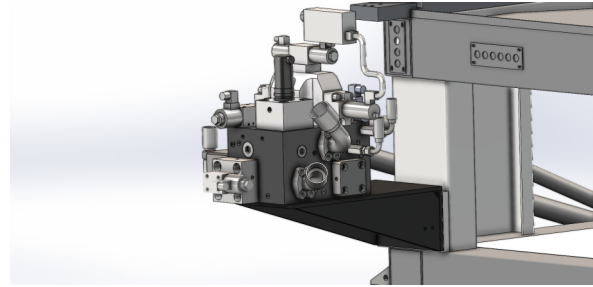
The series models are equipped with active safety valves, differential clamping and buffer functions as standard: 90-160 clamping oil plate integrated configuration clamping differential, clamping low pressure, mold opening buffer, mold opening fast function.



冷却器

90-330采用内置式冷却器,400以上采用外置冷却器内藏于机架的方式，布局更简洁

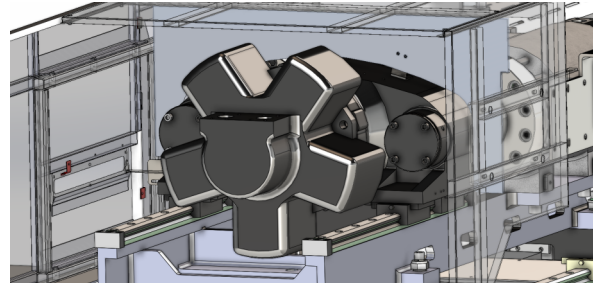
The 90-330 adopts built-in cooler 400 above adopts external cooler built in the rack way, the layout is more concise



高性能液压元件

配合差动式油路设计，保证锁模快速、平稳、低噪，缩短成型周期，提高生产效率

Imported advanced hydraulic valve incorporated with differential oil circuit guarantees mold locking device to be fast, stable and low noise, and reduces forming period, increase production efficiency.



液压马达

低速大扭矩液压马达驱动螺杆满足各种原料的塑化要求

Hydraulic motor: Low speed and large torque hydraulic motor meets plasticizing demand of different raw material.

控制系统

CONTROL SYSTEM

人性化的电脑控制系统功能强大、速度快、控制精准、操作简便、程序可满足多种工艺需求

The humanized computer control system is powerful, fast, precise and easy to operate, and the program can meet a variety of process needs

电箱等部件设计既考虑了走线的安全，同时也提升了操作和维护的方便

The electrical box and other components are designed with both the safety of the alignment and the convenience of operation and maintenance.

- 全新控制面板设计和页面设计
- 屏幕升级为12寸屏
- 控制单元CPU,处理周期提升到最快100μs, 响应速度快、控制精度高
- 一页尽览机器状态
- 一键确定机器零位
- DA输出调整简单直观
- IO点可自定义，方便维修改线
- 多泵工作根据需要自由组合(油路配合)
- 多种配置选项，方便程序管理，满足不同用户需求
- 程序升级页面，便于U盘程序更新
- 与伺服驱动通讯，方便驱动参数数据修改及监控
- 智能故障诊断，报警故障成因一览无遗
- 990组模具记忆功能

- New control panel design and page design;
- The screen has been upgraded to a 12-inch screen
- The CPU of the control unit adopts , and the processing cycle is increased to the fastest 100μs,
- One page at a glance at the status of the machine
- One-click determination of machine zero
- DA output adjustment is simple and intuitive
- The I/O point can be customized, which is convenient for dimensioning and modifying the line
- Multi-pump work can be freely combined according to needs (oil circuit fit)
- A variety of configuration options facilitate program management to meet the needs of different users
- Program upgrade page, easy to update the USB flash drive program
- It communicates with the servo drive to facilitate the modification and monitoring of the drive parameter data
- Intelligent fault diagnosis, alarm fault causes at a glance
- 990 sets of mold memory function



设备配置

Device Configuration

标准配置

1.注射系统

- 氮化钢螺杆料筒
- 料斗滑轨装置
- 标准射嘴
- 双缸平衡注射装置
- 不锈钢料斗
- 螺杆防冷启动功能
- 自动清料功能
- 防流涎功能
- 多段料筒PID温控(4至7段)
- 射胶熔胶故障自动检测
- 射嘴防护罩
- 精密电子尺控制射胶/熔胶行程

2.锁模系统

- 精密电子尺控制锁模/顶针行程
- 锁模三大板/机铰采用高刚性球墨铸铁
- 电脑控制两段顶出前进/后退动作
- 低压模具保护功能
- 液压驱动调模装置
- T型槽、码模孔复合模板

3.液压系统

- 高性能齿轮泵
- 高精度实时旁路滤油器装置
- 系统压力流量自动校正
- 熔胶比例背压控制
- 开合模比例阀控制（400T及以上机型）

4.控制系统

- 输入/输出检视功能
- 自动保温及自动加热设定功能
- 射胶转保压采用时间/位置/压力三种转换方式
- 各个动作斜率的独立调整
- 生产资料监测功能

5.附件

- 说明书
- 工具箱
- 随机配件

1.Injection system

- Nitriding steel screw & barrel
- Sliding rail unloading device
- Standard injection nozzle
- Double injection cylinders
- Stainless steel hopper
- Anti-cold start-up of screw
- Automatic resin clear function
- Anti leaking function
- Multistage charging barrel PID temperature control (4-7 stages)
- Automatic defecting on material molten and injection fault
- Protective nozzle cover
- Precision electronic meter control on materia injection/molten stroke

2.Mold locking device

- Precision electronic meter control mold locking / ejector stroke
- Mold clamping three plates/hinges are made of high strength nodular cast iron.
- Two stages forward / backward movement controlled by computer
- Mold low pressure protection function
- Hydraulic mold adjusting device
- T-slot & mounting hole platen

3.Hydraulic system

- High performance proportional variable pump system / variable-pump
- High precision real-time bypass filter device
- Automatic adjustment of system pressure and flow
- Melting by proportional back pressure control
- Proportional Valve Control for Mold Opening and Closing （400T or above）

4.Control system

- Input/output view function
- Automatic heat preservation and automatic heating setting function:
- Injection to holding pressure adopts three conversion methods: time/ position/pressure
- Independent adjustment of the slope of each action
- production data monitoring function

5.Accessory

- Operation manual
- Tool box
- Spare parts

备选配置

1.注射系统

- 加长射嘴点
- 专用螺杆组件
- 干燥料斗
- 料筒吹风装置
- 自锁射嘴
- 螺杆转速检测功能

2.锁模系统

- 加大容量量
- 加大顶针行程
- 吊模架(200及以下)
- 加装模具隔热板
- 特殊模具安装孔
- 电动安全门(800及以上标配)

3.液压系统

- 液压抽芯/旋转脱模装置
- 液压安全保护
- 独立油温控制系统
- 高响应伺服注射系统
- 氮气射胶装置

4.控制系统

- 电动旋转脱模装置
- 多组工模吹风
- 电动旋转脱模动接口
- 更改电源电压
- 加热固态继电器控制
- 欧规机械手接口

1.Injection system

- Long injection nozzle
- Special screw & Barrel
- Hopper dryer
- Barrel with air blowing devices
- Self-locked injection nozzle
- Screw speed detection function

2.Mold locking device

- Enlarged mold capacity by
- Super large ejector stroke
- Mold hanger(below 200T)
- Mold heat insulating plates
- Special mold mounting hole
- Electric safety door(8000kN and above models)

3.Hydraulic system

- Hydraulic core pull /Unscrewing mold release device
- Hydraulic safety protection
- Independent oil temperature control system
- Sensitive servo control injection system
- Nitrogen material injection device

4.Control system

- Electric unscrewing mold release device
- Mold air blowing devices in moving mold Platen
- Electric unscrewing mold release dynamic interface
- Change of power supply voltage
- Heating by solid-state relay control
- Euro standard robot port

技术参数

TECHNICAL PARAMETER

备注：本公司根据产品提升的需要，可对技术参数、部份元件配置及服务内容进行更改，恕不另行通知。
Remarks: According to upgrading of machine, we will change techical parameters, configuration of some parts and service's items without further notice.

说明	DESCRIPTION	单位	KII90-S8			KII128-S8			KII160-S8			KII200-S8			KII250-S8		
国际公认型号	International size rating		900-300			1280-450			1600-600			2000-900			2500-985		
锁模单元	CLAMPING UNIT																
锁模力	Clamping force	KN	900			1280			1600			2000			2500		
开模行程	Opening stroke	mm	320			360			440			490			540		
模板外形尺寸	Platen size	mm×mm	540x540			610x610			686x686			793×793			871x871		
导柱内距	Space between bars	mm×mm	360x360			410x410			470x470			530×530			580x580		
最大模厚	Max.mold height	mm	360			450			520			550			580		
最小模厚	Min.mold height	mm	130			145			160			180			220		
顶针行程	Ejector stroke	mm	100			120			140			150			150		
顶出力	Ejector force	KN	34			42			49			65			77		
顶针数	Ejector number	PCS	1+4			1+4			1+4			1+4			1+4		
注射单元	INJECTION UNIT																
螺杆直径	Screw diameter	mm	30	36	42	36	40	45	42	46	52	46	52	60	46	52	60
螺杆长径比L/D	Screw L/D ratio	-	20.7	20	17.2	23	20	18.2	22	20	17.4	23	20	18.5	23	20	18.5
注射压力	Injection pressure	Mpa	267	186	136	228	184	146	214	178	140	220	172	130	220	172	130
理论注射容积	Shot volume	cm³	113	163	222	193	239	302	284	341	435	407	520	693	449	573	763
实际注射量(PS)	Shot weight(ps)	g(克)	101	145	198	178	220	278	253	303	388	363	463	617	408	522	695
		OZ(盎司)	3.6	5.1	7.0	6.1	7.5	9.5	8.9	10.7	13.7	12.8	16.3	21.8	14.4	18.4	24.5
注射速率	Injection rate	g/sec	84	121	164	123	152	192	165	198	253	203	260	346	203	260	346
塑化能力(PS)	Plasticizing capacity	g/sec	13	20	27	20	29	36	27	35	45	37	51	73	37	51	73
螺杆转速	Screw speed	rpm	0-267			0-250			0-250			0-267			0-267		
动力/电热	POWER UNIT																
油泵电机功率	Pump motor power	KW	15			18.4			25.1			33.5			33.5		
加热功率	Heater power	KW	6.5			8.3			9.8			10.9			10.9		
其他	GENERAL																
油箱容量	Oil tank capacity	L	112			139			198			253			320		
机器重量	Machine weight	Ton	3			3.8			5			6.4			7.6		
外形尺寸	Machine dimensions (L×W×H)	m×m×m	4.0x1.2x1.77			4.5x1.3x1.85			4.9x1.4x1.90			5.4x1.4x2.05			5.6x1.5x2.05		

技术参数

TECHNICAL PARAMETER

备注：本公司根据产品提升的需要，可对技术参数、部份元件配置及服务内容进行更改，恕不另行通知。
Remarks: According to upgrading of machine, we will change techical parameters, configuration of some parts and service's items without further notice.

说明	DESCRIPTION	单位	KII288-S8				KII330-S8				KII400-S8				KII500-S8				KII560-S8					
国际公认型号	International size rating		2880-1370				3300-1870				4000-2500				5000-3600				5600-4500					
锁模单元	CLAMPING UNIT																							
锁模力	Clamping force	KN	2880				3300				4000				5000				5600					
开模行程	Opening stroke	mm	550				640				710				830				860					
模板外形尺寸	Platen size	mm×mm	905x905				980x980				1080×1060				1230x1190				1230×1230					
导柱内距	Space between bars	mm×mm	610x610				670x670				740x720				820x780				860×860					
最大模厚	Max.mold height	mm	610				680				730				850				880					
最小模厚	Min.mold height	mm	230				250				300				300				330					
顶针行程	Ejector stroke	mm	150				180				210				220				240					
顶出力	Ejector force	KN	77				77				110				135				135					
顶针数	Ejector number	PCS	1+12				1+12				1+12				1+12				1+16					
注射单元	INJECTION UNIT																							
螺杆直径	Screw diameter	mm	52	60	68		60	68	75		68	75	83	90		75	83	90	100		75	83	90	100
螺杆长径比L/D	Screw L/D ratio	-	21	21	19		21	20.6	19		22	20	19	19		21	21.8	20	19		21	21.8	20	19
注射压力	Injection pressure	Mpa	230	173	134		213	166	136		208	171	140	119		210	171	146	118		231	188	160	130
理论注射容积	Shot volume	cm³	595	792	1017		877	1126	1370		1198	1458	1786	2099		1723	2110	2481	3063		1944	2381	2799	3456
实际注射量(PS)	Shot weight(ps)	g(克)	540	719	924		780	1002	1219		1088	1324	1590	1869		1534	1879	2209	2727		1769	2166	2547	3145
		OZ(盎司)	19.0	25.4	32.6		27.5	35.3	43.0		38.4	46.7	56.1	65.9		54.1	66.3	77.9	96.2		62.4	76.4	89.8	110.9
注射速率	Injection rate	g/sec	244	324	417		329	423	514		431	524	642	755		502	615	723	892		418	512	602	744
塑化能力(PS)	Plasticizing capacity	g/sec	49	62	81		55	77	89		73	98	109	119		84	99	109	144		84	99	109	144
螺杆转速	Screw speed	rpm	0-222				0-208				0-200				0-188				0-172					
动力/电热	POWER UNIT																							
油泵电机功率	Pump motor power	KW	45.2				55.2				63.6				29.3+45.2				63.6					
加热功率	Heater power	KW	17.2				20.8				27.6				33.2				33.2					
其他	GENERAL																							
油箱容量	Oil tank capacity	L	340				356				470				640				700					
机器重量	Machine weight	Ton	8.5				9.7				15				17				23					
外形尺寸	Machine dimensions (L×W×H)	m×m×m	6.2x1.5x2.2				6.6x1.8x2.2				7.9x1.9x2.2				8.7x2.1x2.2				9.2×2.3×2.1					

技术参数

TECHNICAL PARAMETER

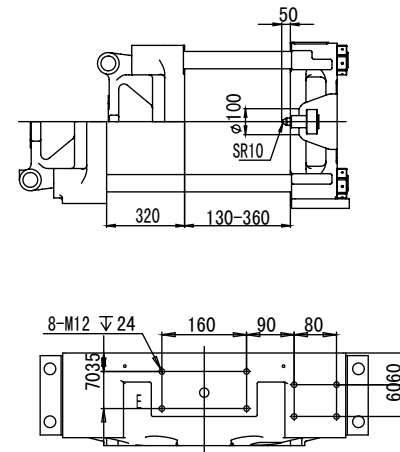
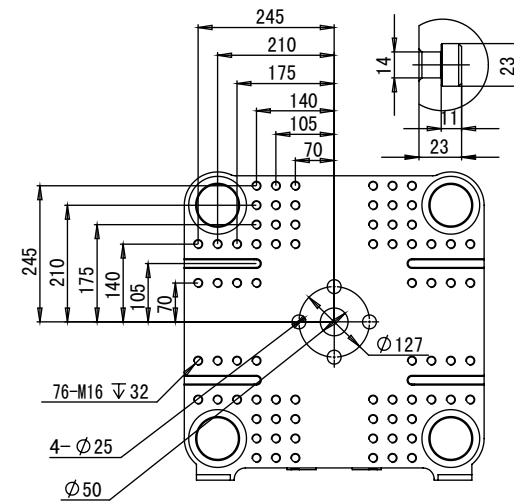
备注：本公司根据产品提升的需要，可对技术参数、部份元件配置及服务内容进行更改，恕不另行通知。
Remarks: According to upgrading of machine, we will change techical parameters, configuration of some parts and service's items without further notice.

说明	DESCRIPTION	单位	KII680-S8				KII850-S8				KII1000-S8				KII1200-S8				KII1380-S8					
国际公认型号	International size rating		6800-5500				8500-7400				10000-9530				12000-9530				13800-12000					
锁模单元	CLAMPING UNIT																							
锁模力	Clamping force	KN	6800				8500				10000				12000				13800					
开模行程	Opening stroke	mm	930				1030				1150				1310				1350					
模板外形尺寸	Platen size	mm×mm	1400X1400				1550x1550				1690x 1690				1800x1800				2000x1950					
导柱内距	Space between bars	mm×mm	940X940				1040X1040				1160x 1160				1250x1250				1420x1280					
最大模厚	Max.mold height	mm	940				1050				1200				1250				1400					
最小模厚	Min.mold height	mm	350				380				500				500				600					
顶针行程	Ejector stroke	mm	280				280				350				320				380					
顶出力	Ejector force	KN	184				184				290				215				300					
顶针数	Ejector number	PCS	1+20				1+20				1+20				1+24				1+24					
注射单元	INJECTION UNIT																							
螺杆直径	Screw diameter	mm	85	90	100	110	90	100	110	120	100	110	120	130	100	110	120	130	110	120	130	140		
螺杆长径比L/D	Screw L/D ratio	-	23.5	22.4	20	18.5	23.5	21	20	18.3	23	21	19.2	18.5	23	21	19.2	18.5	21	21	19.3	18.9		
注射压力	Injection pressure	Mpa	208	186	150	124	235	190	157	132	221	182	153	131	221	182	153	131	204	171	146	127		
理论注射容积	Shot volume	cm³	2667	2990	3691	4464	3149	3888	4704	5598	4320	5227	6220	7300	4320	5227	6220	7300	5892	7012	8229	9544		
实际注射量(PS)	Shot weight(ps)	g(克)	2375	2663	3287	4062	2866	3538	4281	5094	3931	4756	5661	6643	3931	4756	5661	6643	5259	6381	7488	8685		
		OZ(盎司)	83.8	93.9	116.0	143.3	101. 1	124.8	151.0	179.7	138.7	167.8	199.7	234.3	138.7	167.8	199.7	234.3	185.5	167.8	264.1	306.4		
注射速率	Injection rate	g/sec	566	635	784	948	596	736	882	1060	724	876	1043	1224	724	876	1043	1224	892	1061	1163	1349		
塑化能力(PS)	Plasticizing capacity	g/sec	97	113	146	170	118	146	176	209	126	153	182	222	126	153	182	222	123	147	172	208		
螺杆转速	Screw speed	rpm	0-144				0-159				0-127				0-127				0-102					
动力/电热	POWER UNIT																							
油泵电机功率	Pump motor power	KW	37+37				89.5				116.1				116.1				137.2					
加热功率	Heater power	KW	39.3				41.6				49.5				49.5				84.2					
其他	GENERAL																							
油箱容量	Oil tank capacity	L	770				770				945				945				1051					
机器重量	Machine weight	Ton	26				35				50				56				70					
外形尺寸	Machine dimensions (L×W×H)	m×m×m	9.6x2.4x2.1				10.4x2.4x2.2				11.4X2.7X2.5				11.6X2.91X2.5				13X3X3					

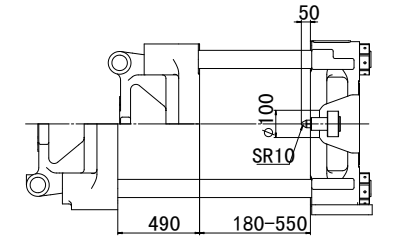
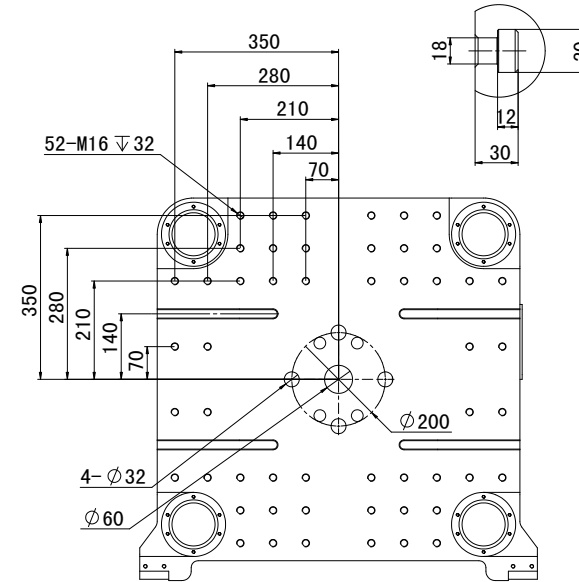
模板尺寸

TECHNICAL PARAMETER

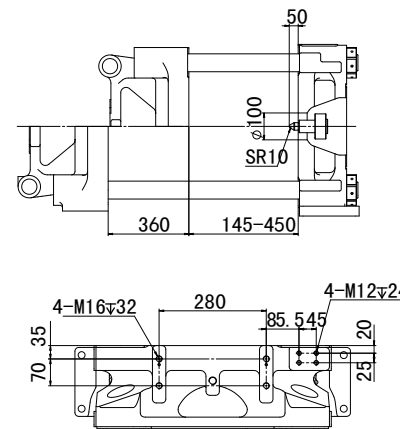
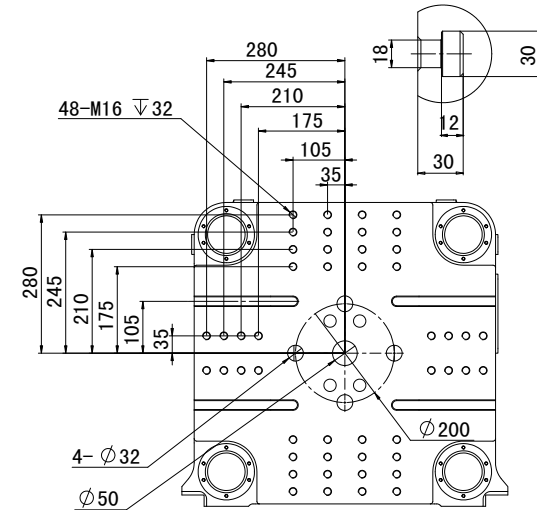
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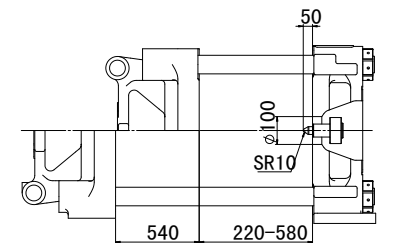
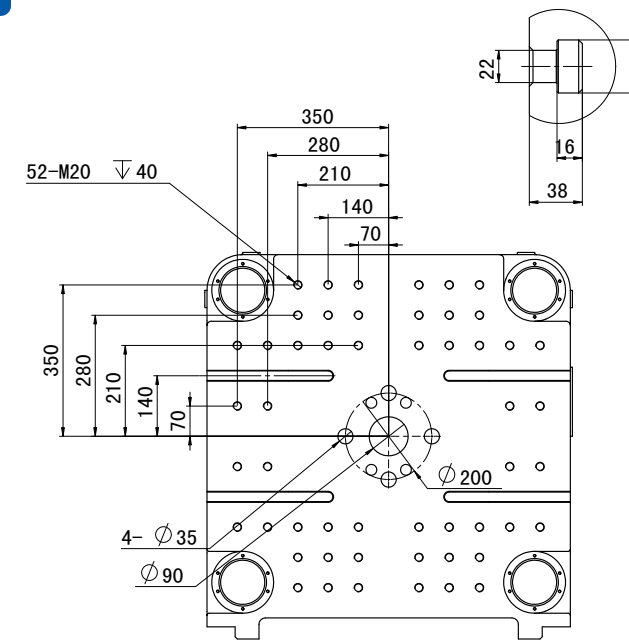
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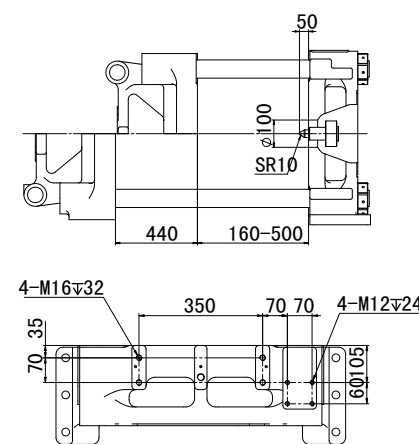
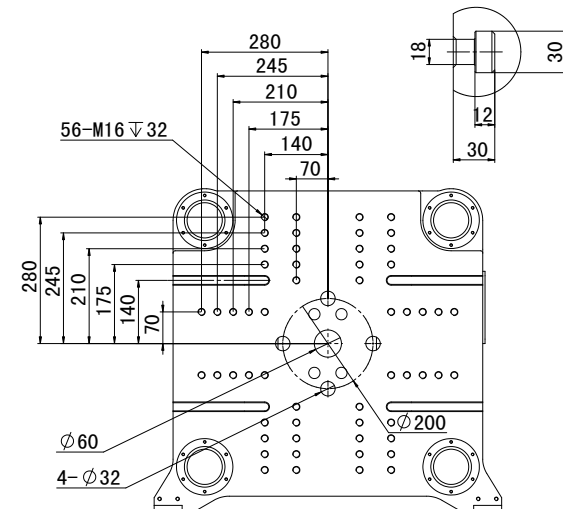
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KII250-S8



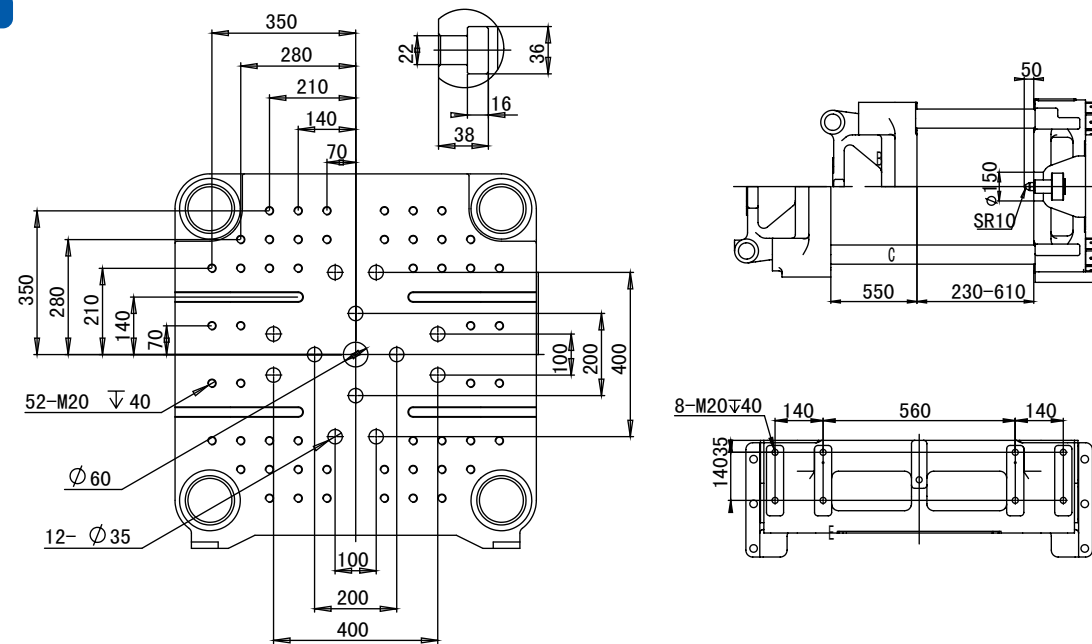
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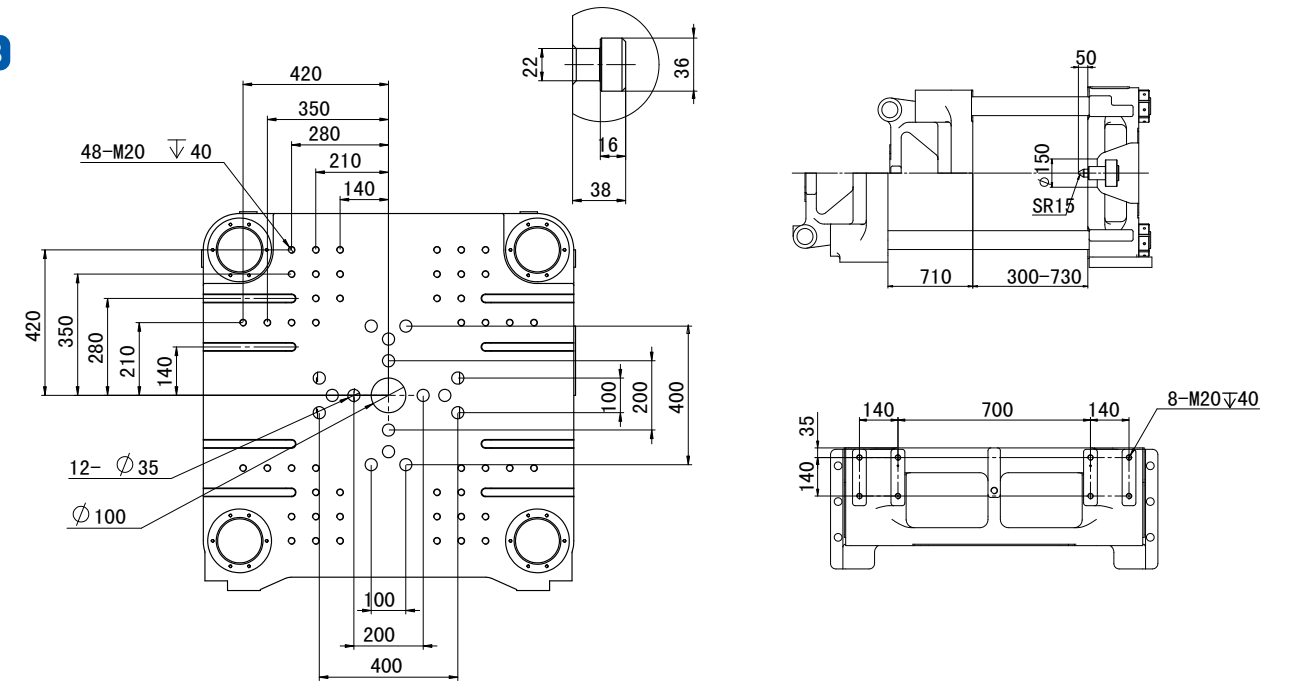
模板尺寸

TECHNICAL PARAMETER

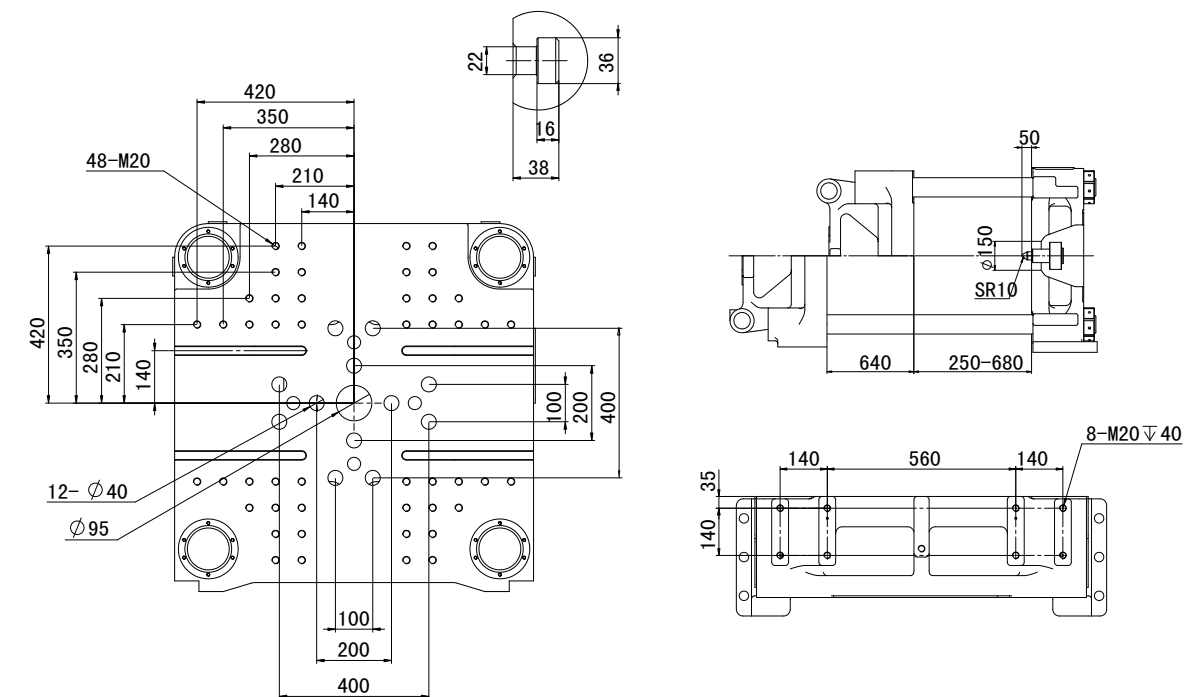
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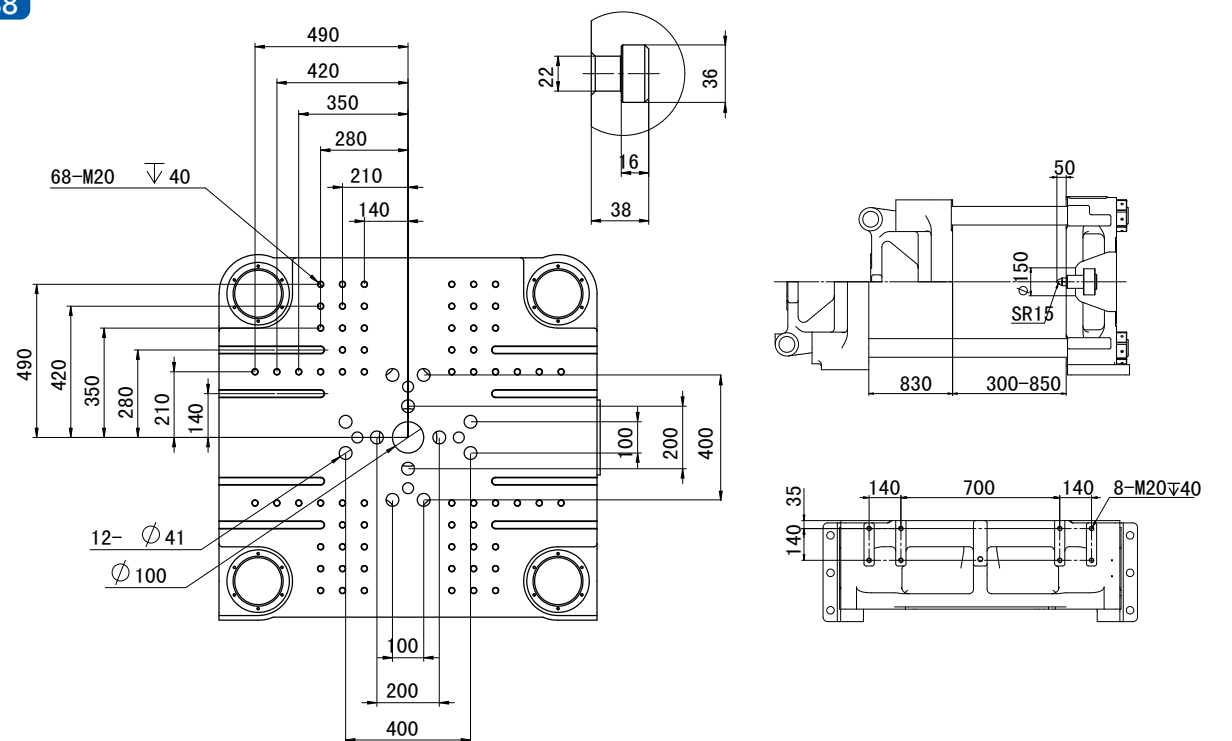
KII400-S8



KII330-S8

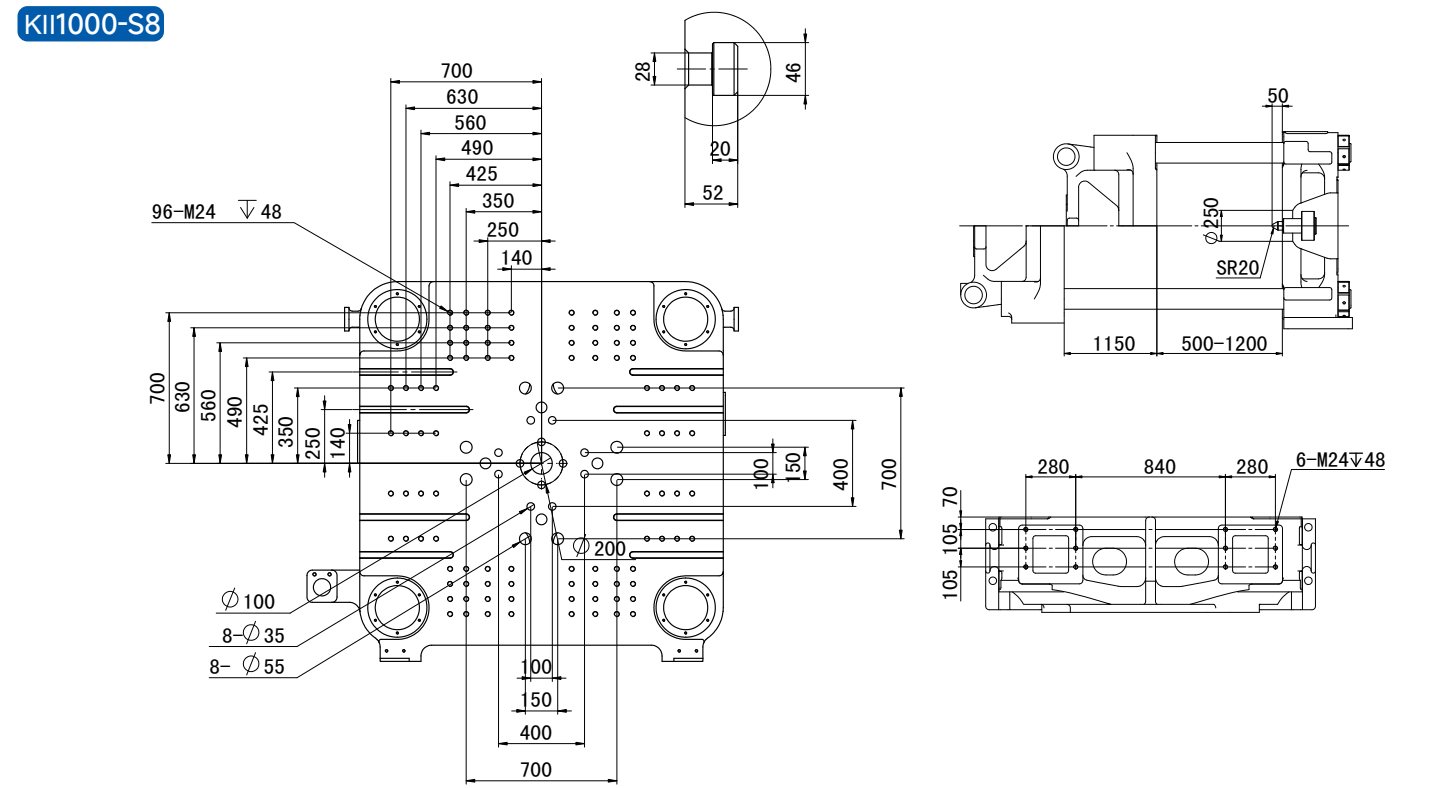
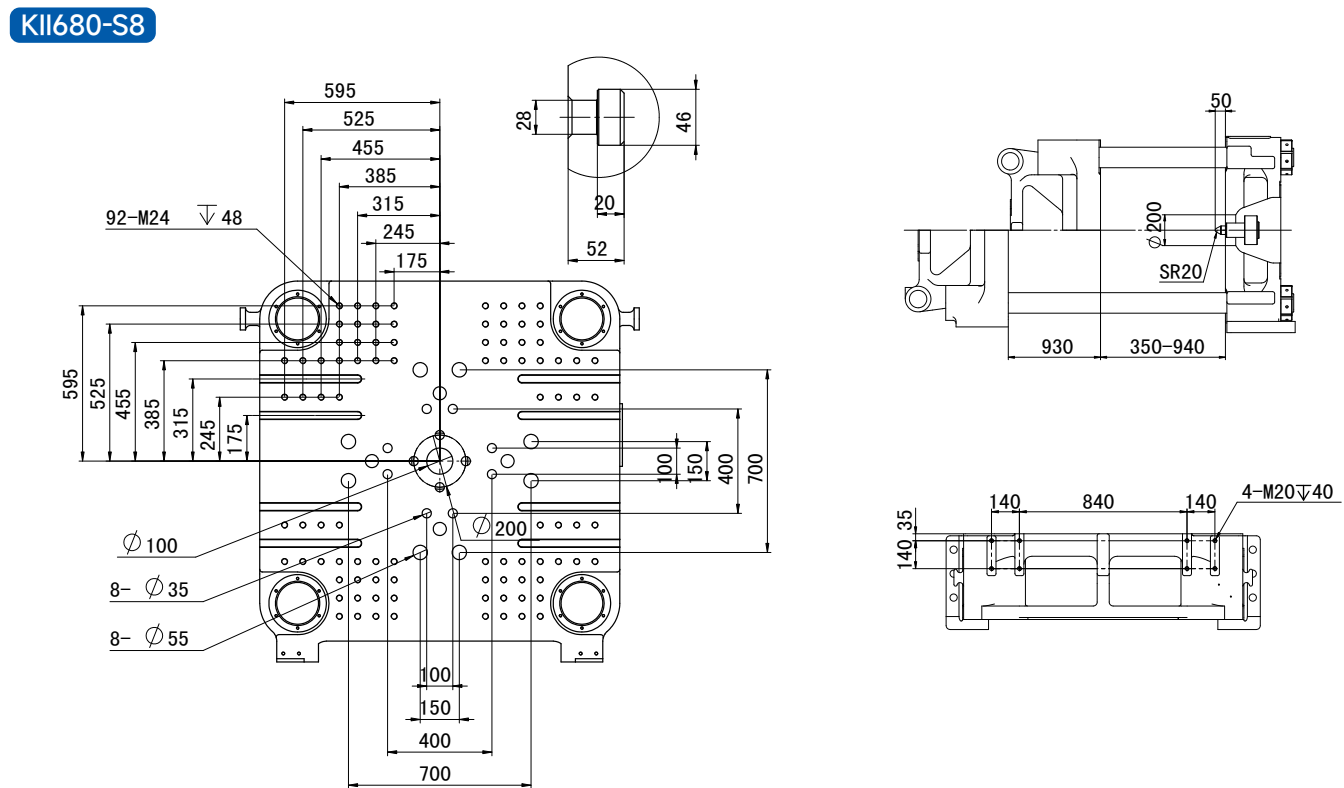
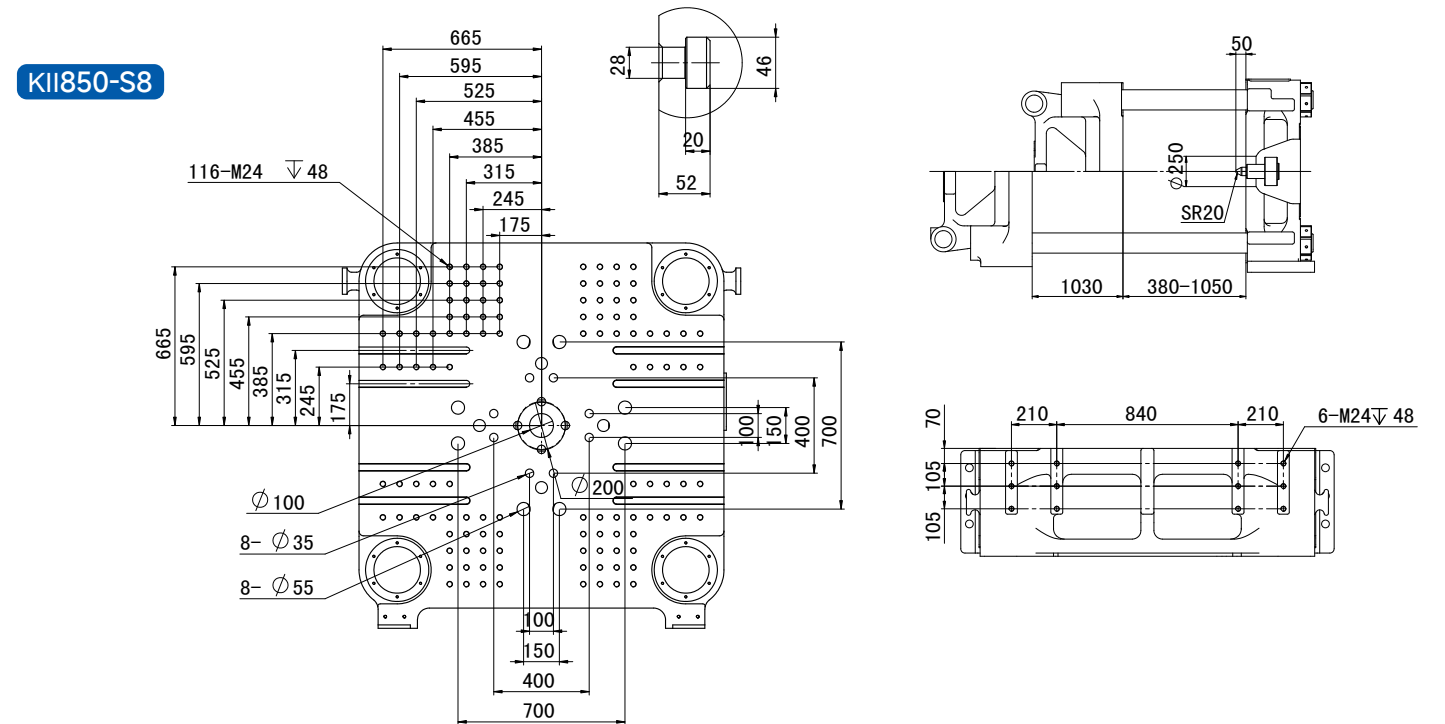
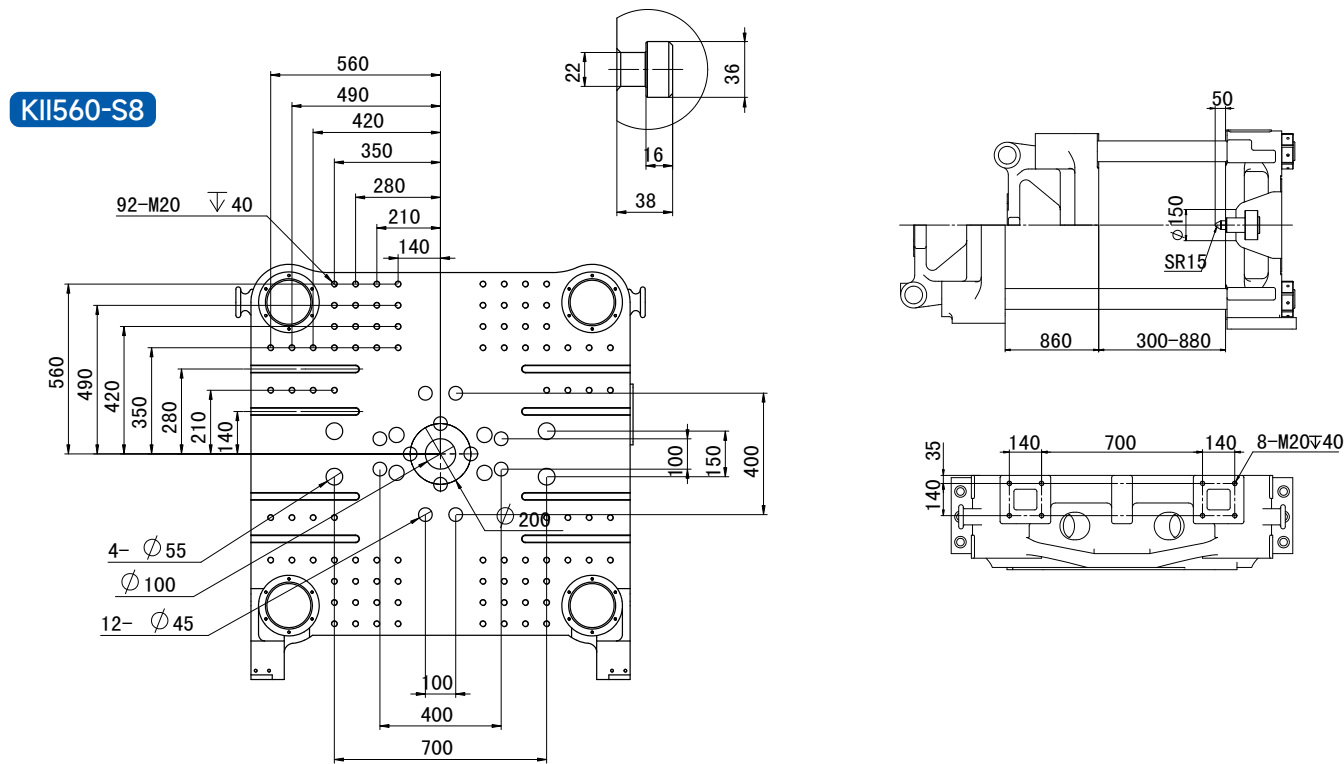


KII500-S8



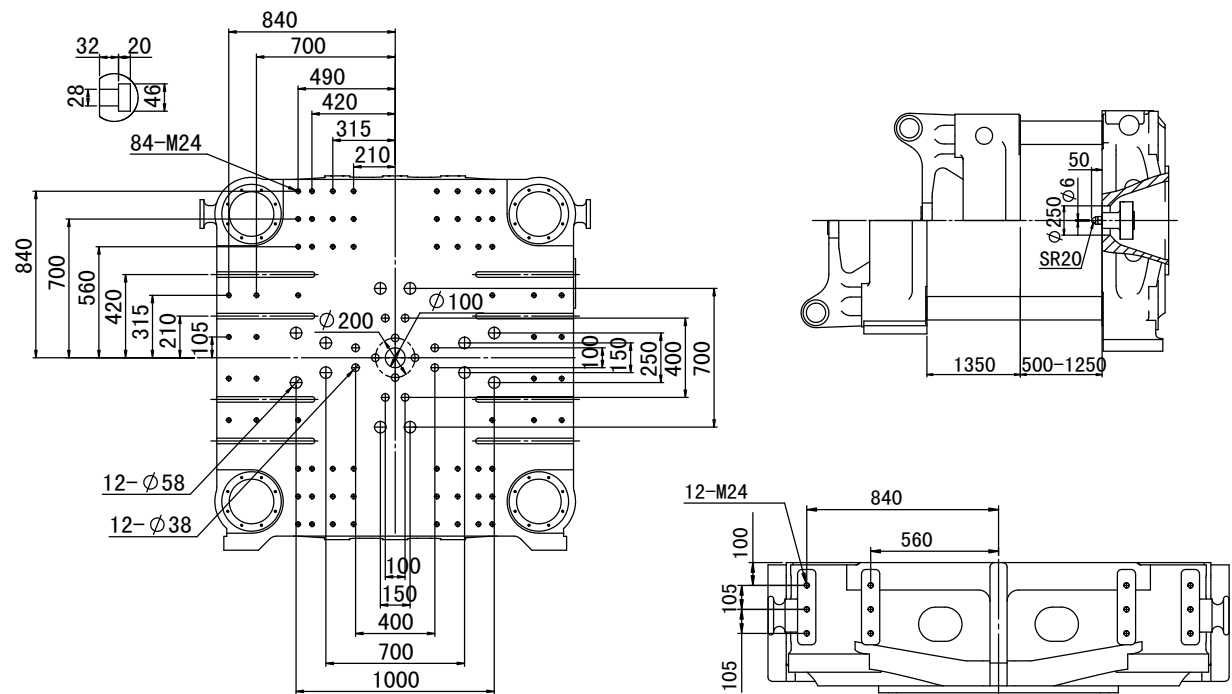
模板尺寸

TECHNICAL PARAMETER



模板尺寸
TECHNICAL PARAMETER

KII1200-S8



KII1380-S8

