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PVC industry application
 HA/PVC



HT 20220621-CV

PVC industry application

PVC has excellent weather resistance and mechanical properties, in building materials, industrial products, civilian supplies and other industries are widely used. With the continuous development of the real estate and home improvement industry, the market demand for PVC pipe fittings has been high.

According to the processing characteristics of PVC raw materials and the technological characteristics of products, a new generation of HA-PVC special machine was optimized and developed. Suitable for producing all kinds of hard PVC products, PPR pipe fittings (special options), PE pipe fittings (special options), etc.

Main feature

- » Adopt high quality chrome plated screw, end cap and nozzle, corrosion resistance and anti viscosity can be better;
- » According to the requirements of raw materials and products matching the most suitable plastic parts, to ensure better product quality;
- » For hard PVC larger charging load, equipped with preferred high torque motor, stable and more durable;
- » Intelligent algorithm for mold open/close, Easier operation and improve accuracy;
- » Equipped with full closed-loop injection function to improve injection accuracy;
- » Equipped with J6 card, easy to realize automation;
- » Optional Haitian standard widened protective door, specially designed for pipe fitting mold, convenient for customers to install mold.



High matching plasticized parts

According to the requirements of raw materials and products matching the most suitable plastic parts, to ensure better product quality



Accurate barrel temperature control system

In view of the narrow temperature range of PVC processing molding, the barrel is equipped with air-cooled temperature control system to improve the temperature control accuracy



Increase of charging motor power

Increase of charging motor power, equipped with preferred low speed and high torque motor, more stable and durable



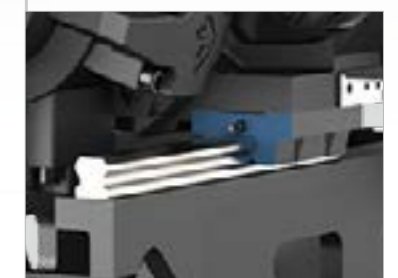
Intelligent algorithm for mold open/close

Easier operation, more accurate repeated positioning accuracy, faster dry cycle



High driving force servo system

New high driving force servo system, to achieve high dynamic, high response ability



linear guide rails are used for injection movement

High rigidity injection unit, low friction coefficient, high operation precision, low energy consumption

PVC industry application



Application1

Machine: HA4500/2950B
Product: UPVC TEE
Cavity: 2
Total Weight: 1073g



Application2

Machine: HA2500/1000B
Product: CPVC FLANGE
Cavity: 1
Total Weight: 725g
*To select CPVC options



Application3

Machine: HA6550/4550B
Product: PE FIFTING
Cavity: 4
Total Weight: 1450g
*To select PE/PPR options



Application4

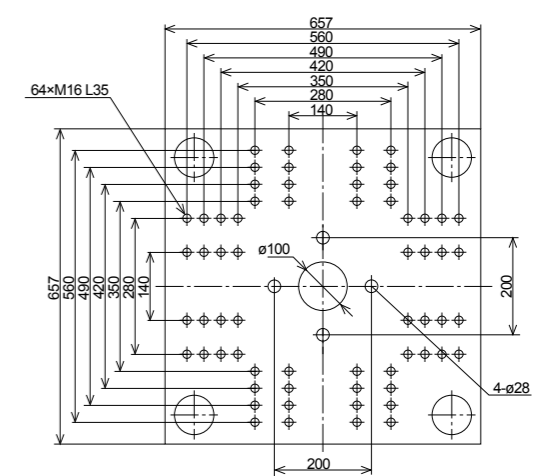
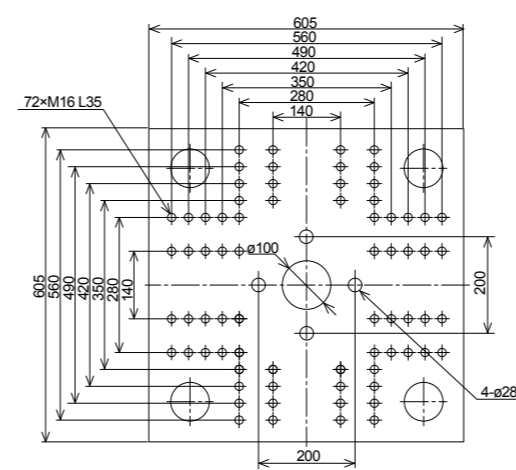
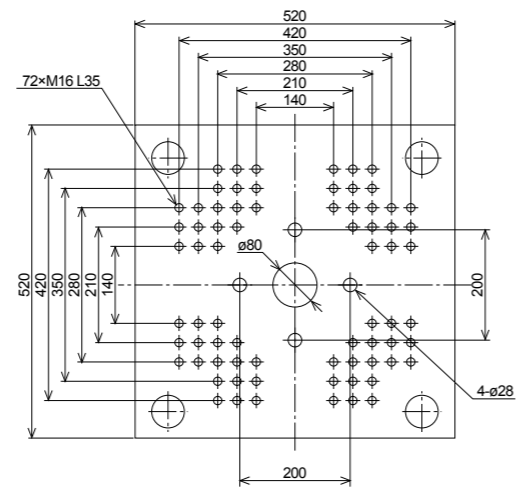
Machine: HA10000/7950B
Product: PPR FIFTING
Cavity: 8
Total Weight: 2830g
*To select PE/PPR options



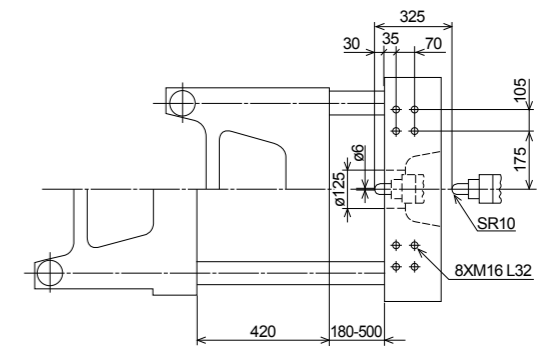
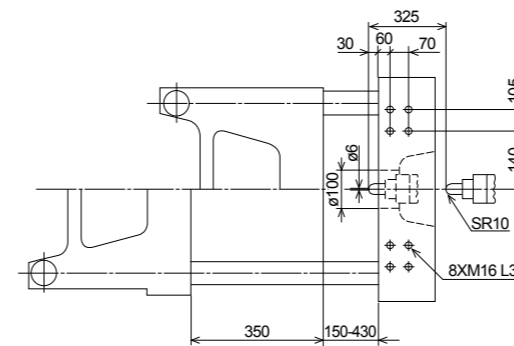
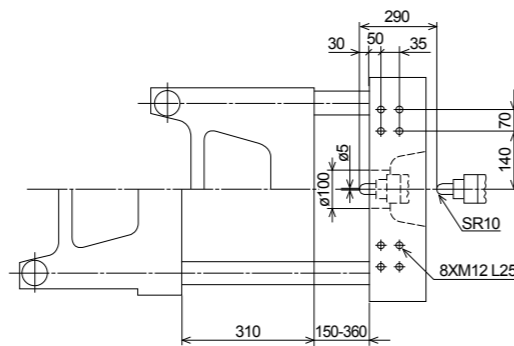
PVC industry application HA/PVC (860-1600 kN)

	HA860/280PVC		HA1200/400PVC		HA1600/570PVC		
INJECTION UNIT							
Screw diameter	mm	B 36	C 40	B 40	C 45	B 45	C 50
Screw L/D ratio	L/D	22.5	22	22.9	22	21.3	22
Injection volume (theoretical)	cm ³	152	188	213	270	319	394
Injection weight (PVC)	g	182	226	256	324	383	473
Injection rate (PVC)	g/s	113	140	124	157	164	203
Injection pressure	MPa	187	151	187	147	178	145
Screw speed	rpm	210	175	190	145	185	122
CLAMPING UNIT							
Clamping force	kN	860		1200		1600	
Mold opening stroke	mm	310		350		420	
Dist. between tie bars (HxV)	mm	360x360		410x410		470x470	
Mold height max.	mm	360		430		500	
Mold height min.	mm	150		150		180	
Ejector stroke	mm	100		120		140	
Ejector tonnage	kN	33		33		33	
OTHERS							
Pump motor power	kW	13		13		18.5	
Heater power	kW	5.2	5.7	10.6	11.4	10.6	12.2
Machine dimension (LxWxH)	m	4.11x1.2x1.8		4.60x1.2x1.8		5.1x1.3x1.90	
Machine weight	t	3		4.1		4.9	
Hopper capacity	kg	25		25		50	
Oil tank	l	130		160		185	

Platen dimensions
Moving platen



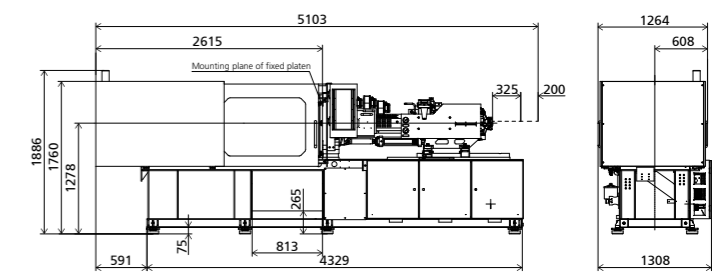
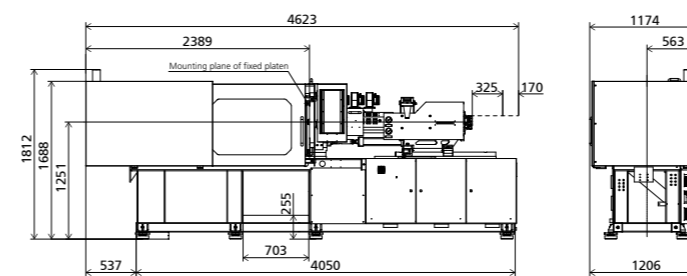
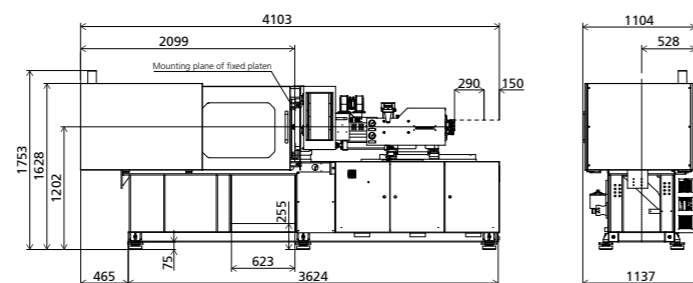
Platen dimensions
Mounting hole for robot/sprue picker top view from fixed platen



Machine dimensions

Note: ① Value in "()" is the size of C screw

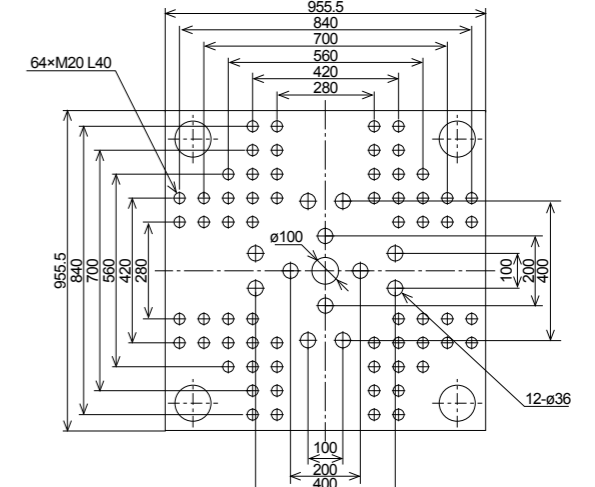
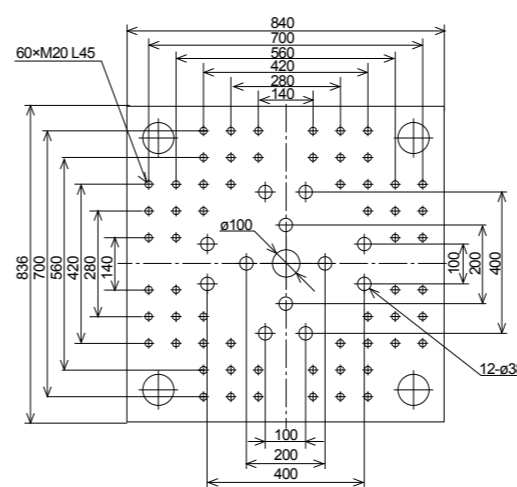
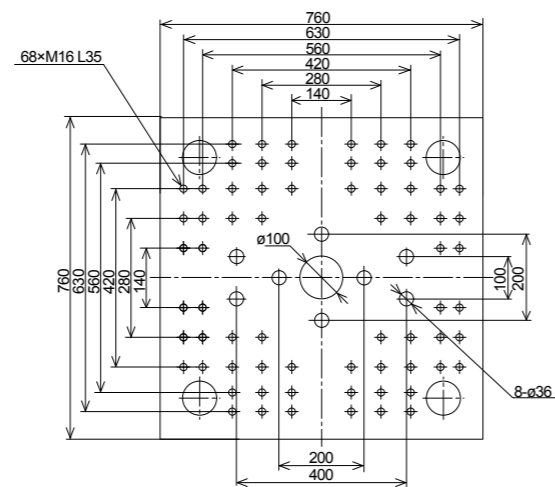
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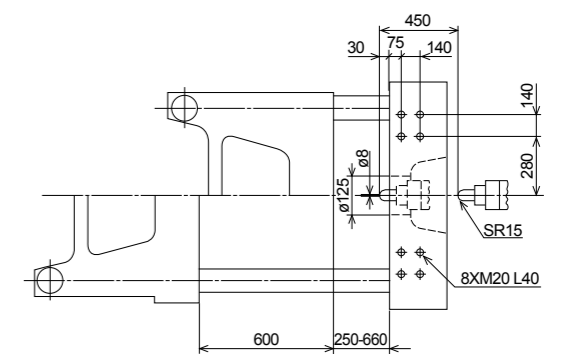
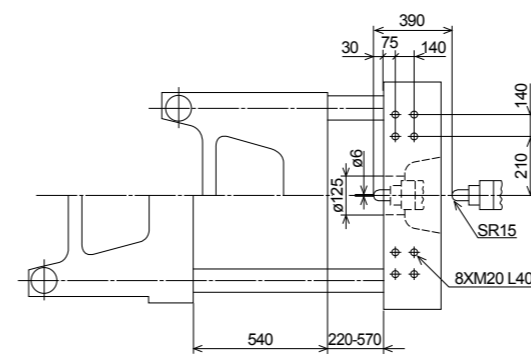
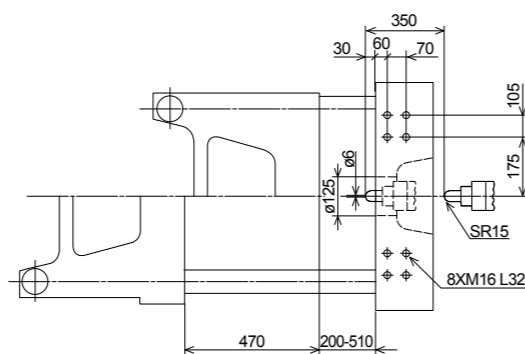
PVC industry application HA/PVC (2000-3000 kN)

	HA2000/770PVC		HA2500/1000PVC		HA3000/1800PVC	
INJECTION UNIT						
Screw diameter	50	55	55	60	65	70
Screw L/D ratio	22.1	22	21.9	22	21.5	22
Injection volume (theoretical)	451	546	601	715	995	1154
Injection weight (PVC)	541	655	721	858	1194	1385
Injection rate (PVC)	193	234	241	287	296	343
Injection pressure	172	142	176	148	181	155
Screw speed	140	120	150	135	120	102
CLAMPING UNIT						
Clamping force	2000		2500		3000	
Mold opening stroke	470		540		600	
Dist. between tie bars (HxV)	510x510		570x570		660x660	
Mold height max.	510		570		660	
Mold height min.	200		220		250	
Ejector stroke	140		150		160	
Ejector tonnage	62		62		62	
OTHERS						
Pump motor power	18.5		22		32	
Heater power	11.3		13.6		17.3	
Machine dimension (LxWxH)	5.6x1.4x2.0		6.3x1.5x2.1		6.8x1.80x2.4	
Machine weight	6.3		7.8		11.3	
Hopper capacity	50		50		50	
Oil tank	235		270		420	

Platen dimensions
Moving platen



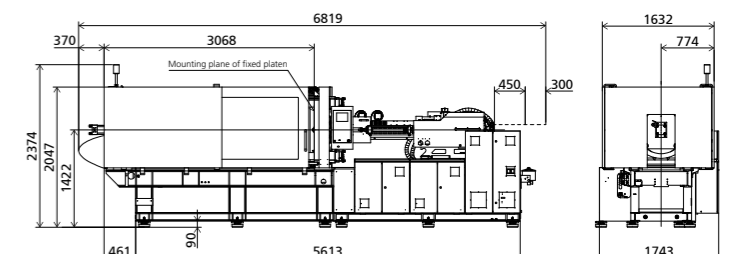
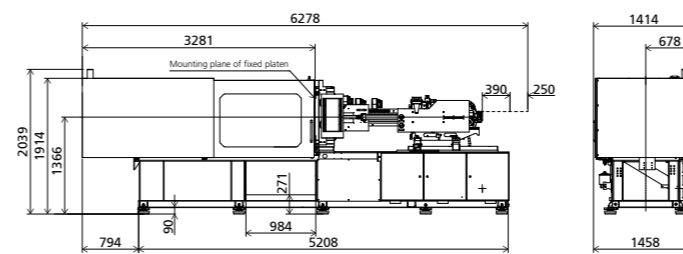
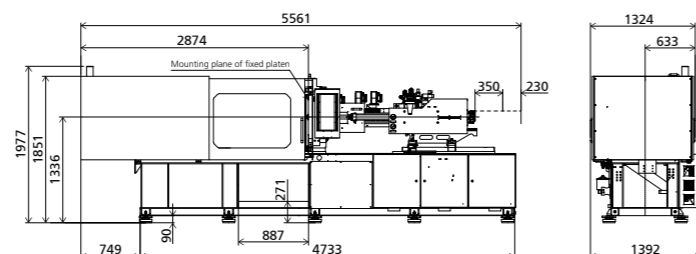
Platen dimensions
Mounting hole for robot/sprue picker top view from fixed platen



Machine dimensions

Note: ① Value in "()" is the size of C screw

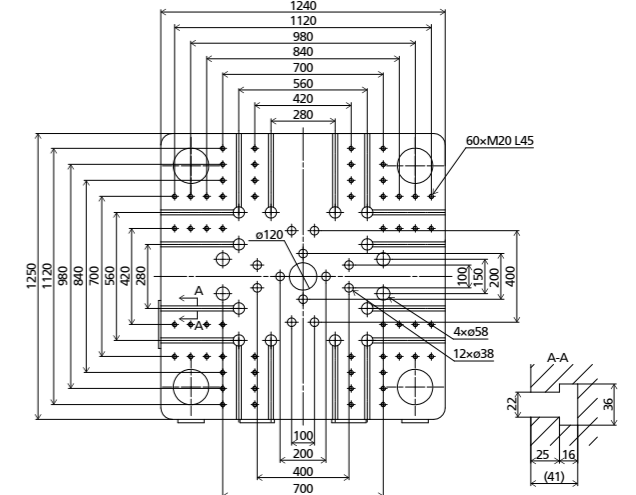
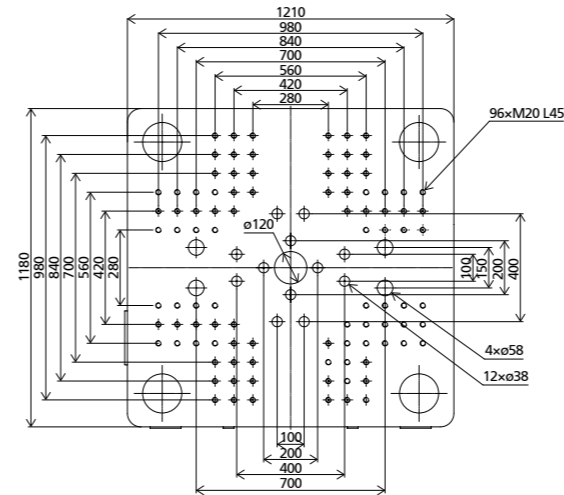
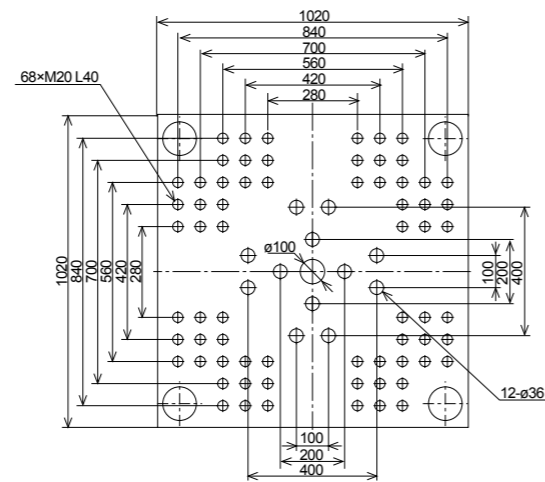
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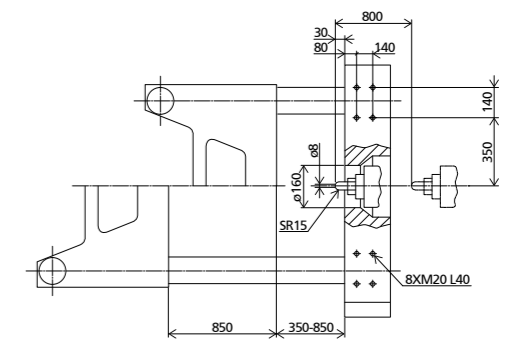
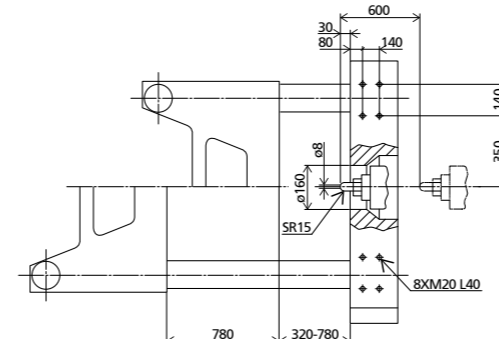
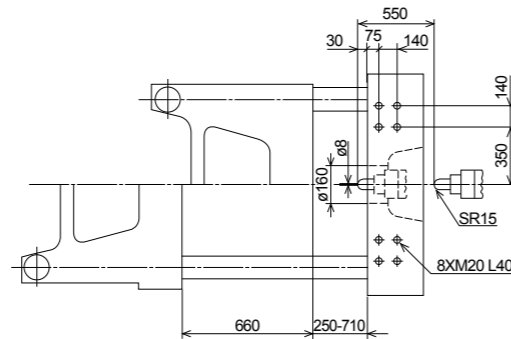
PVC industry application HA/PVC (3600-5300 kN)

	HA3600/2250PVC		HA4700/3200PVC		HA5300/4000PVC		
INJECTION UNIT							
Screw diameter	mm	B 70	C 80	B 80	C 90	B 85	C 90
Screw L/D ratio	L/D	21.6	22	21	22	20	20
Injection volume (theoretical)	cm ³	1239	1618	1859	2353	2496	2799
Injection weight (PVC)	g	1487	1942	2231	2824	2995	3359
Injection rate (PVC)	g/s	383	500	490	620	554	621
Injection pressure	MPa	176	135	173	137	176	157
Screw speed	rpm	130	102	130	82	82	82
CLAMPING UNIT							
Clamping force	kN	3600		4700		5300	
Mold opening stroke	mm	660		780		850	
Dist. between tie bars (HxV)	mm	710x710		820x800		840x830	
Mold height max.	mm	710		780		850	
Mold height min.	mm	250		320		350	
Ejector stroke	mm	160		200		220	
Ejector tonnage	kN	110		110		158	
OTHERS							
Pump motor power	kW	37		45		55	
Heater power	kW	21.3	25.2	27.6	35.1	33	33
Machine dimension (LxWxH)	m	7.5x1.8x2.4		8.5x2.0x2.6		9.0x2.1x2.5	
Machine weight	t	14.7		18.8		23	
Hopper capacity	kg	50		50		100	
Oil tank	l	510		630		780	

Platen dimensions
Moving platen



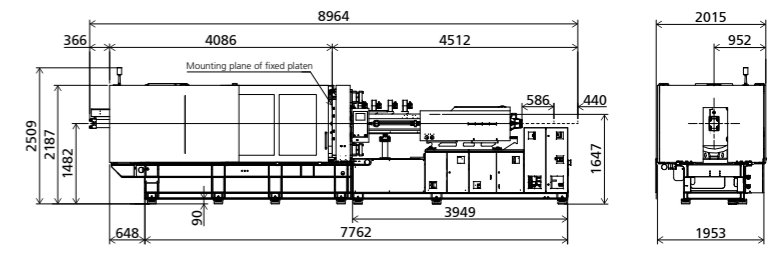
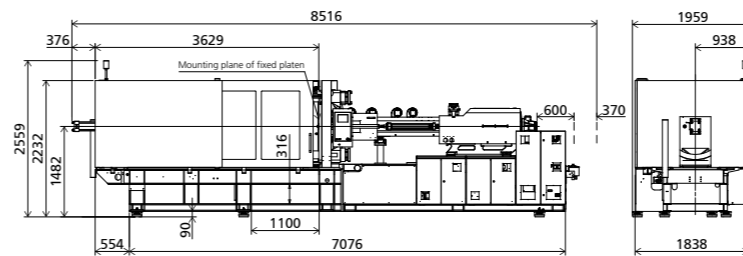
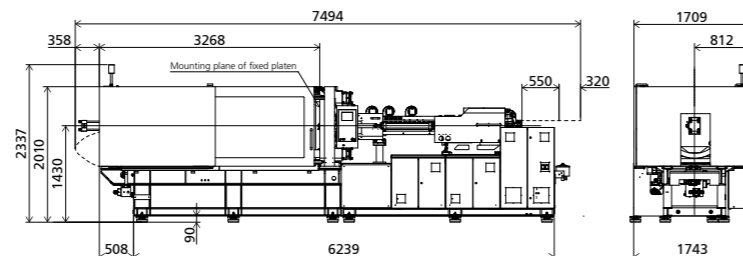
Platen dimensions
Mounting hole for robot/sprue picker top view from fixed platen



Machine dimensions

Note: ① Value in "()" is the size of C screw

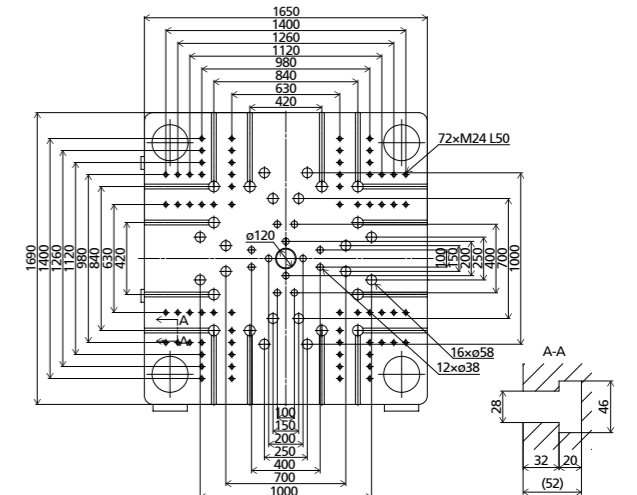
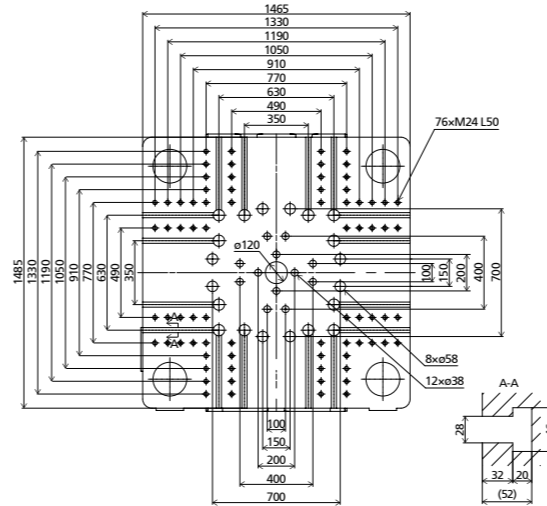
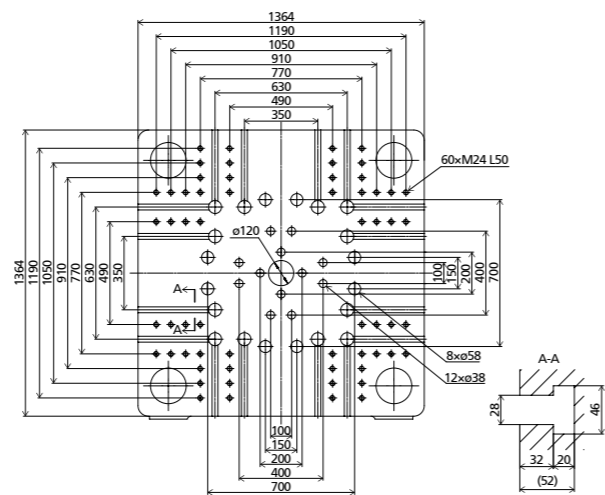
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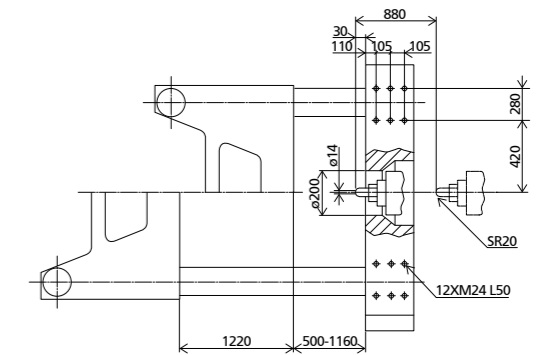
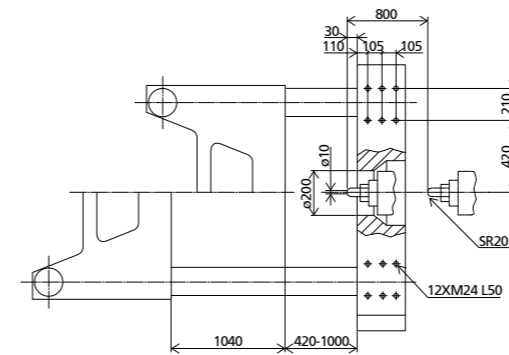
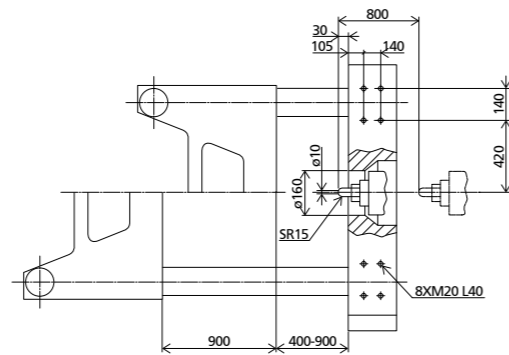
PVC industry application HA/PVC (6500-10000 kN)

	HA6500/4550PVC		HA8000/6350PVC		HA10000/7950PVC	
INJECTION UNIT						
Screw diameter	mm	90	100	100	110	120
Screw L/D ratio	L/D	20	20	20	20	20
Injection volume (theoretical)	cm ³	2799	3455	3455	4181	5428
Injection weight (PVC)	g	3359	4146	4146	5017	6514
Injection rate (PVC)	g/s	667	824	700	847	1067
Injection pressure	MPa	178	144	182	150	179
Screw speed	rpm	100	78	102	71	86
CLAMPING UNIT						
Clamping force	kN	6500		8000		10000
Mold opening stroke	mm	900		1040		1220
Dist. between tie bars (HxV)	mm	920x920		1000x1000		1160x1160
Mold height max.	mm	900		1000		1160
Mold height min.	mm	400		420		500
Ejector stroke	mm	260		280		320
Ejector tonnage	kN	186		186		215
OTHERS						
Pump motor power	kW	65		75		65+37
Heater power	kW	37.6	42.7	48.2	52.8	54.8
Machine dimension (LxWxH)	m	10x2.2x2.7		11x2.3x2.7		11.8x2.5x2.9
Machine weight	t	30.2		36		47.5
Hopper capacity	kg	100		100		100
Oil tank	l	800		1000		1150

Platen dimensions
Moving platen



Platen dimensions
Mounting hole for robot/sprue picker top view from fixed platen



Machine dimensions

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