

海天塑机集团有限公司
HAITIAN PLASTIC MACHINERY GROUP CO., LTD.

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HT 20221013-CV



Extrusion injection
HA/auriga
 3,600-66,000 kN

Application to the extrusion injection industry

In recent years, with the continuous growth of environmental protection, municipal and other industries, the demand for environmental protection products such as inspection Wells, filter pressure plates, pipelines and other infrastructure is constantly expanding. Under the environment of the country's continuous emphasis on infrastructure construction, the products of the extrusion injection industry will continue to maintain a strong production demand.

A wider range of product sizes and more stringent product stability requirements also put forward higher demand for injection molding machines. Therefore, on the basis of the original large pipe fitting machine, Haitian launched the new HA/auriga series. The new series has a wider range of models, can cover a product line of up to 500KG, equipped with better injection structure and plasticized components, the machine performance is greatly improved.

Product structure

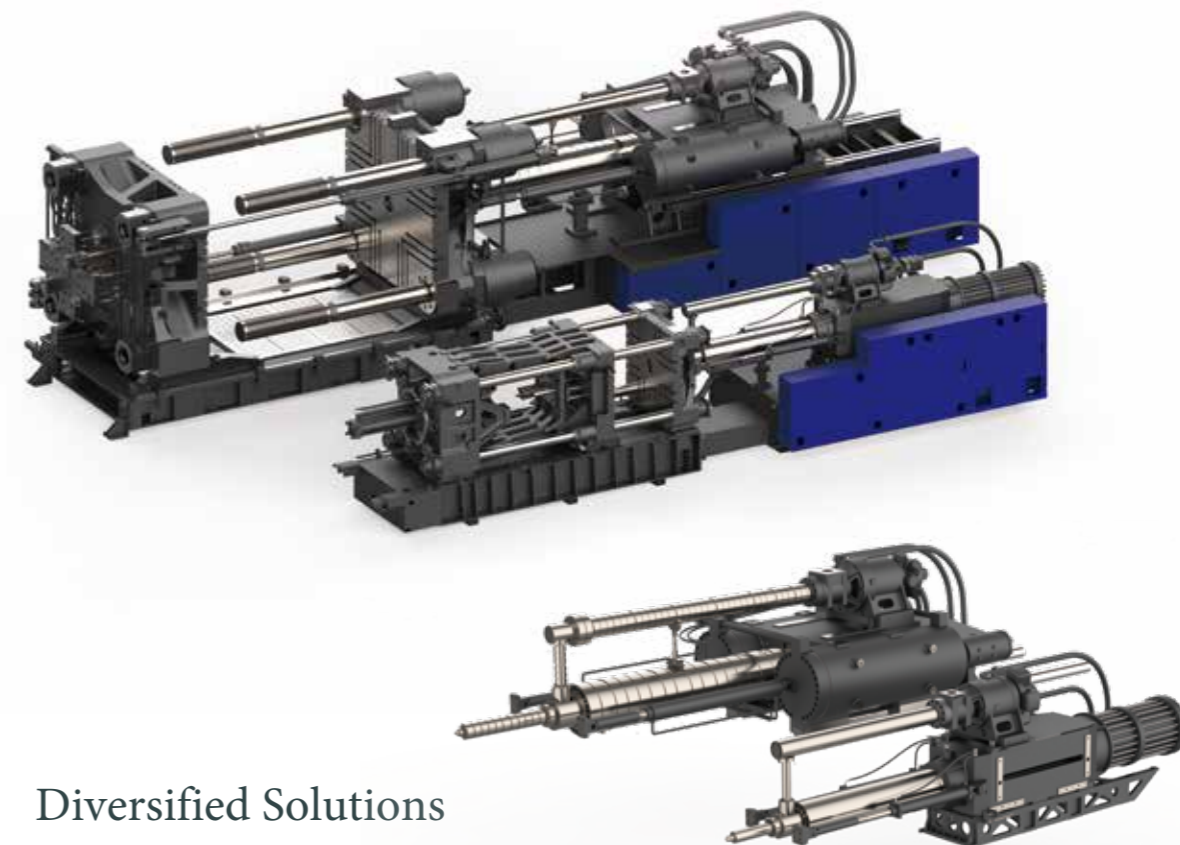


Two platen configuration

Three platen configuration



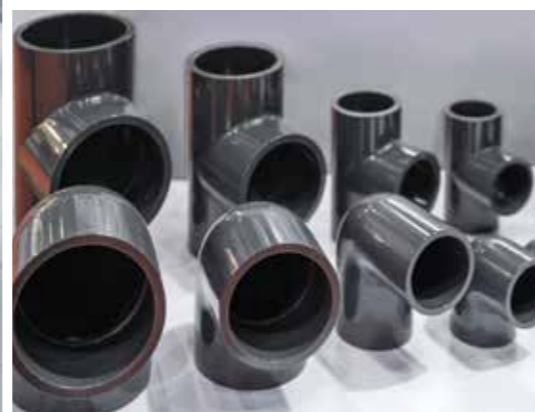
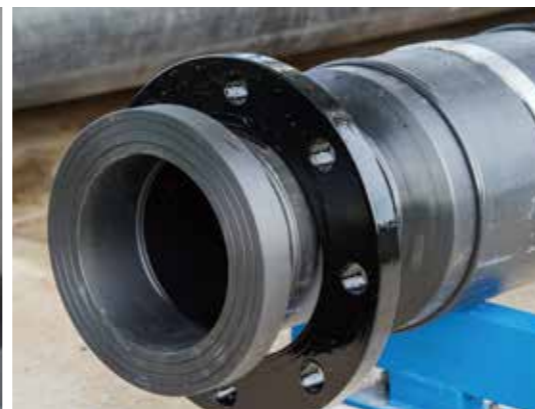
PIPE FITTING



Diversified Solutions

- ◎ A variety of machine types are available.
- ◎ The main products of extrusion injection industry are pipe fitting, inspection well, mud sinking well, filter plate and so on. The product size and weight distribution range is large, and the demand for injection molding machine tonnage and injection volume range is also wide. Haitian launched a new HA/auriga series of extrusion injection industry special machine, a total of 8 kinds of three-platen machine and 9 kinds of two-platen machine, each model according to the product process requirements of injection seat can choose high pressure type or standard type, on this basis can also carry out a variety of similar models similar modules combination;
- ◎ Optimization of injection and charge structure
The HA/auriga series adopts the charge independent two-stage injection structure, which can meet the requirements of large injection weight. Injection unit adopts new structure, stable injection, strong rigidity, to ensure the stability of the product.
- ◎ High wear resistance plasticized components
Extrusion injection industry mostly uses PE, PP and other recycle materials, some will have color mixing agent and other additives, raw material liquidity is poor, the wear resistance of the screw is higher. For this feature, HA/auriga adopts alloy screw barrel to adapt to high wear resistance. In terms of screw structure, HA/auriga adopts high mixing and high efficiency wear-resistant screw, which can meet the requirements of color mixing and wear-resisting, and has excellent plasticizing ability and plasticizing effect.
- ◎ High cost performance options
In view of the characteristics of extrusion injection industry, such as large injection volume, multiple core-pulling and long cycle, the special machine launches cost-effective selection schemes, including plunger blower, core diameter increase, mold auxiliary support, heating energy-saving insulation, and the opening of the machine base under the mold, which effectively improves the machine performance and shortens the production cycle.

Application to the extrusion injection industry



Machine: HA3600/4500 auriga
Product: Straight fitting
Size: D150mm
Cavity: 1
Weight: 1.8kg



Machine: HA12500/41000 auriga
Product: Reducer
Size: D400mm×250mm
Cavity: 1
Weight: 37kg



Machine: HA28000/189300auriga
Product: Tee
Size: D630mm
Cavity: 1
Weight: 142kg



Machine: HA12500/28000hp auriga
Product: Rain sinks mud Wells
Size: D315mm×300mm
Cavity: 1
Weight: 6.8kg



Machine: HA28000/132300hp auriga
Product: Four way mud sinking well
Size: D700mm X 600mm
Cavity: 1
Weight: 36kg



Machine: HA41000/189300hp auriga
Product: Inspection well
Size: D1000mm×700mm
Cavity: 1
Weight: 80kg



Machine: HA41000/260300 auriga
Product: Filter plate
Size: 2000mm×2000mm×80mm
Cavity: 1
Weight: 180kg

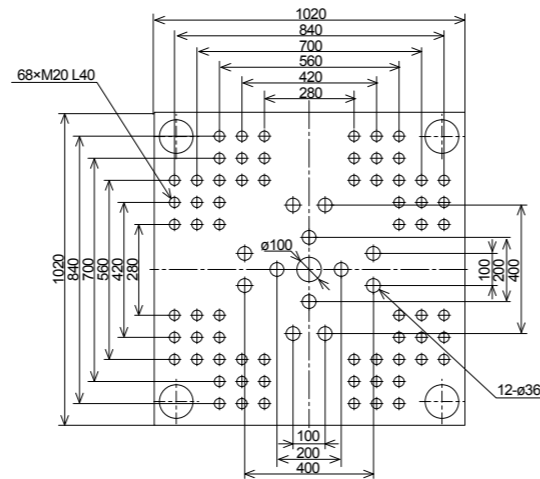


Machine: HA55000/325300 auriga
Product: Filter plate
Size: 2500x2200x80mm
Cavity:1
Weight: 280kg

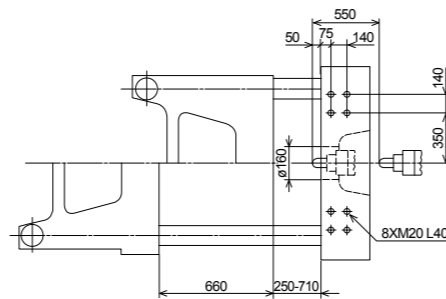
HA3600auriga

		HA3600	
CLAMPING UNIT		Three-Platen	
Clamping force	kN	3600	
Mold opening stroke	mm	660	
Dist.between tie bars(HXV)	mm	710x710	
Mold height max.	mm	710	
Mold height min.	mm	250	
Ejector stroke	mm	160	
Ejector force	kN	110	
INJECTION UNIT		4500hp	4500
Screw diameter	mm	70	70
Screw L/D ratio		25	25
Piston diameter	mm	95	120
Injection volume(theoretical)	cm ³	3544	5655
Injection weight(PE)	g	2587	4128
Injection rate(PE)	cm ³ /s	469	480
Injection pressure	MPa	128	80
Screw speed	rpm	175	110
OTHERS			
Pump motor power	kW	45	30
Heater power	kW	75	75
Machine weight	t	18.5	20.5
Hopper capacity	kg	100	100
Oil tank	l	600	600
Machine dimension(LxWxH)	m	8.4x2.0x3.3	8.4x2.0x3.3
Nozzle	mm	8	10
Nozzle radius	mm	SR20	SR20

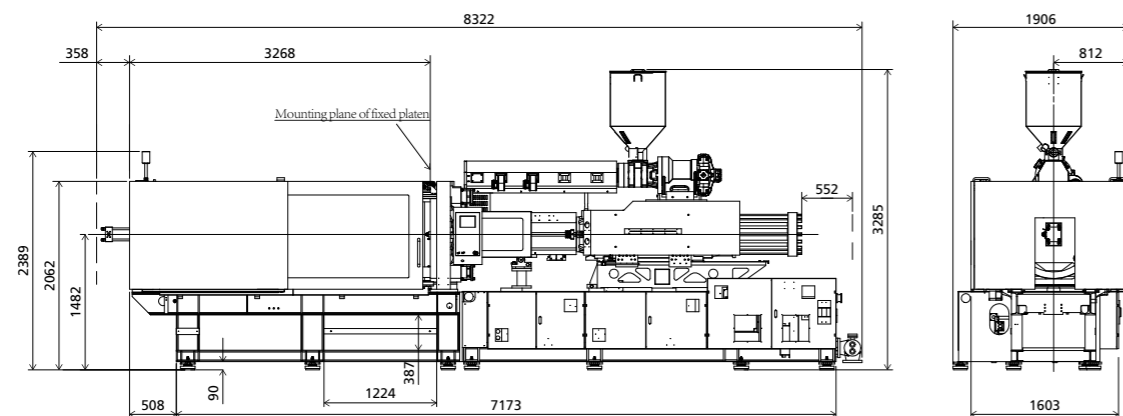
Moving platen dimensions



Platen side dimensions



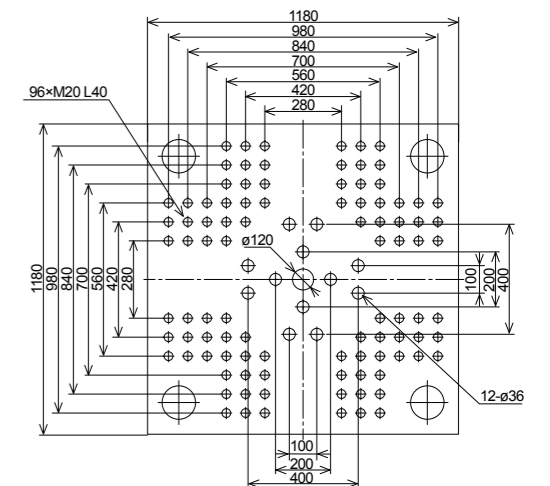
Machine dimensions



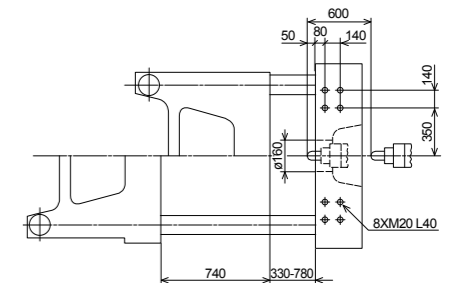
HA4500auriga

		HA4500	
CLAMPING UNIT		Three-Platen	
Clamping force	kN	4500	
Mold opening stroke	mm	740	
Dist.between tie bars(HXV)	mm	780x780	
Mold height max.	mm	780	
Mold height min.	mm	330	
Ejector stroke	mm	200	
Ejector force	kN	110	
INJECTION UNIT		8200hp	8200
Screw diameter	mm	80	80
Screw L/D ratio		25	25
Piston diameter	mm	110	140
Injection volume(theoretical)	cm ³	6177	10006
Injection weight(PE)	g	4509	7304
Injection rate(PE)	cm ³ /s	541	600
Injection pressure	MPa	132	82
Screw speed	rpm	108	70
OTHERS			
Pump motor power	kW	55	37
Heater power	kW	86	86
Machine weight	t	22.8	23.5
Hopper capacity	kg	100	100
Oil tank	l	760	760
Machine dimension(LxWxH)	m	9.5x2.1x3.4	9.5x2.1x3.4
Nozzle	mm	8	10
Nozzle radius	mm	SR20	SR20

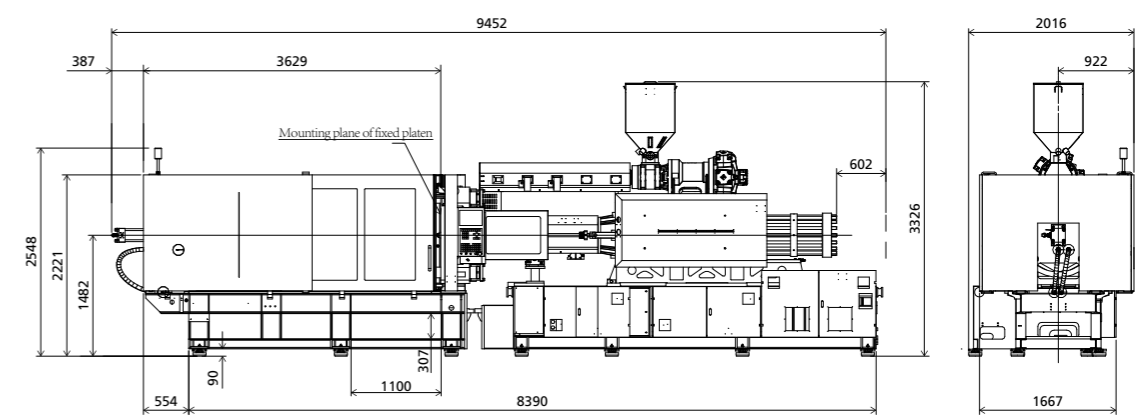
Moving platen dimensions



Platen side dimensions



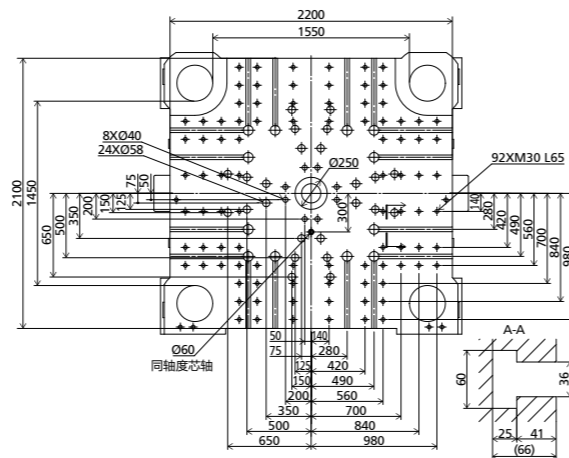
Machine dimension



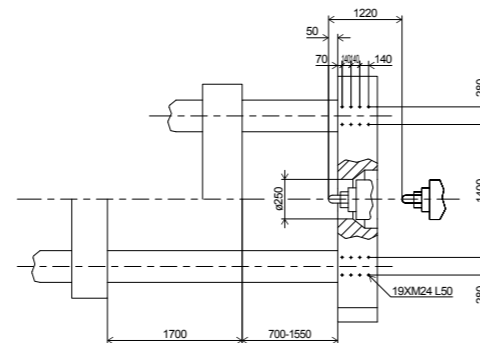
HA16000auriga

		HA16000	
CLAMPING UNIT		Two-Platen	
Clamping force	kN	16000	
Dist.between tie bars(HXV)	mm	1550x1450	
Mold height max.	mm	1550	
Mold height min.	mm	700	
Ejector stroke	mm	400	
Ejector force	kN	330	
Max. daylight	mm	3250	
Mold opening stroke①	mm	2550/1700	
Max. mold weight②	t	33	
INJECTION UNIT		81300hp	81300
Screw diameter	mm	100	100
Screw L/D ratio	L/D	30	30
Piston diameter	mm	210	270
Injection volume(theoretical)	cm ³	60613	100197
Injection weight(PE)	g	44247	73144
Injection rate(PE)	cm ³ /s	2149	2042
Injection pressure	MPa	134	81
Screw speed	rpm	110	110
OTHERS			
Pump motor power	kW	30+75x3+3.75	75x2+3.75
Heater power	kW	217	217
Machine weight	t	94	95
Hopper capacity	kg	400	400
Oil tank	l	1950	1550
Machine dimension(LxWxH)	m	13.4x3.8x5.1	13.4x3.7x5.1
Nozzle	mm	12	12
Nozzle radius	mm	SR20	SR20

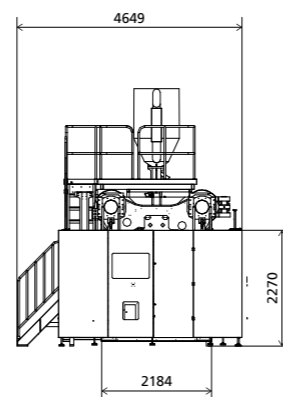
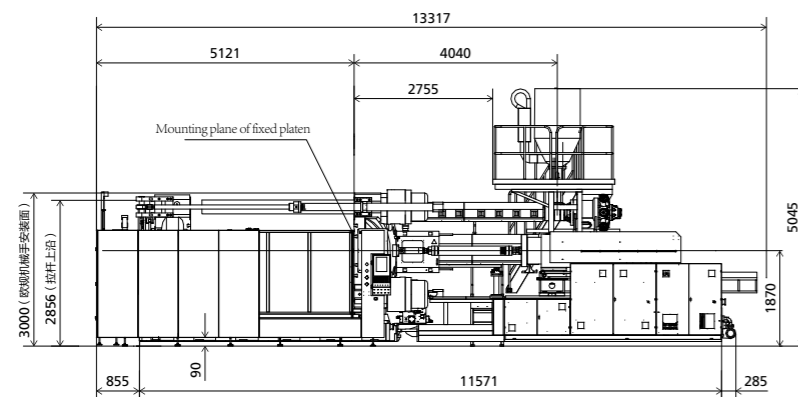
Moving platen dimensions



Platen side dimensions



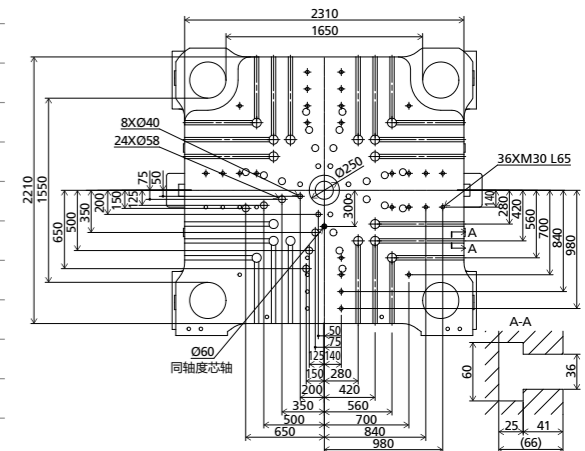
Machine dimension



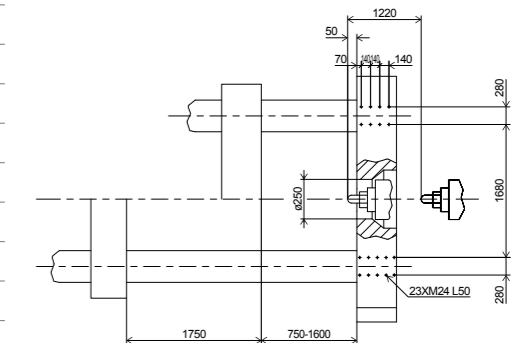
HA18500auriga

		HA18500	
CLAMPING UNIT		Two-Platen	
Clamping force	kN	18500	
Dist.between tie bars(HXV)	mm	1650x1550	
Mold height max.	mm	1600	
Mold height min.	mm	750	
Ejector stroke	mm	450	
Ejector force	kN	450	
Max. daylight	mm	3350	
Mold opening stroke①	mm	2600/1750	
Max. mold weight②	t	40	
INJECTION UNIT		81300hp	81300
Screw diameter	mm	100	100
Screw L/D ratio	L/D	30	30
Piston diameter	mm	210	270
Injection volume(theoretical)	cm ³	60613	100197
Injection weight(PE)	g	44247	73144
Injection rate(PE)	cm ³ /s	2149	2042
Injection pressure	MPa	134	81
Screw speed	rpm	110	110
OTHERS			
Pump motor power	kW	30+75x3+3.75	75x2+3.75
Heater power	kW	217	217
Machine weight	t	104	105
Hopper capacity	kg	400	400
Oil tank	l	1950	1550
Machine dimension(LxWxH)	m	13.7x3.9x5.2	13.7x3.9x5.2
Nozzle	mm	12	12
Nozzle radius	mm	SR20	SR20

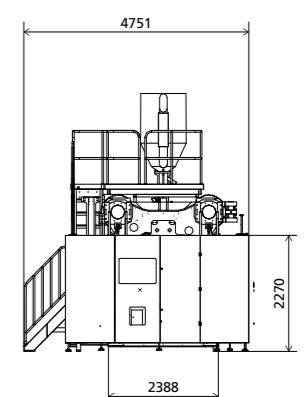
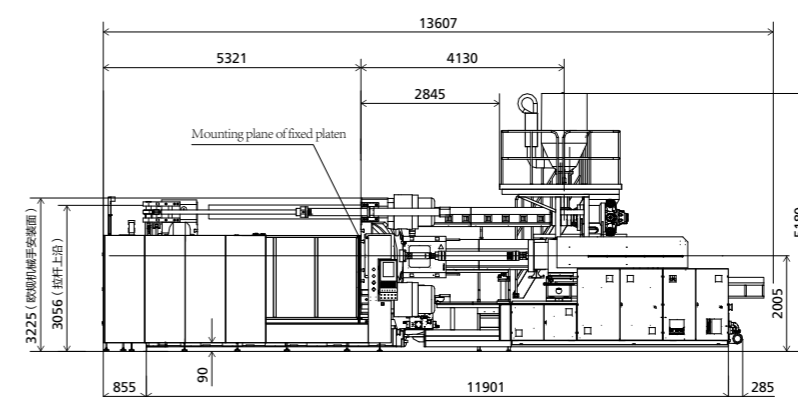
Moving platen dimensions



Platen side dimensions



Machine dimension



NOTE:

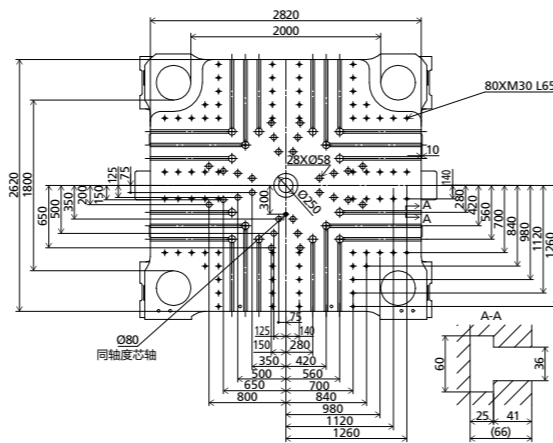
- with min. mold height /with max. mold height
- moving platen: 2/3 of max. mold weight.

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

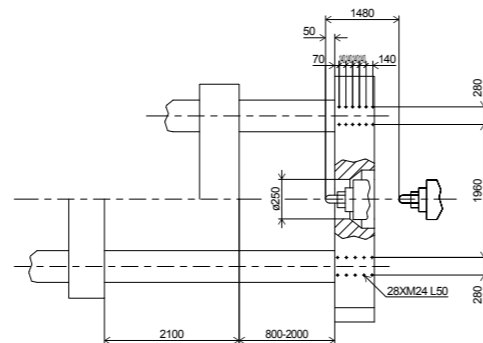
HA28000auriga

		HA28000	
CLAMPING UNIT		Two-Platen	
Clamping force	kN	28000	
Dist.between tie bars(HXV)	mm	2000×1800	
Mold height max.	mm	2000	
Mold height min.	mm	800	
Ejector stroke	mm	500	
Ejector force	kN	450	
Max. daylight	mm	4100	
Mold opening stroke①	mm	3300/2100	
Max. mold weight②	t	66	
INJECTION UNIT		189300hp	189300
Screw diameter	mm	120	120
Screw L/D ratio	L/D	30	30
Piston diameter	mm	270	340
Injection volume(theoretical)	cm ³	143138	226980
Injection weight(PE)	g	104491	165695
Injection rate(PE)	cm ³ /s	3021	2797
Injection pressure	MPa	132	83
Screw speed	rpm	110	110
OTHERS			
Pump motor power	kW	45+75×4+3.75	45+75×2+3.75
Heater power	kW	323	323
Machine weight	t	175	177
Hopper capacity	kg	400	400
Oil tank	l	3250	2750
Machine dimension(LxWxH)	m	17.1×4.3×5.6	17.1×4.3×5.6
Nozzle	mm	16	20
Nozzle radius	mm	SR20	SR20

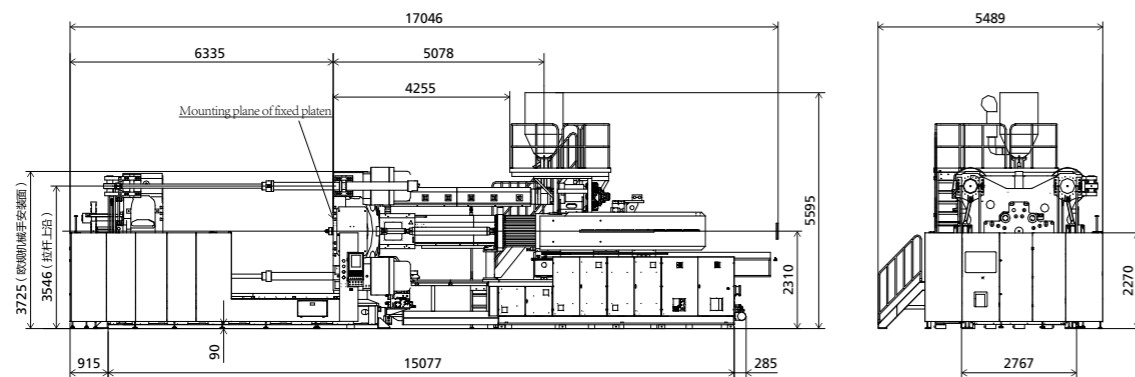
Moving platen dimensions



Platen side dimensions



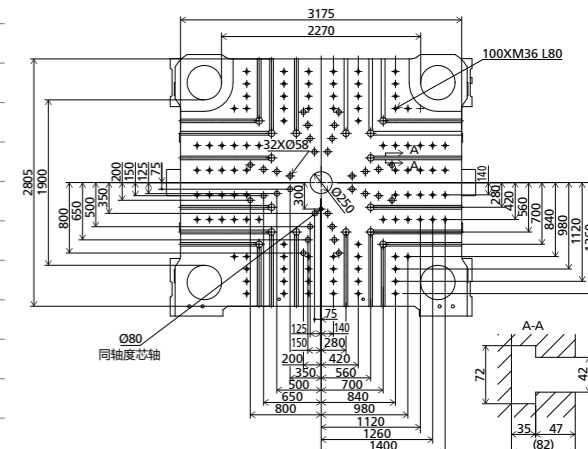
Machine dimension



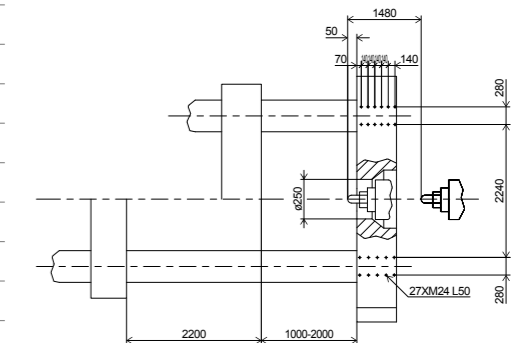
HA33000auriga

		HA33000	
CLAMPING UNIT		Two-Platen	
Clamping force	kN	33000	
Dist.between tie bars(HXV)	mm	2270×1900	
Mold height max.	mm	2000	
Mold height min.	mm	1000	
Ejector stroke	mm	550	
Ejector force	kN	580	
Max. daylight	mm	4200	
Mold opening stroke①	mm	3200/2200	
Max. mold weight②	t	75	
INJECTION UNIT		189300hp	189300
Screw diameter	mm	120	120
Screw L/D ratio	L/D	30	30
Piston diameter	mm	270	340
Injection volume(theoretical)	cm ³	143138	226980
Injection weight(PE)	g	104491	165695
Injection rate(PE)	cm ³ /s	3021	2797
Injection pressure	MPa	132	83
Screw speed	rpm	110	110
OTHERS			
Pump motor power	kW	45+75×4+3.75	45+75×2+3.75
Heater power	kW	326	326
Machine weight	t	205	207
Hopper capacity	kg	400	400
Oil tank	l	3250	2750
Machine dimension(LxWxH)	m	17.5×4.7×6.0	17.5×4.7×6.0
Nozzle	mm	16	20
Nozzle radius	mm	SR20	SR20

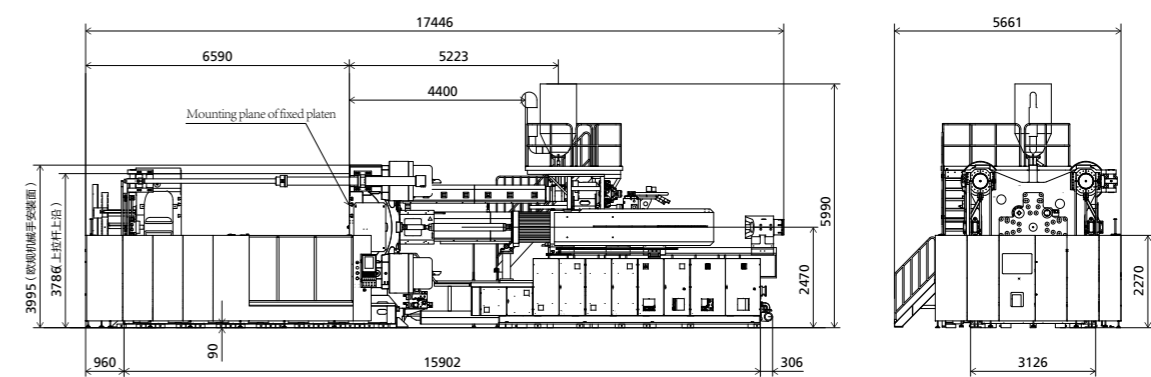
Moving platen dimensions



Platen side dimensions



Machine dimension



NOTE:

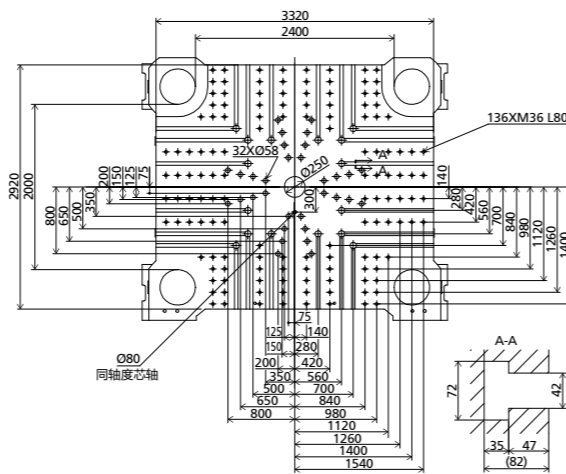
- with min. mold height /with max. mold height
- moving platen: 2/3 of max. mold weight.

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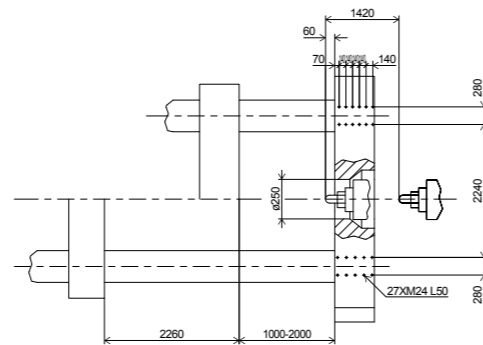
HA41000auriga

		HA41000	
CLAMPING UNIT		Two-Platen	
Clamping force	kN	41000	
Dist.between tie bars(HXV)	mm	2400×2000	
Mold height max.	mm	2200	
Mold height min.	mm	1000	
Ejector stroke	mm	550	
Ejector force	kN	580	
Max.daylight	mm	4460	
Mold opening stroke①	mm	3460/2260	
Max. mold weight②	t	86	
INJECTION UNIT		260300hp	260300
Screw diameter	mm	140	140
Screw L/D ratio	L/D	30	30
Piston diameter	mm	300	400
Injection volume(theoretical)	cm ³	197920	351858
Injection weight(PE)	g	144482	256856
Injection rate(PE)	cm ³ /s	3153	3900
Injection pressure	MPa	131	74
Screw speed	rpm	110	110
OTHERS			
Pump motor power	kW	75×5+3.75	30+75×3+3.75
Heater power	kW	370	392
Machine weight	t	255	257
Hopper capacity	kg	600	600
Oil tank	l	4050	4050
Machine dimension(LxWxH)	m	18.6×5.3×6.1	18.6×5.3×6.1
Nozzle	mm	20	30
Nozzle radius	mm	SR30	SR40

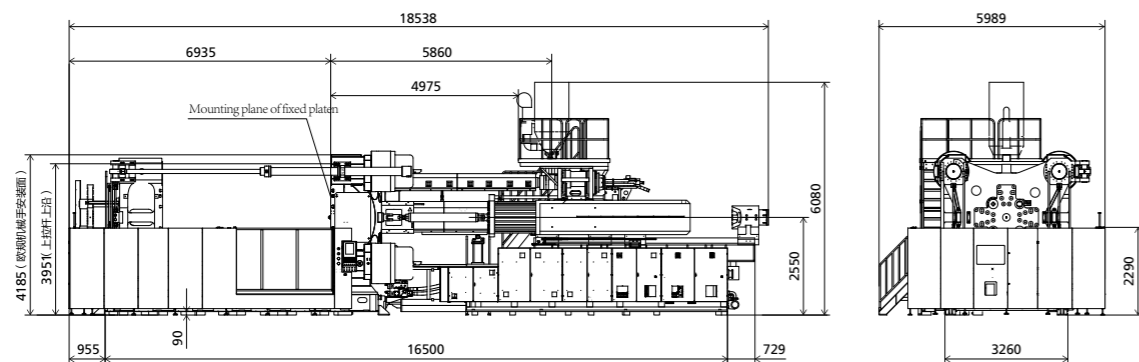
Moving platen dimensions



Platen side dimensions



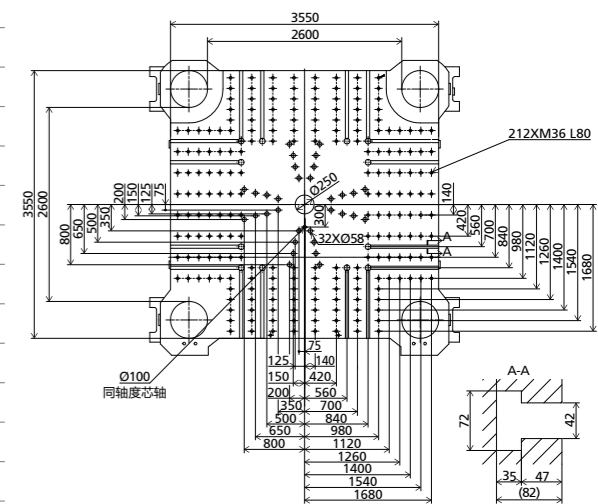
Machine dimension



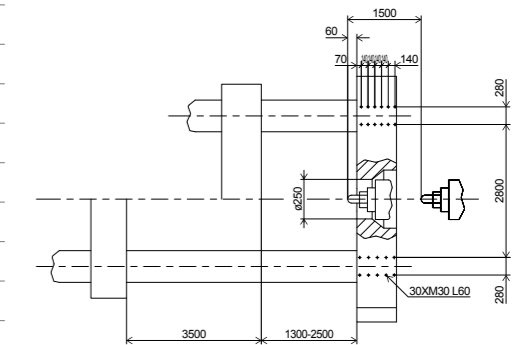
HA55000auriga

		HA55000	
CLAMPING UNIT		Two-Platen	
Clamping force	kN	55000	
Dist.between tie bars(HXV)	mm	2600×2600	
Mold height max.	mm	2500	
Mold height min.	mm	1300	
Ejector stroke	mm	600	
Ejector force	kN	800	
Max. daylight	mm	6000	
Mold opening stroke①	mm	4700/3500	
Max. mold weight②	t	130	
INJECTION UNIT		325300hp	325300
Screw diameter	mm	150	150
Screw L/D ratio	L/D	30	30
Piston diameter	mm	340	450
Injection volume(theoretical)	cm ³	258757	453272
Injection weight(PE)	g	188893	330889
Injection rate(PE)	cm ³ /s	3960	5179
Injection pressure	MPa	125	70
Screw speed	rpm	100	100
OTHERS			
Pump motor power	kW	75×6+3.75	30+75×4+3.75
Heater power	kW	420	447
Machine weight	t	410	410
Hopper capacity	kg	600	600
Oil tank	l	4050	4050
Machine dimension(LxWxH)	m	20.7×5.8×6.7	20.7×5.8×6.7
Nozzle	mm	30	30
Nozzle radius	mm	SR40	SR40

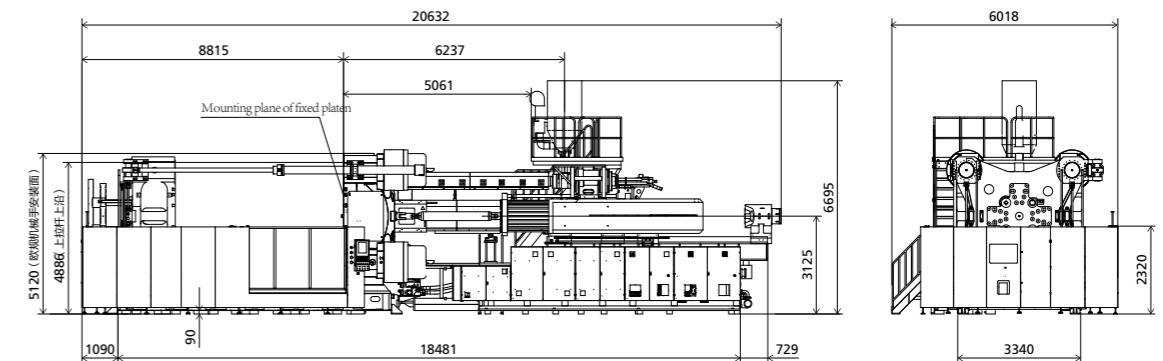
Moving platen dimensions



Platen side dimensions



Machine dimension



NOTE:

- with min. mold height /with max. mold height
- moving platen: 2/3 of max. mold weight.

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