

宝捷精机 PowerJet

注塑机产品系列

标准机系列

- V系列节能型注塑机
- S系列伺服节能型注塑机
- DP系列两板大型注塑机
- K系列快速注塑机

专用机系列

- PET系列瓶坯专用注塑机
- HPET系列高速瓶坯专用注塑机
- IBM系列注吹专用注塑机
- PVC系列管件专用注塑机
- KF系列高速薄壁专用注塑机
 - KF系列一次性快餐盒生产系统
 - PKF系列模内贴标生产系统
 - CKF系列瓶盖专用生产系统
 - PC材料专用方案
- KE系列医疗器械高速专用注塑机
- T系列电木专用注塑机
- F系列尼龙扎带专用注塑机
- ▶ BJM系列清双色专用注塑机
- SI系列硅胶专用注塑机
- PB系列制桶专用注塑机
- FB系列果框专用注塑机
- PE双壁波纹管承插口注射成型机

Injection Molding Machine Series

Standard Series

- V-series Energy-saving Injection Molding Machine
- S-series Servo Energy-saving Injection Molding Machine
- DP-series Large Two-platen Injection Molding Machine
- K-series High Speed Injection Molding Machine

Special Injection Molding Machine Series

- PET-series Preform Injection Molding Machine
- HPET-series High Speed Preform Injection Molding Machine
- IBM-series Injection & Blow Molding Machine
- PVC-series Special Injection Molding Machine for PVC/PPR Fitting
- KF-series High Speed Injection Molding Machine for Thin-wall Products
 - KF series disposable fast food box production system
 - PKF series in mold labeling production system
 - CKF series special system for the production of bottle cap
 - Special applications for PC
- KE-series High Speed Injection Molding Machine for Medical Instrument
- T-series Bakelite Injection Molding Machine
- F-series Injection Molding Machine for Nylon Ribbon
- ▶ BJM-series Double Color Injection Molding Machine
- SI-series Silicone Injection Molding Machine
- PB-series Paint Bucket Injection Molding Machine
- FB-series Fruit Basket Injection Molding Machine
- PE Special IMM for Double-wall Corrugated Pipe Socket

宝捷集团2015年5月印



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

厂址: 中国·广东省佛山市南海区狮山工业区B区博爱东路12号
ADD: No. 12, BoAi Road East, Zone B, Shishan Industrial Park, Nanhai, Foshan, Guangdong, P. R. China
Service line: 86-400 830 0005 | TEL: 86-757-86697806 | FAX: 86-757-86697861 | E-mail: powerjet@126.com



BJM

—系列Series—

多物料

Multic material
专用注塑机

Injection Molding Machine



www.powerjet.cn
www.powerjetgroup.com

宝捷精机
PowerJet

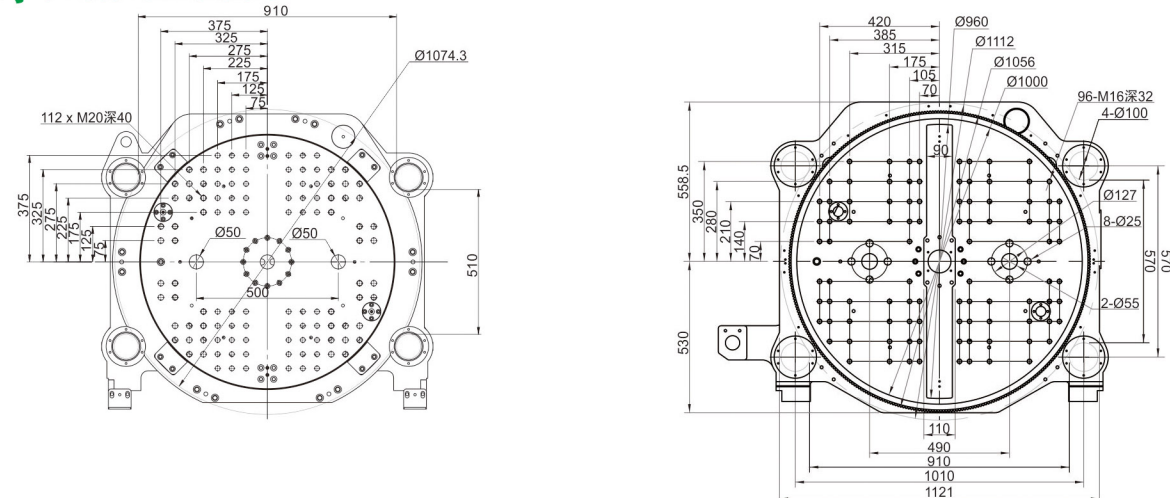


工作原理 / Working principle

注塑机进行第一种塑料注射成型，开模后由转盘把整个动模连同工件转动180°，对准模腔合模后作第二次注射进行共塑成型；第一种塑料注射和第二种塑料注射同步进行。

The injection molding machine injects the first material into the mould and the plastic takes the shape. After the mould is open, the movable rotatory mould platen turns around with the other work pieces by 180° then the machine makes the second injection after the injection nozzles is directed at the cavities of the mould and the mould is closed, and then finally takes shape; Or the first material injection and the second material can be done at the same time to take shape.

模板尺寸 / Platen Dimensions



技术参数 / Parameter

说明	DESCRIPTION	单位	BJM160S6			BJM200S6			BJM250S6			BJM400S6														
国际公认型号	International size rating	UNIT	1600-325			2000-770			2500-770			4000-1230														
锁模单元			CLAMPING UNIT																							
锁模力	Clamping force	KN	1600			2000			2500			4000														
开模行程	Opening stroke	mm	400			490			460			600														
模板最大开距	Max.daylight	mm	850			1060			1090			1250														
模板外形尺寸	Platen size	mm×mm	990×850			1252×990			1252×1150			1300×995														
导柱内距	Space between bars	mm×mm	700×420			910×510			910×570			1020×630														
码模转盘直径	Diameter of rotational mold adapter	mm	Ø730			Ø896			Ø1000			Ø1120														
最大回旋直径	Max. mold height	mm	Ø850			Ø1074			Ø1118			Ø1329														
最大模厚	Max.mold height	mm	450			600			510			650														
最小模厚	Min.mold height	mm	150			150			200			300														
顶针行程	Ejector stroke	mm	110			150			110			140														
顶出力	Ejector force	KN	2×34			2×65			2×34			2×65														
模具定位中心距	Distance between molds positing centers	mm	420			500			490			500														
注射单元			INJECTION UNIT																							
螺杆直径	Screw diameter	mm	26	28	30	26	28	30	30	36	42	36	42	46	30	36	42	36	42	46	46	52	60	30	36	42
螺杆长径比L/D	Screw L/D Ratio		21	20	19.6	21	20	18.3	20	20	17	23.3	20	18.2	20	20	17	23.3	20	18.2	23	19.9	17.5	20	20	17
注射压力	Injection Pressure	Mpa	257	221	155	257	221	193	266	185	136	222	190.5	136	266	185	136	222	190.5	136	230	180	135	266	185	136
理论注射容积	Shot volume	cm³	63	74	96	63	74	85	113	163	222	183	249	298	113	163	222	183	249	298	407	520	693	113	163	222
实际注射量(PS)	Shot weight(ps)	g(克) OZ(盎司)	54	62	91	54	62	75	106	153	208	172	234	281	106	153	208	172	234	281	362	462	617	106	153	208
注射速率(PS)	Injection rate	g/s	54	62	84	54	62	72	54	78	106	69	95	113	54	78	106	69	95	113	119	153	203	54	78	106
螺杆行程	Screw stroke	mm	120			120			160			180			160			180			245			160		
螺杆转速	Screw speed	rpm	206			206			187			164			187			164			170			187		
动力/电热			POWER UNIT																							
油压系统压力	Hydraulic system Pressure	Mpa	17.5			17.5			16			16			17.5			17.5			17.5			17.5		
油泵电机功率	Pump motor power	KW	11+7.5			11+7.5			11+11			11+11			11+11			11+11			22+11			22+11		
加热功率	Heater power	KW	3.5	3.5		3.5	3.5		6	7.5		6	7.5		6	7.5		6	7.5		11.5	6		11.5	6	
其他			GENERAL																							
油箱容量	Oil tank capacity	L	260			260			490			490			410			410			630			630		
理论机重	Machine weight	Ton	6.8			6.8			8			8			9.5			9.5			15			15		
外形尺寸	Machine dimensions(L×W×H)	m×m×m	4.6×1.5×1.7			4.6×1.5×1.7			5.2×1.7×1.9			5.2×1.7×1.9			5.6×1.8×2			5.6×1.8×2			7×2×2.3			7×2×2.3		

节能 | 性能卓越 | 可以长期减低成本 | 操作简单

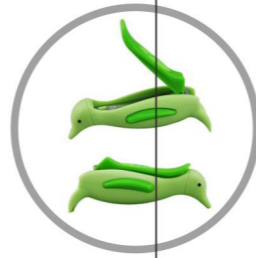
Energy saving, Excellent performance, Reducing production costs, Easy to operate

- 机器有转盘机构，适合颜色分明的双色产品生产；
 - 转盘用机械定位，精准可靠；
 - 外置式的模具分油、分水管路，使用维护方便；
 - 液压伺服系统，节能环保，控制精度高；
 - 可选配转盘、转轴机构，实现多种产品的生产；
 - 顶出控制方式多样；
 - 两射台独立控制，可实现同时注射，减短成型时间。
- Machine is equipped with rotary mold platen, which is suitable for producing the double color product.
 - Rotary table is located by mechanism, which is precise and stable.
 - External mold hydraulic and water cooling system are easy for operation and maintenance.
 - Hydraulic servo system is energy saving and high control precision.
 - Optional rotary table or rotary shaft can produce many kinds of product.
 - Variable ways for ejection control.
 - Two independent controls for the shot platforms, injection simultaneously is achieved to shorten the molding time.

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

BJM-L 双色专用注塑机

Mixed Double color injection molding machine



- 在标准机的基础上，搭配定制化副射台，使用灵活；
- 适用多种双色产品的生产；
- 副射台调整方便，可靠。

- Equipped with customization vice-injection platform based on the standard machine, the operation is flexible.
- Suitable for producing many kinds of mixed double color products.
- Vice injection platform is easy to adjust and stable.



技术参数 / Parameter

说明	DESCRIPTION	单位	BJM126S6-L				BJM160S6-L				BJM200S6-L				BJM250S6-L				BJM288S6-L				BJM330S6-L				BJM400S6-L				BJM500S6-L																	
国际公认型号	International size rating	UNIT	1260-540				1600-760				2000-1090				2500-1090				2880-1640				3300-2200				4000-2890				5000-3900																	
锁模单元																																																
CLAMPING UNIT																																																
锁模力	Clamping force	KN	1200				1600				2000				2500				2880				3300				4000				5000																	
开模行程	Opening stroke	mm	350				440				490				520				550				600				710				830																	
模板最大开距	Max.daylight	mm	750				940				1040				1100				1160				1300				1440				1680																	
模板外形尺寸	Platen size	mm×mm	610×610				705×705				775×755				800×760				850×850				985×985				1050×1050				1260×1260																	
导柱内距	Space between bars	mm×mm	410×410				460×460				510×510				560×490				610×610				670×670				740×720				820×780																	
最大模厚	Max.mold height	mm	400				500				550				580				610				700				730				850																	
最小模厚	Min.mold height	mm	145				160				230				230				280				300				300				300																	
顶针行程	Ejector stroke	mm	100				140				140				145				145				180				210				220																	
顶出力	Ejector force	KN	42				49				65				77				77				77				110				135																	
注射单元																																																
INJECTION UNIT																																																
			主射台		副射台		主射台		副射台		主射台		副射台		主射台		副射台		主射台		副射台		主射台		副射台		主射台		副射台		主射台		副射台															
螺杆直径	Screw diameter	mm	36	40	45	26	28	42	46	52	26	28	46	52	60	26	28	52	60	68	30	42	52	60	68	30	36	42	60	68	75	83	90	36	40	45	75	83	90	100	36	40	45					
螺杆长径比L/D	Screw L/D Ratio		23	20	18.2	21.3	20	22	20.5	18	21.3	20	23	20	17.5	21.3	20	21	21	19	20.7	17.2	21	21	19	20.7	20	17.2	21	20.6	19	20.7	20	17.2	22	20	19	19	23	20	18.2	21	21.8	20	19	23	20	18.2
注射压力	Injection Pressure	Mpa	205	166	131	235	202	213	177	139	235	202	230	180	135	235	202	226	169	132	266	136	226	169	132	266	185	136	217	169	139	266	185	136	208	171	140	119	205	166	131	204	167	142	115	205	166	131
理论注射容积	Shot volume	cm³	193	238	302	63	73	284	340	435	63	73	407	520	693	63	73	594	791	1017	113	222	594	791	1017	113	163	222	876	1126	1370	113	163	222	1198	1458	1786	2099	193	238	302	1722	2110	2481	3063	193	238	302
实际注射量(PS)	Shot weight(ps)	g(克)	172	213	270	54	62	253	302	387	54	62	362	462	617	54	62	529	704	905	101	198	529	704	905	101	145	198	780	1002	1219	101	145	198	1066	1298	1590	1868	172	213	270	1533	1878	2208	2725	172	213	270
		OZ(盎司)	5.7	7.5	9.5	2	2.4	8.9	10.7	13.7	2	2.4	12.8	16.3	21.8	2	2.4	18.7	24.8	31.9	3.7	7.2	18.7	24.8	31.9	3.7	5.4	7.2	27.5	35.4	43	3.7	5.4	7.2	37.6	45.8	56.1	65.9	5.7	7.5	9.5	54	66.3	77.9	96.1	5.7	7.5	9.5
注射速率(PS)	Injection rate	g/s	88	109	137	54	62	105	126	161	54	62	119	153	203	54	62	194	259	333	54	106	194	259	333	54	78	106	253	324	395	54	78	106	298	363	421	495	88	109	137	346	428	480	592	88	109	137
塑化能力(PS)	Plasticizing Capacity	g/s	17	23	32	10	12	19	27	36	10	12	28	38	55	10	12	39	50	64	13	26	39	50	64	13	19	26	57	67	81	13	19	26	58	70	88	88	17	23	32	68	80	88	94	17	23	32
螺杆行程	Screw stroke	mm	190		120		205		120		245		120		280		160		280		160		310		160		330		190		390		190															
螺杆转速	Screw speed	rpm	190		200		210		200		170		200		170		174		170		174		180		174		120		190		120		190															
动力/电热																																																
POWER UNIT																																																
油压系统压力	Hydraulic system pressure	Mpa	17.5		16		17.5		16		17.5		16		17.5		16		17.5		16		17.5		16		17.5		16		17.5		16															
油泵电机功率	Pump motor power	KW	11		7.5		15		7.5		18.5		7.5		22		11		22		11		30		11		37		11		45		11															
加热功率	Heater power	KW	7.8		3.5		9.8		3.5		11.5		3.5		13.8		6		13.8		6		18		6		22		6		28		6															
其他																																																
GENERAL																																																
油箱容量	Oil tank capacity	L	200+120				260				340				420				420				460				630				810																	
理论机重	Machine weight	Ton	4.2				5.5				6.5				8.5				9.5				12				16.5				20																	
外形尺寸	Machine dimensions(L×W×H)	m×m×m	4.3×2.4×1.8				4.8×2.5×1.8				5.3×2.6×2.1				5.8×2.7×2.2				6.3×2.7×2.2				6.8×2.8×2.3				7.2×2.8×2.3				8.7×3.2×2.3																	

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

BJM-C 双色胶花专用注塑机

Injection molding machine for mixed double color plastic flower



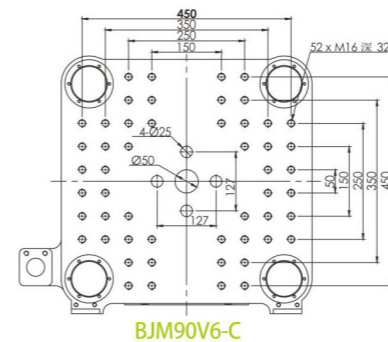
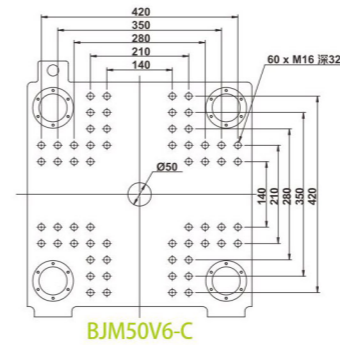
- 单缸注射，射胶响应速度快；
- 差动注射油路，注射速度高；
- 全电脑控制，机器动作精准，操作简便，可实现多种操作方式生产；
- 进口电脑、电气元件，性能稳定；
- 液压系统可选用定量、变量或伺服油泵；
- 冷却水统一收集，循环利用，干净环保。

- Single cylinder injection, shooting response speed is fast.
- Differential injection hydraulic system and fast injection speed.
- Controlled by computer, the machine movement is precise and easy to operation; variable operation is realizable for production.
- Imported computer and electrical element ensure the stable performance.
- Fixed pump, Variable pump, or servo motor can be chosen for the hydraulic system.
- Cooling water will be collected for cyclic utilization, which is clean and environmental protection.

技术参数 / Parameter

说明	DESCRIPTION	单位	BJM50V6-C	BJM90V6-C
国际公认型号	International size rating	UNIT	500-98	900-472
锁模单元 CLAMPING UNIT				
锁模力	Clamping force	KN	500	900
开模行程	Opening stroke	mm	265	320
模板最大开距	Max.daylight	mm	580	680
模板外形尺寸	Platen size	mm×mm	480×480	540×540
导柱内距	Space between bars	mm×mm	315×315	360×360
最大模厚	Max.mold height	mm	310	360
最小模厚	Min.mold height	mm	110	130
顶针行程	Ejector stroke	mm	70	100
顶出力	Ejector force	KN	20	34
注射单元 INJECTION UNIT				
螺杆直径	Screw diameter	mm	22 25	28 32
理论注射容积	Shot volume	cm ³	38 49	99 129
实际注射量 (PS)	Shot weight(ps)	g(克)	20 32	88 115
		OZ(盎司)	0.7 1.1	3.1 4.1
螺杆行程	Screw stroke	mm	166	260
动力/电热 POWER UNIT				
液压系统压力	Hydraulic system Pressure	Mpa	16	16
油泵电机功率	Pump motor power	KW	7.5	11
加热功率	Heater power	KW	3.5	6
其他 GENERAL				
空循环时间	Dry-cycle time	s	1.2	1.5
油箱容量	oil tank capacity	L	120	180
理论机重	Machine weight	Ton	2	2.6
外形尺寸	Machine dimensions(L×W×H)	m×m×m	3.4×1.0×1.6	4×1.2×1.7

模板尺寸 / Platen Dimensions



生产实例 / Production Instance

- 产品名称：双色仿真胶花
- 模腔数：8
- 周期：6秒
- 产品重量：13g
- 材料：PE
- Product: Mixed double color plastic flower
- Cavity: 8
- Product cycle time: 6S
- Product weight/unit: 13g
- Material: PE

