

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

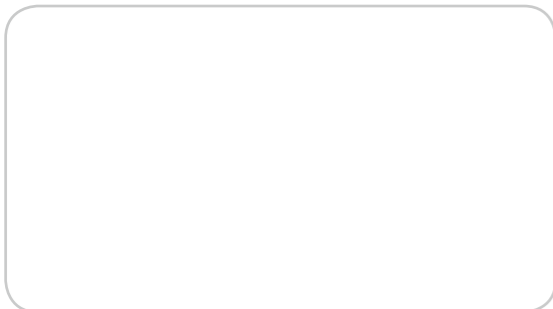
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海天 **天隆<sup>2</sup>** MA/t系列

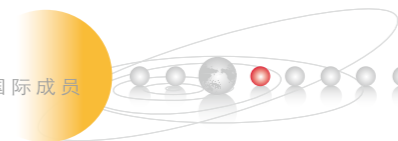
热固性专用机  
技术参数 



海天销售分公司：



HT 20131205-CV



# 海天天隆MA II /t系列

## Special Purpose Heat Curing Machine

Haitian MA / t series is for thermosetting BMC plastic products designed for the second generation of special injection molding machine, in the inheritance of the day-long MA / t series of all the advantages of the Based on the combination of a large number of years of customer application practice, more advanced design concepts, and more reliable hardware configuration, effectively enhance the machine accuracy, but also So that energy efficiency to achieve the best.

BMC is a special unsaturated polyester-based thermosetting hardening resin, molding products with good electrical insulation properties, heat resistance, flame resistance, corrosion resistance High mechanical strength Dimensional stability, small shrinkage, can be used to produce thick-walled products, widely used in the electronics industry, household appliances, transportation industry and other zero Components and so on.

Haitian MA / t series of special injection molding machine, unique design, reliable performance, accurate closed-loop control, suitable for a variety of BMC products molding.

### 主要特性

- The use of bimetallic screw, the smaller aspect ratio, easy to material
- Rapid replacement, reducing the plastic in the barrel of the residence time;
- Compression ratio, to prevent friction overheating, reducing the chance of curing.
- »Special groove and anti-reverse ring design, keep the glass fiber
- Integrity, accurate measurement, the stability of the pressure of plasticizing system force.
- »Special barrel design, operation screen real-time monitoring barrel temperature
- Degree, the barrel temperature control uses the spacer type inner circulation pattern,
- Reserved water or other media control interface, user-friendly control
- System and replacement.
- »Fixed and mobile templates reserved for 220V mold heating with automatic temperature control
- Interface, signal directly connected with the injection molding machine computer, and intuitive
- To display in the computer screen.
- »Template set imported high strength insulation board and auxiliary template,
- Effectively prevent the mold heat dissipation, maintain the mold temperature,
- Precise control of mold temperature, reduce energy loss.
- »Template set imported high-strength insulation board, effectively prevent the mold
- With heat dissipation, maintain mold temperature, precise control of mold
- Temperature, reduce the energy loss;

MA 2000 II / 770t



MA 3200 II / 2250t



# 海天天隆MA II /t系列

## Special Purpose Heat Curing Machine

### BMC Special Configuration of the Feeding System

Convenient feeding device, can be added in bulk raw materials,

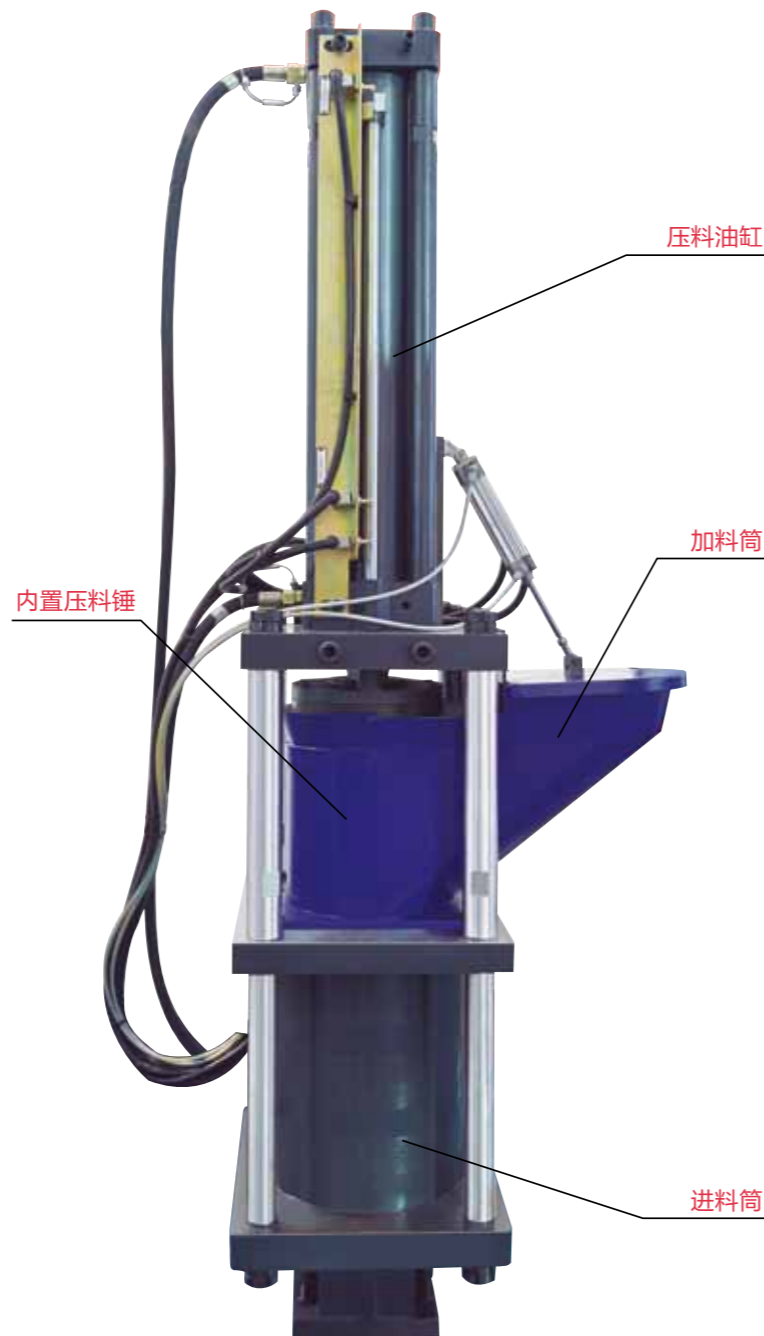
To achieve continuous machine production cycle, improve production efficiency rate.

»Forced feeding system, through the control of pressure, flow, Smoothly and evenly squeeze the BMC material into rotation Screw storage materials, metering accurate and stable.

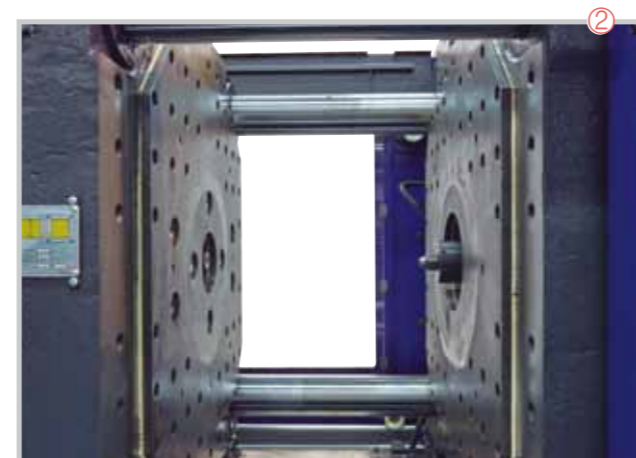
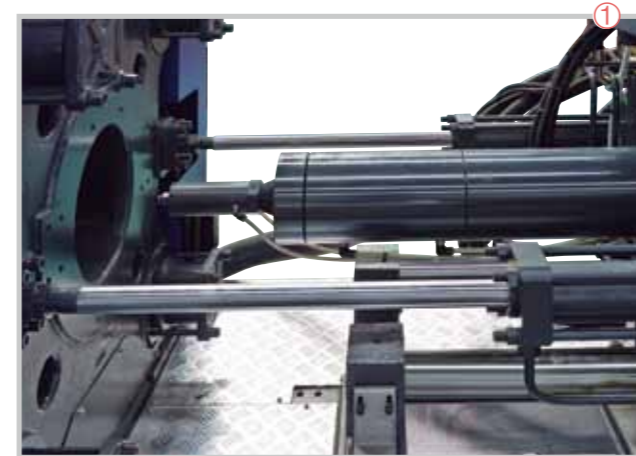
»Specially designed built-in pressure hammer for easy extrusion Material, so that feed tube residual material to a minimum, large Greatly reduce the waste of raw materials to facilitate the clean-up of residual material.

»Material level monitoring system, lack of material alarm, no material machine For automatic stop.

»Independent control of the oil system, through the control surface The plate sets the action of the feeding system.



Haitian MA / t series BMC injection molding machine dedicated feeding system: Proven, Accurate, environmentally friendly, safe, simple and easy to operate.



Picture ① Special barrel design, the use of bimetal screw, the smaller aspect ratio, easy to object Rapid replacement of materials to reduce the plastic in the barrel of the residence time; zero compression ratio, to prevent Friction overheating, reducing the chance of curing.

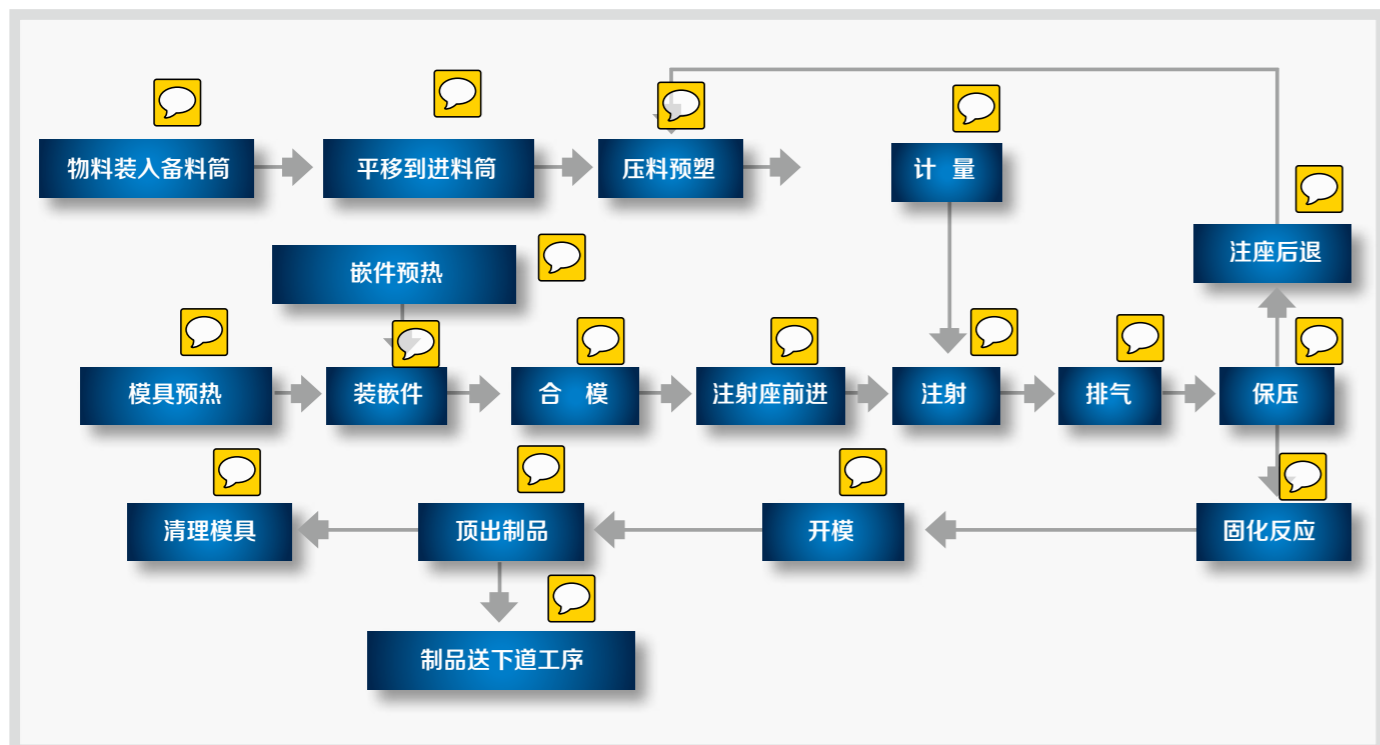
Picture ② Template set the import of high-strength insulation boards and auxiliary templates, effectively prevent the mold heat The amount of distribution, maintaining mold temperature, precise control of mold temperature, reducing the energy loss Consumption.

Picture ③ Fixed and mobile templates reserved 220V mold heating temperature control interface, signal straight Connected with the injection molding machine computer, and intuitively displayed in the computer screen.

# 海天天隆MA II /t系列

Haitian-day-long MA / t series  
Special-purpose heat-curing machine

Thermosetting (BMC) plastic injection molding machine process



## BMC产品工艺的特点

- » 成型周期短，无需预先制作坯料，避免预处理时原料暴露于空气中而性能下降甚至报废的可能性，并有效节省生产工时。
- » 产品适应性强，适合生产各种结构复杂，产品质量要求高的BMC产品。
- » 自动化程度高，生产过程简化（取消了预压、预热工序），原料自动输送，成品和料柄自动顶出，制品修整简单，减少劳动强度，节约劳动力成本。
- » 生产效率高，适合生产一出多腔制品，且成型周期短，高度自动化，效率明显提高。
- » 生产成本低，海天BMC专用注塑机生产效率高，废品率低，废料少，批量生产成本大大降低。
- » 产品品质优异，MA II /t机器配置油路闭环系统，使整机性能更出色，产品重量更加稳定，密度更加均匀，重复性更好，适合长期大批量生产。

Haitian-day-long MA / t series  
Special-purpose heat-curing machine

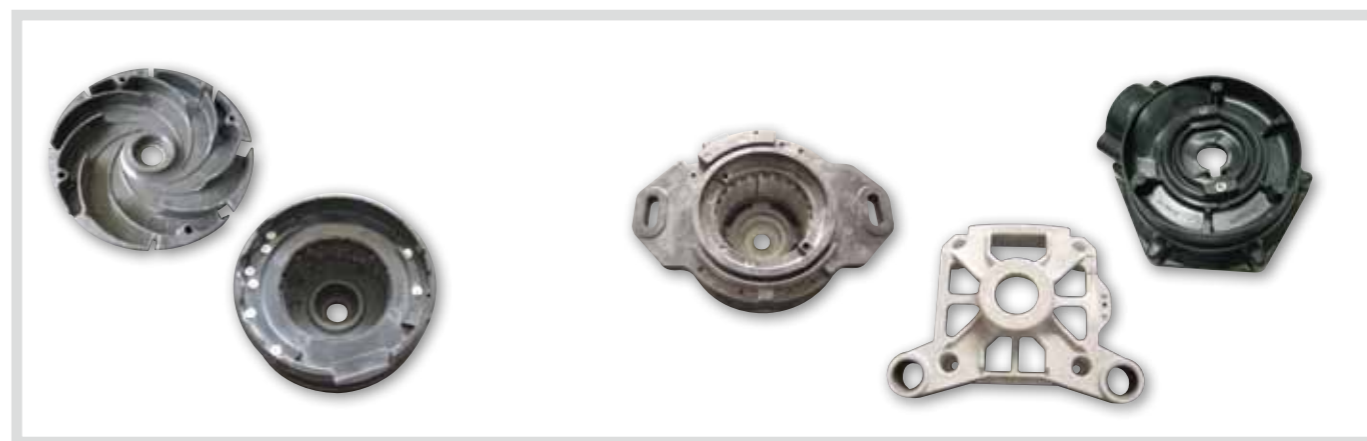
Haitian-day-long MA / t series  
Special-purpose heat-curing machine

Haitian-day-long MA / t series  
Special-purpose heat-curing machine

BMC产品应用领域概况  
低压电器和电子元器件



端盖支撑件和绝缘塑封件



车灯反射体及其它



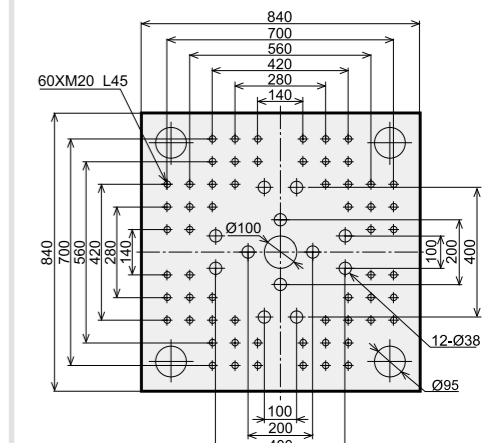
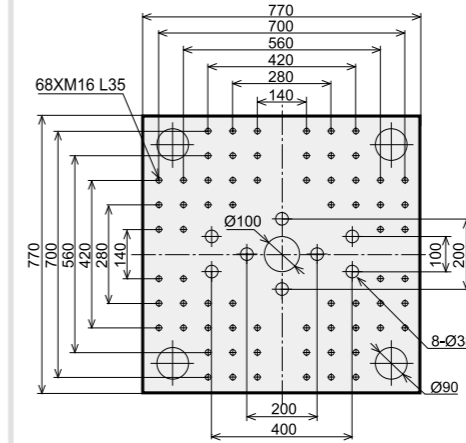
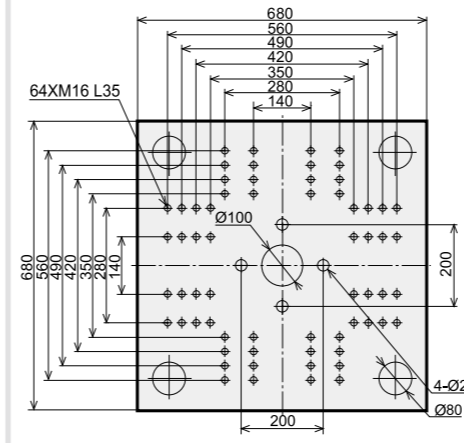
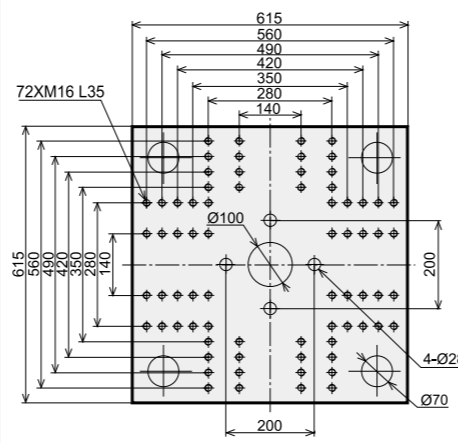
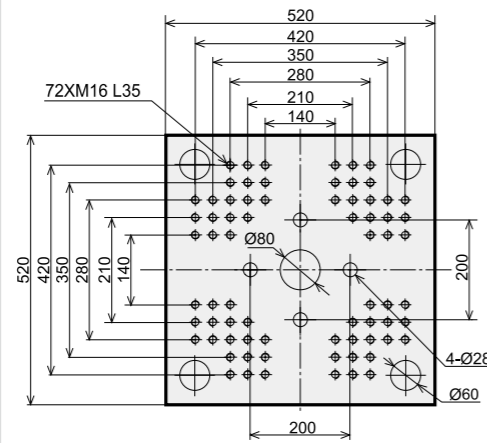
# 技术参数

<b>注射装置</b>	<b>INJECTION UNIT</b>	
螺杆直径	Screw Diameter	mm
螺杆长径比	Screw L/D Ratio	L/D
注射容量 (理论)	Shot Size (Theoretical)	cm <sup>3</sup>
注射重量 (BMC)	Injection Weight (BMC)	g
注射速率	Injection Rate	g/s
注射压力	Injection Pressure	Mpa
螺杆转速	Screw Speed	r/min
<b>合模单元</b>	<b>CLAMPING UNIT</b>	
锁模力	Clamp Tonnage	KN
移模行程	Toggle Stroke	mm
拉杆内间距	Space Between Tie Bars	mm
最大模厚	Max. Mold Height	mm
最小模厚	Min. Mold Height	mm
顶出行程	Ejector Stroke	mm
顶出力	Ejector Tonnage	KN
<b>其他</b>	<b>OTHERS</b>	
最大油泵压力	Max. Pump Pressure	Mpa
油泵马达	Pump Motor Power	Kw
模具电热功率 (模温 X 段数 X 功率)	Mold Heater Power	Kw
外型尺寸	Machine Dimension(L×W×H)	m
机器重量	Machine Weight	t
进料筒容积	Hopper Capacity	Kg
油箱容积	Oil Tank Capacity	L

	MA900 II /300t	MA1200 II /410t	MA1600 II /600t	MA2000 II /770t	MA2500 II /1350t
B	36	40	45	50	55
L/D	12	12	12	12	12
Shot Size (Theoretical)	153	214	320	412	618
Injection Weight (BMC)	275	385	576	742	1112
Injection Rate	250	350	357	509	502
Injection Pressure	197	192	188	187	219
Screw Speed	170	170	140	180	160
Clamp Tonnage	900	1200	1600	2000	2500
Toggle Stroke	320	360	430	490	540
Space Between Tie Bars	360X360	410X410	470X470	530X530	580X580
Max. Mold Height	350	420	490	520	550
Min. Mold Height	120	120	150	170	190
Ejector Stroke	100	120	140	140	150
Ejector Tonnage	33	33	33	62	62
Max. Pump Pressure	16	16	16	16	16
Pump Motor Power	7.5+7.5	11+11	11+11	18.5+11	22+13
Mold Heater Power	2X2X3.5	2X2X3.5	2X2X3.5	2X2X3.5	2X3X3.5
Machine Dimension(L×W×H)	4.4X1.13X2.94	4.88X1.20X3.1	5.4X1.30X3.22	5.9X1.5X3.5	6.42X1.55X3.8
Machine Weight	4	4.9	6.15	8.1	9.5
Hopper Capacity	15	15	15	30	30
Oil Tank Capacity	160	185	230	290	330

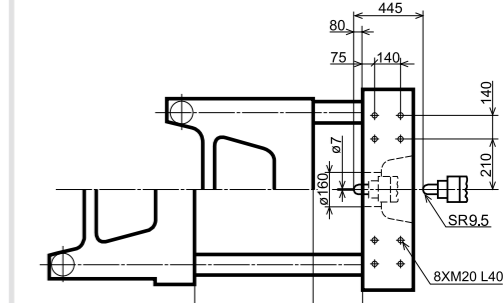
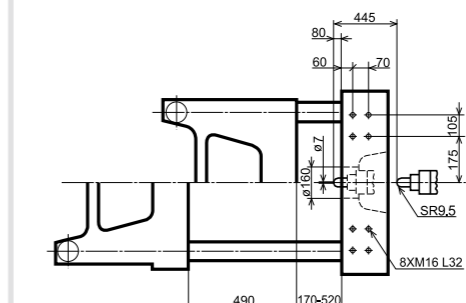
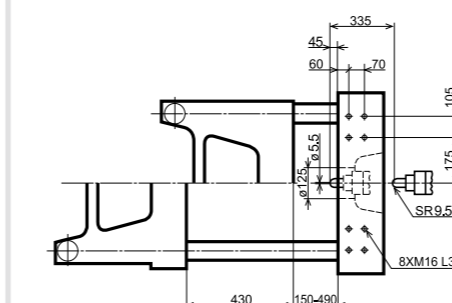
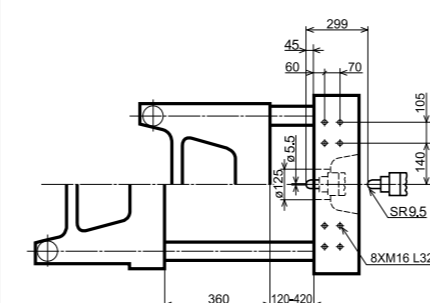
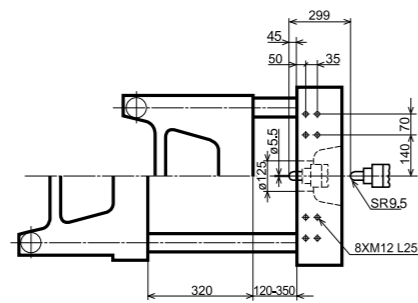
## 模板正面尺寸 Platen dimensions

Moving platen



## 模板侧面尺寸 Platen dimensions

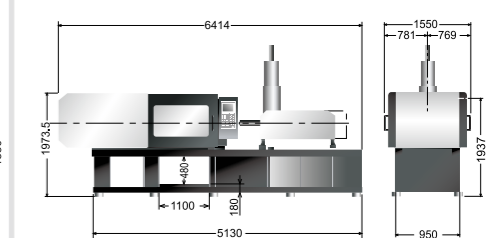
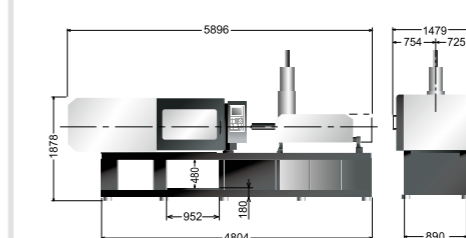
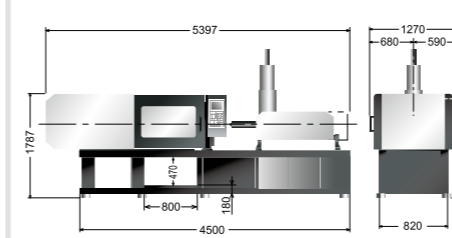
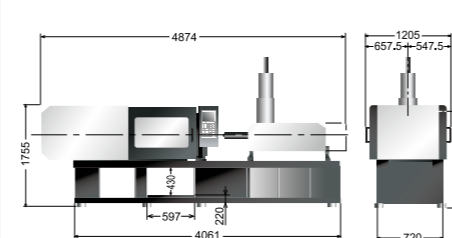
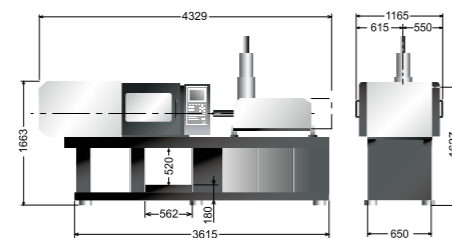
Mounting hole for robot/sprue picker top view from fixed platen



## 外型尺寸 Machine dimensions

本公司保留修改技术参数的权力, 恕不另行通知。

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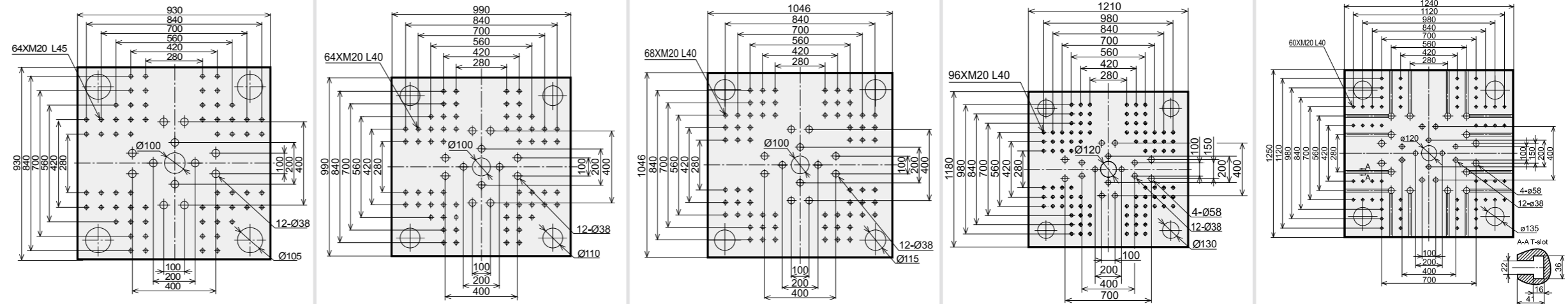
# 技术参数

注射装置		INJECTION UNIT	
螺杆直径	Screw Diameter	mm	
螺杆直径比	Screw L/D Ratio	L/D	
注射容量 (理论)	Shot Size (Theoretical)	cm <sup>3</sup>	
注射重量 (BMC)	Injection Weight (BMC)	g	
注射速率	Injection Rate	g/s	
注射压力	Injection Pressure	Mpa	
螺杆转速	Screw Speed	r/min	
合模单元		CLAMPING UNIT	
锁模力	Clamp Tonnage	KN	
移模行程	Toggle Stroke	mm	
拉杆内间距	Space Between Tie Bars	mm	
最大模厚	Max. Mold Height	mm	
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顶出行程	Ejector Stroke	mm	
顶出力	Ejector Tonnage	KN	
其他		OTHERS	
最大油泵压力	Max. Pump Pressure	Mpa	
油泵马达	Pump Motor Power	Kw	
模具电热功率 (模温 X 段数 X 功率)	Mold Heater Power	Kw	
外型尺寸	Machine Dimension(L x W x H)	m	
机器重量	Machine Weight	t	
进料筒容积	Hopper Capacity	Kg	
油箱容积	Oil Tank Capacity	L	

MA2800 II /1700t	MA3200 II /2250t	MA3800 II /2250t	MA4700 II /3300t	MA5300 II /4500t
B	B	A	A	A
60	65	65	70	80
12	13	13	13	13
727	1068	1068	1239	2212
1309	1922	1922	2230	2497
630	673	769	835	959
213	208	208	229	202
190	160	190	140	120
2800	3200	3800	4700	5300
590	640	700	780	850
630X630	680X680	730X730	820X800	840X830
600	650	700	750	820
200	220	250	290	320
150	160	180	200	220
62	62	110	158	158
16	16	16	16	16
30+11	30+13	37+13	37+22	45+22
2X3X3.5	2X3X3.5	2X3X3.5	2X4X3.5	2X4X3.5
6.6X1.8X3.81	7.05X1.9X3.83	7.46X1.9X4.2	7.87X2.12X4.3	9.27X2.15X4.3
12	14.3	16.5	20.5	27.5
30	30	50	50	50
580	690	690	900	1040

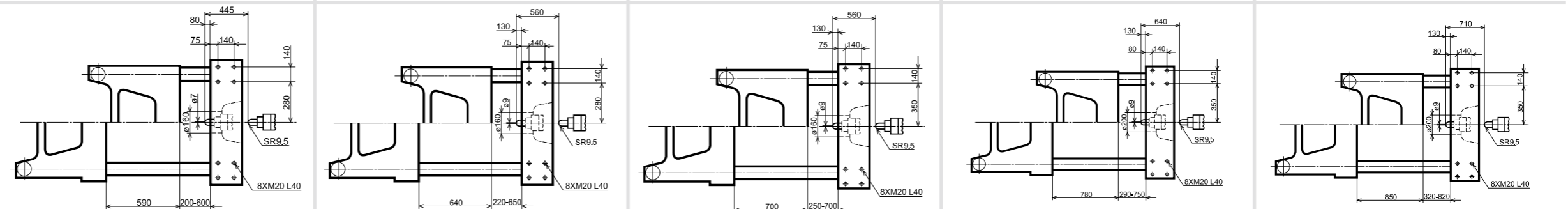
## 模板正面尺寸 Platen dimensions

Moving platen



## 模板侧面尺寸 Platen dimensions

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



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