

JY820-650正负压多工位三工位高速热成型机可降解餐盒机

产品名称	JY820-650正负压多工位三工位高速热成型机可降解餐盒机
公司名称	汕头市聚能科技有限公司
价格	1180000.00/台
规格参数	品牌:YJX-JN 型号:JY820-650 产地:广东汕头
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产品详情

JY820-650大版面全自动正负压三工位高速塑料热成型机可降解餐盒机

JY820-650 Three Station High Speed Thermoforming Machine

热成型 冲剪 堆叠

一、技术参数 Technical Parameters :

序号 描述 Descriptions 参数 Parameters

1. 适应物料Suitable material : APET, PP, PS, BOPS, PVC, PLA
2. 适用片材宽度Sheet width : 500 ~ 860 mm
3. 适用片材厚度Sheet thickness : 0.2 ~ 2.0 mm
4. 片材卷径Max sheet roller diameter 800 mm
5. 成型面积Max forming area 820 × 650 mm

6. 裁切面积Max cutting area 820 × 650 mm
7. 成型模具宽度Forming mould width : 500 ~ 820 mm
8. 成型深度/高度Max forming depth/high 140 mm
9. 成型模具开合行程 Forming mould stroke : Up上模170mm , Down下模170mm
10. 裁切模具开合行程 Cutting mould stroke : Up上模170mm , Down下模170mm
11. 工作效率Max production speed 35模次/分钟 35 Cycle/Min
12. 使用电源(三相四线制) Power supply : 380V/50Hz (Three phase four wire)
13. 电热炉加热功率 Max heating power 170 Kw
14. 整机功率 Max total power 200 Kw
15. 运行平均功率 Average running power 80 Kw
16. 制品定型冷却方式 Product cooling method : 水冷 Water cooling
17. 真空泵 Vacuum pump : UniverstarXD100
18. 外配气源供气量 Air consumption 6 m³/ min
19. 外配气源气压 Air pressure : 0.8 MPa
20. 整机外形尺寸长宽高 Dimension(L × W × H) : 1304 × 240 × 350 cm
21. 整机重量 (吨) Machine total weight 14 Ton

二、机组概述 Machine Descriptions:

1. JY正负压高速多工位热成型机，是我司引进德国技术新研发的针对于包装工业、食品工业、电子工业的新一代革命性产品。此系列应用广泛，通用性好，此机型只是其中一款，针对客户要求，完全能为所有产品要求提供满足的设备；

JY Series of Pressure & Vacuum Multistation High Speed Plastic Thermoforming Machines are the new generation revolutionary products which were introduced from Germany latest technology, aiming at packing industry, food industry and electronic industry. This model machine is only among them. According to clients' requirements, we can design and provide machines to meet them.

2. JY系列高速成型机由：上料放卷机、加热总成、成型工位、冲剪工位、堆叠工位、制品送出、废片收卷、电气控制系统及机架等组成，高速运行、噪音小、能耗低，其可靠性、操作维护方面相当不错；

The three stations thermoforming machine is assembled of several units:

Sheet feeding unreeling device Sheet heating unit Product thermoforming station Product punching & cutting

station Product stacking station Product transferring unit Waste sheet collecting rewinding unit Electrical control system unit Machine framework. It runs on high speed, low noise, low energy consumption. Its high reliability, easy operation and maintenance are highly appreciated by customers.

3. 生产速度可达到35模次/分钟的成型机，称得上高速成型机，全部采用伺服控制系统，加上先进的自动化系统，对加工淀粉降解片材、光降解片材、环保片材、PP、PS、BOPS、PE、PVC、APET 还是 CPET，JY高速成型机都无可挑剔；

Its Max production speed is 35 Cycle/Min, absolute a high speed machine. It is equipped with servo control system and advanced automatic system. The suitable sheet materials can be PLA、PP、PS、BOPS、PE、PVC、APET、CPET;

4. 具备新型设计的模具更换机构，保证了极短的模具更换时间，按照人体效学优化设计的简易模具更换系统，以及激光钢刀冲切和堆叠装置，从而保证了生产时间；

With the new mould replacement structure, the mould can be easily replaced in a short time. The mould replacement structure, laser steel cut punching and stacking device are designed on the basis of human engineering (Ergonomics), so save labor and time.

5. 先进的加热系统，采用全新的控温模块，响应快、时间短，取得了高效益、低成本。

This advanced heating system adopts new temperature control module, it is quick response, efficient and low cost.

三、功能特点 Function Features:

1. 机械、气动、电气一体化，各动作程序由PLC控制，触摸屏操作，简单方便；

Mechanical, pneumatic, electrical integration. Each action program is controlled by PLC. Color touch screen operation is simple and convenient;

2. 正负压热成型 Pressure & Vacuum thermoforming

3. 上下模成型方式 Up & Down mould forming style

4. 伺服送片，长度无级调整，高速准确稳定；

Sheet servo feeding, length stepless adjusting, high speed, accuracy, stability;

5. 上、下电热炉四段加热 Up & Down electric heaters with four zones heating

6. 电热炉控温系统采用全电脑智能自动补偿控制，分区一控一采用人机界面数字输入，具有微调精度高，温度均匀，升温快（从0~400度只需3分钟），稳定（不受外部电压影响，温度波动不超过1度），能耗低（节能15%左右），炉板使用寿命长等优点；

Electric heating furnace temperature control system adopts full computer intelligent automatic compensation control, partition control uses digital input human-computer interface one by one. There are the advantages of high precision fine tuning, uniform temperature, fast temperature rise (only 3 minutes from 0 ~ 400) and stability (not affected by external voltage, temperature fluctuation is no more than 1), low energy consumption (energy saving about 15%), heating furnace long service life;

7. 成型、裁切单元开模、合模伺服电机控制，制品自动计数输出；

The opening moulds and closing moulds in the stations of forming and cutting are controlled by servo motors, the plastic product is output in automatic counting;

8. 制品向下堆叠方式 Down stacking style for plastic product

9. 具有产品资料及参数档案记忆功能45组

With memory function for product information & data 45 sets

10. 送片链轨宽度可同步自动或分立电动调整

Sheet feeding caterpillar width can be automatic synchronization or separate electric adjusting

11. 电热炉自动移出装置 The heating furnace can be removed out automatically

12. 机械上料卷装置，减轻工人劳动强度。

The mechanical sheet feeding unreeling device can save labor intensity.

四、主要电气元器件品牌 Main Pneumatic Component Brand:

可编程逻辑控制器 (PLC)：台达 DELTA

15英寸彩色触摸屏 15" Color touch screen：成型上/下模伺服电机

(7.5Kw/7.5Kw) Forming servo motor：7.5Kw/7.5Kw

上成型拉伸伺服电机(4.5Kw) Sending servo motor：台达 DELTA 4.5Kw

裁切上/下模伺服电机(11Kw/7.5Kw) Cutting servo：台达 DELTA 11Kw/7.5Kw

成品堆叠伺服电机(1.5Kw) Stacking servo motor：台达 DELTA 1.5Kw

废片送出伺服电机(5.5Kw) Sending servo motor：台达 DELTA 5.5Kw

陶瓷加热板 (280块) Ceramic panel heater：TRIMBLE

交流接触器 AC contactor：法国施耐德 France Schneider

热继电器 Thermal relay：法国施耐德 France Schneider

中间继电器 Intermediate relay：日本欧姆龙 Japan OMRON

空气开关 Air switch：韩国 Korea LS

电子压力传感器 Electron pressure sensor：韩国 Korea LS

气动元件 Pneumatic component：亚德客 AirTAC，日本 SMC

气缸 Cylinder : 志诚 ZHICHENG