



www.tongdamachine.net 🔍

欲了解更多公司详情，请登录官网或扫二维码查询。



苏州同大机械有限公司
SUZHOU TONGDA MACHINERY CO., LTD.

地址：江苏省苏州市张家港市凤凰大道21号
电话：0512-56370112 0512-56370113
传真：86-512-58920956
邮箱：info@tongdamachine.com
邮编：215614

Add: No. 21 Fenghuang Avenue, Zhangjiagang City, Suzhou City, Jiangsu Province, China
Tel: 0512-56370112 0512-56370113
Fax: 86-512-58920956
Email: info@tongdamachine.com

本产品手册仅供参考之用，一切以实物及产品说明为准，同大产品均有各项国家专利，盗版必究。

TONGDA MACHINE

ISO9001 CE

中空吹塑设备解决方案 同大一站式智造

TONGDA — PROVIDES ONE-STOP INTELLIGENT
MANUFACTURING SOLUTION FOR PLASTIC EXTRUSION BLOW MOULDING MACHINE



TONGDA
同大机械

20⁺
年专注
ABSORBED

GROWING WITH PARTNERS

同心合力 一起壮大

我们始终坚持以客户为中心，秉持真诚，时刻关注客户的需求
以强大的技术力量团队，根据不同客户的具体要求提供切实可行的技术方案
成就客户，为客户持续创造价值

We always adhere to customer-centric, sincerity and attend to customer needs at all times
With a strong technical team, provide practical technical solutions according
to the specific requirements of different customers
Dedication to every client's success, create value continuously for customers



www.tongdamachine.net



CONTENTS

目录



01 公司篇 COMPANY CHAPTER

关于同大
About Us 01

同大发展
Development History 03

同大文化
Culture 05

同大荣誉
Honorary Qualification 07

同大加工
Equipment 09

应用领域
Application Field 11

02 产品篇 PRODUCTS CHAPTER

0-3L 13

3-5L 15

5-10L 21

10-12L 23

12-25L 27

25-30L 29

30-50L 33

50-120L 35

120-160L 37

160-250L 39

250-350L 41

350-1500L 43

TDB-25APC 45

模板图
Formwork Drawing 47

辅机
Auxiliary Machine 53

模具
Mould 56

03 发展篇 DEVELOPMENT CHAPTER

主要客户(部分)
Major Customers 57

全球销售服务中心
Global Sales 59

销售服务
Service Centersales Service 61

未来展望
Future Outlook 63



ABOUT TONGDA

关于同大

苏州同大机械有限公司，始创于1999年，是一家以塑料中空成型设备为核心的整厂智能制造解决方案提供商。公司连续十二年被评为塑料机械挤出吹塑中空成型装备行业前三强，是中国塑料机械工业协会副会长单位、国家级专精特新“小巨人”企业。

公司现有四个生产基地，总占地面积10万平方米，年生产能力超1200台套。公司产品在技术创新、研发智造等方面具有明显的优势，截至2022年，公司主持起草2项国家标准和1项行业标准，参与3项国家标准制定。

24年来，同大机械为日用化工包装、医药瓶包装、饮料瓶包装、润滑油包装行业、汽车吹塑件、五金工具包装箱，化工用塑料桶、太阳能光伏浮体、物流运输九脚托盘及各类民用、农用、游乐设施等各类型吹塑生产厂家提供了8000多台(套)各种规格的挤吹中空成型设备，客户遍布全球90多个国家和地区，并在国内外已建设完善的销售服务网络。

同大机械将秉承“同心合力、一起壮大”的企业司训，持续为全球客户提供定制化产品与服务，共同创造价值。



Suzhou Tongda Machinery Co., Ltd. was founded in 1999, is a plastic hollow molding equipment as the core of the whole plant intelligent manufacturing solutions provider. The company has been rated as the top three plastic machinery extrusion blow molding equipment industry for 12 consecutive years, and is the vice president unit of China Plastic Machinery Industry Association and the national specialized special new "little giant" enterprise.

The company has four production bases, with a total area of 100,000 square meters and an annual production capacity of more than 1,200 sets. The company's products have obvious advantages in technological innovation, R & D and intelligent manufacturing, etc. By 2022, the company has presided over the drafting of two national standards and one industry standard, and participated in the formulation of three national standards.

In the past 24 years, Tongda Machinery for daily chemical packaging, pharmaceutical bottle packaging, beverage bottle packaging, lubricating oil packaging industry, automotive blow molding parts, hardware tools packing boxes, Chemical plastic drums, solar photovoltaic floating body, logistics transport nine-legged pallets and all kinds of civil, agricultural, amusement facilities and other types of blow molding manufacturers to provide more than 8000 sets (sets) of various specifications of extrusion blowing hollow molding equipment, customers all over the world more than 90 countries and regions, and has built a perfect sales service network at home and abroad.

With great machinery will adhere to the "work together, grow together" enterprise training, continue to provide customized products and services for global customers, and jointly create value.

DEVELOPMENT HISTORY

同大发展

百年同大
CENTENINAL TONGDA
环抱全球
EMBRACE THE WHOLE WORLD



CULTURE

同大文化



司训

MOTTO

同心合力、一起壮大
Growing With partners.



使命

MISSION

以科技创新为驱动力、为客户创造价值、为员工创造机会、为社会创造财富
Driven by technological innovation, creating value for customers, creating opportunities for employees, and creating wealth for society



企业愿景

COMPANY VISION

创建常青基业，成就挤出中空领域的领航者
Create an Evergreen Foundation and become a leader in the field of extrusion.



价值观

SENSE OF WORTH

成就客户、诚信正直、求真创新、持续进步
Achieve customers, integrity, truth-seeking, innovation and continuous progress.



HONORARY QUALIFICATION

同大荣誉

荣誉源于用心。

每一份认可的资质证书都是凝聚同大奋力拼搏的结晶，每一份荣誉都是一个路标，一次历程。我们也将以每次荣誉为起点，不断锐意进取，超越自我。

Honor comes from heart.

Each recognized qualification certificate is the crystallization of Tongda's hard work, and each honor is a road sign and a process. We will also take each honor as the starting point, constantly forge ahead and surpass ourselves.





EQUIPMENT

同大加工

BUILD AN EXPLORER IN MECHANICAL EQUIPMENT INDUSTRY



Since its establishment for over 20 years, Tongda Machinery has always adhered to the principle of "quality is the foundation of the enterprise", focusing on the field of plastic hollow forming technology, creating value for customers together, strictly controlling every step of the processing process, and striving to respond to fierce market competition with first-class quality products.

Tongda ensures product quality with its precision machine manufacturing process, innovative technology, and strict quality control process.

同大机械创立20多年来, 始终坚持“质量是企业立足之本”, 专注于塑料中空成型技术领域, 为客户共同创造价值, 严把加工过程的每一道关口, 力求以一流质量的产品应对激烈的市场竞争。

同大凭借精密的机器制造工艺、创新技术、严格的质量管控流程, 确保产品质量。



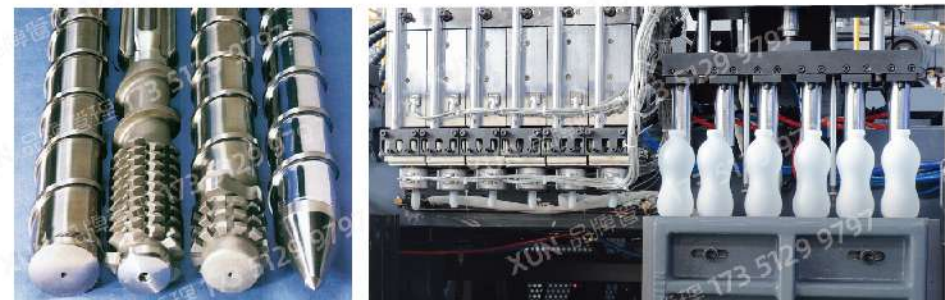
智能化
Intelligent



数字化
Digitalize



低碳化
low-carbon





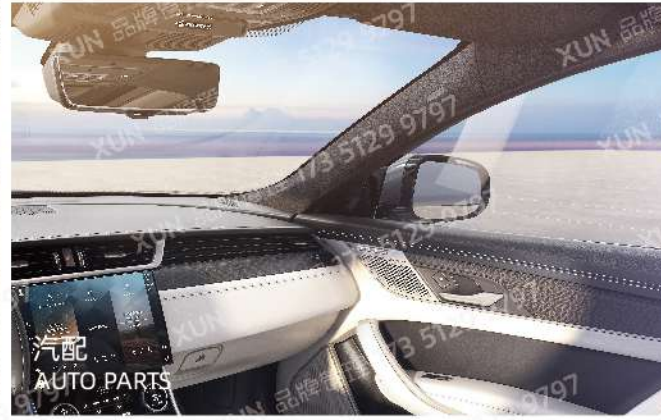
日用品
DAILY NECESSITIES



医疗
MEDICAL CARE



家具
FURNITURE



汽配
AUTO PARTS



食品包装
FOOD PACKAGING

APPLICATION
应用领域

同大生产的各类设备已应用于各大领域，使用效果佳。我们始终坚持以客户为中心而展开一切工作，秉持真心，时刻关注客户的需求。我们凭借强大的技术研发团队以及优异的研发创新能力，为不同客户的具体要求提供切实可行的技术方案，为客户提供满意的解决方案。

Various types of equipment produced by Tongda have been applied in various fields with good results.

We always adhere to customer-centric approach and carry out all work with sincerity, always paying attention to customer needs. We rely on a strong technical R&D team and excellent R&D innovation capabilities to provide practical and feasible technical solutions for the specific requirements of different customers, and to provide satisfactory solutions for customers.



其他
OTHER

- 电子 -ELECTRONIC
- 物流 -LOGISTICS
- 建材 -BUILDING MATERIALS
- 光学 -OPTICS
- IBC桶 -IBC BARREL



水罐
WATER POT



九脚托盘
NINE LEGGED TRAY



玩具
TOYS



广口桶
WIDE MOUTHED BARREL



机油罐
ENGINE OIL BOLLLE



化工
CHEMICAL INDUSTRY

0-3L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

性能和优点

- 适用于生产0-3L各类塑料中空制品;
- 采用高产量挤出系统, 连续式模头;
- 选配液位线挤出系统;
- 选配液压伺服控制系统。

PERFORMANCE AND ADVANTAGES

- Suitable for the production of 0-3L plastic hollow products;
- Continuous extrusion die head with high output extrusion system;
- Liquid Level Line extrusion system option;
- Hydraulic Servo Control System option.



HT-2L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



HTS II-2L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

No. of cavity	Center distance	A		B		H		φ		A		H	
		A	B	A	B	H	φ	A	H	A	H		
1	155	90	220	155	90	220	100	220	100	220			
2	130	95	95	220	95	95	220	95	220	95	220		
3	65			65	65	220	65	220	65	220			
4	60			50	50	120	50	120	50	120			
5	65												



技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL				
机型 Model		HT-2L	HTS-2L	HT II-2L	HTS II-2L	HT II-3L/6 (4)
基本参数 Specification						
工位数 Station		单 Single	单 Single	双 Double	双 Double	双 Double
制品最大容积 Max. Product volume	L	2	2	2	2	0.35
空循环 Dry cycle	pc/h	900	900	900×2	900×2	800×2
HDPE塑料挤出量 Output of HDPE	kg/h	50	40	60	60/85	85/110
机器重量 Weight of machine	kg	3300	4000	3900	6000	6000
机器外形尺寸 Size of machine	m,LxWxH	3×1.55×2.55	3.3×2.1×2.55	3.45×2.12×2.55	3.5×2.16×2.55	3.8×2.8×2.5
模头 Die Head						
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	108	108	108	108	30/50
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	5.2	5.2	5.2	5.2	12/11
模头加热段数(单模头) Die Head Heating Zone (Single-head)		3	3	3	3	13/10
六模头中心距(四模头) Central distance of Hexa diehead(Quad diehead)	mm					70/100
双模头中心距 Central distance of Bi-head	mm	130	130	130	130	
最大口模直径(双模头) Max. Die diameter (Bi-head)	mm	72	72	72	72	
模头加热功率(双模头) Die Head Heating power (Bi-head)	KW	7	7	7	7	
模头加热段数(双模头) Die Head Heating Zone (Bi-head)		5	5	5	5	
开合模系统 Clamping Unit						
开合模行程 Platen Distance	mm	138~368	138~368	138~368	138~368	160~320
移模行程 Moldmoving stroke	mm	370	370	370	370	500
锁模力 Clamping force	KN	44	44	44	44	70
挤出系统 Extruder Unit						
螺杆直径 Screw Diametre	mm	50	50	60	60/70	70/80
螺杆长径比 Screw Length/Diametre Ratio		25:1	25:1	25:1	25:1	25:1
螺杆加热功率 Screw heating power	KW	6.8	6.8	11.2	11.2/13.2	13.2/19
螺杆加热区段 No. of heating zone (Screw)		3	3	3	3	3/4
动力系统 Power Unit						
油泵电机功率 Hydraulic Pump Driving Power	KW	7.5	7.5	7.5	7.5	11
螺杆电机功率 Screw Motor Power	KW	11	11	15	15/22	22/30
装机总功率 Total Power	KW	30.5	30.5	39	39/46	58/72
备注 Remarks						
气体用量 Air consumption	m ³ /min	0.4	0.4	0.4	0.4	0.8
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	0.3	0.3	0.3
用水量 Water consumption	L/min	35	35	35	35	80
模具最大尺寸 Max. Size of Mold	mm,WxH	310×320	360×320	360×320	360×320	490×250

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

3-5L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

性能和优点

- 适用于生产3-5L各类塑料中空制品生产。
- 采用高产量挤出系统连续式模头。
- 选配液位线挤出系统。
- 选配液压伺服控制系统。

PERFORMANCE AND ADVANTAGES

- Suitable for the production of 3-5L plastic hollow products;
- Continuous extrusion die head with high output extrusion system;
- Liquid Level Line extrusion system option;
- Hydraulic Servo Control System option;



HT-5L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



单模头 Single die head

双模头 Double die head



技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL			
		HT-5L	HTS-5L	HS-5L	HSE-5L
机型 Model					
基本参数 Specification					
工位数 Station		单 Single	单 Single	单 Single	单 Single
制品最大容积 Max. Product volume	L	5	5	5	5
空循环 Dry cycle	pc/h	700	700	900	640
HDPE塑料挤出量 Output of HDPE	kg/h	60	85	85	80
机器重量 Weight of machine	kg	4000	5000	9000	20000
机器外形尺寸 Size of machine	m,LxWxH	3.6x2.06x2.65	3.68x2.17x2.85	5.2x2.5x3	4.9x4.5x3.5
模头 Die Head					
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	145	145	145	145
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	7.6	7.6	7.6	9
模头加热段数(单模头) Die Head Heating Zone (Single-head)		4	4	4	5
双模头中心距 Central distance of Bi-head	mm	160/180	160/180	160/180	
最大口模直径(双模头) Max. Die diameter (Bi-head)	mm	108	108	108	110
模头加热功率(双模头) Die Head Heating power (Bi-head)	KW	10.7	10.7	12	14
模头加热段数(双模头) Die Head Heating Zone (Bi-head)		5	5	5	11
开合模系统 Clamping Unit					
开合模行程 Platen Distance	mm	180~540	180~540	220~550	300~660
移模行程 Moldmoving stroke	mm	400	450	490	550
锁模力 Clamping force	KN	70	110	158	150
挤出系统 Extruder Unit					
螺杆直径 Screw Diameter	mm	60	70	70	60
螺杆长径比 Screw Length/Diameter Ratio		25:1	25:1	25:1	30:1
螺杆加热功率 Screw heating power	KW	11.2	13.2	13.2	15.6
螺杆加热区段 No.of heating zone (Screw)		3	3	3	4
螺杆电机功率 Screw Motor Power					30
动力系统 Power Unit					
油泵电机功率 Hydraulic Pump Driving Power	KW	11	15	12.5+4	
螺杆电机功率 Screw Motor Power	KW	15	22	22	
装机总功率 Total Power	KW	44.8	57.8	63.5	80
吹气系统 Blowing system	驱动形式 Driving form				伺服驱动 Servo drive
抬模头系统 Head lifting system	驱动形式 Driving form				伺服驱动 Servo drive
去飞边系统 Deflash system	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
移模 Shifting mold	驱动形式 Driving form				伺服驱动 Servo drive
开合模 Mold opening and closing	驱动形式 Driving form				伺服驱动 Servo drive
切刀 Slicer	驱动形式 Driving form				气动 Pneumatic
机械手 Manipulator	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
子模 Submodule	驱动形式 Driving form				伺服驱动 Servo drive
备注 Remarks					
气体用量 Air consumption	m ³ /min	0.4	0.4	1	≥5
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	≥0.8
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	0.3	≥0.4
用水量 Water consumption	L/min	50	50	60	250
模具最大尺寸 Max.Size of Mold	mm,WxH	370x390	440x420	480x450	530x430

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

3-5L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

性能和优点

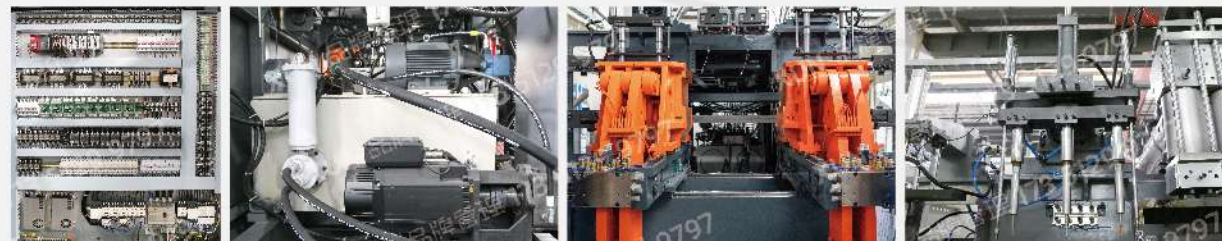
- 适用于生产3-5L各类塑料中空制品生产;
- 采用高产量挤出系统, 连续式模头, 移模比例伺服控制;
- 标配伺服液压控制系统;
- 选配液位线挤出系统。

PERFORMANCE AND ADVANTAGES

- Suitable for the production of 3-5L plastic hollow products;
- Continuous extrusion die head with high output extrusion system, mold moving proportional servo control system;
- Standard Hydraulic servo control system;
- Liquid Level Line extrusion system option.



HSII-5L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



HS-电箱 Electric box

HS-伺服电机 Servo motor

HS-开合模 Opening and closing die

HS-吹针 Blowing needle

技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL			
机型 Model		HT II-5L	HTS II-5L	HS II-5L	HSEII-5L
基本参数 Specification					
工位数 Station		双 Double	双 Double	双 Double	双 Double
制品最大容积 Max. Product volume	L	5	5	5	5
空循环 Dry cycle	pc/h	700×2	700×2	900×2	640×2
HDPE塑料挤出量 Output of HDPE	kg/h	85/110	110	110	160
机器重量 Weight of machine	kg	5500	8000	11000	22000
机器外形尺寸 Size of machine	m,LxWxH	3.43×2.3×2.65	4.1×2.6×2.85	5.2×2.7×3	7×4×4.5
模头 Die Head					
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	145	145	145	145
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	7.6	7.6	7.6	9
模头加热段数(单模头) Die Head Heating Zone (Single-head)		4	4	4	5
双模头中心距 Central distance of Bi-head	mm	160/180	160/180	160/180	
最大口模直径(双模头) Max. Die diameter (Bi-head)	mm	108	108	108	110
模头加热功率(双模头) Die Head Heating power (Bi-head)	KW	5	10.7	12	14
模头加热段数(双模头) Die Head Heating Zone (Bi-head)		10.7	5	5	11
开合模系统 Clamping Unit					
开合模行程 Platen Distance	mm	180~540	180~540	220~550	300~660
移模行程 Moldmoving stroke	mm	400	450	490	550
锁模力 Clamping force	KN	70	110	158	150
挤出系统 Extruder Unit					
螺杆直径 Screw Diameter	mm	70/80	80	80	80
螺杆长径比 Screw Length/Diameter Ratio		25:1	25:1	25:1	30:1
螺杆加热功率 Screw heating power	KW	13.2/19	19	19	17.2
螺杆加热区段 No.of heating zone (Screw)		3	4	4	4
螺杆电机功率 Screw Motor Power					55
动力系统 Power Unit					
油泵电机功率 Hydraulic Pump Driving Power	KW	11	15	12.5+4	
螺杆电机功率 Screw Motor Power	KW	22/30	30	30	
装机总功率 Total Power	KW	53.8/67.6	71.6	80	105
吹气系统 Blowing system	驱动形式 Driving form				伺服驱动 Servo drive
抬模头系统 Head lifting system	驱动形式 Driving form				伺服驱动 Servo drive
去飞边系统 Deflash system	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
移模 Shifting mold	驱动形式 Driving form				伺服驱动 Servo drive
开合模 Mold opening and closing	驱动形式 Driving form				伺服驱动 Servo drive
切刀 Slicer	驱动形式 Driving form				气动 Pneumatic
机械手 Manipulator	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
子模 Submodule	驱动形式 Driving form				伺服驱动 Servo drive
备注 Remarks					
气体用量 Air consumption	m ³ /min	0.4	0.4	1.2	≥6
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	≥0.8
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	0.3	≥0.4
用水量 Water consumption	L/min	60	60	60	320
模具最大尺寸 Max.Size of Mold	mm,WxH	390×390	440×420	480×450	530×430

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

3-5L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

性能和优点

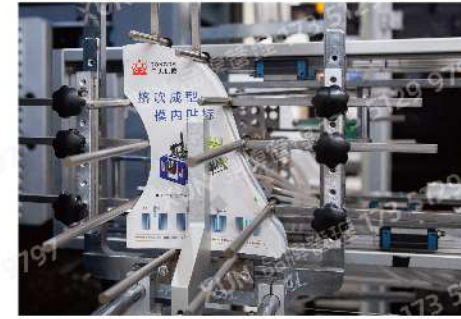
- 15寸触摸屏，可监控主机及各辅机；
- 采用Modbus/TCP通讯使主、辅机互联互通；
- 集成有伺服壁厚控制系统；
- 具备物联网功能，实现云端查看机器生产状态。

PERFORMANCE AND ADVANTAGES

- 15 inch touch screen, which can monitor the host and each auxiliary machine;
- Modbus/TCP communication is adopted to make the main and auxiliary machines interconnected;
- The servo wall thickness control system is integrated;
- It has the function of Internet of Things, enabling the cloud to view the machine production status.



HSE II-5L (全电动)
FULLY ELECTRICAL



HSE-模内贴标
In Mould Labeling



HSE-触摸屏
Touch Screen



HSE-开合模
Flex Arm Clamping



HTS-塑化系统
Plasticizing system



HTS-开合模
Flex Arm Clamping



HTS-吹针
Needle blow system



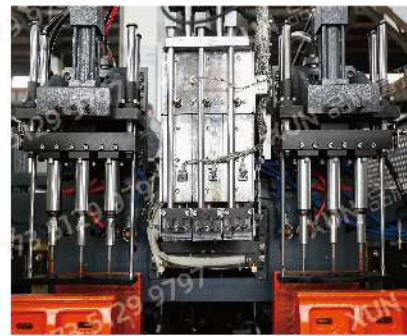
HTS-5L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

5-10L 全自动吹瓶机

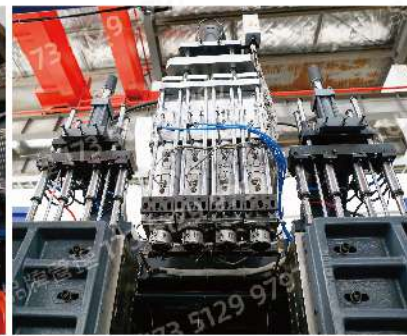
FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE



HTII-6L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



三模头 Three die head



四模头 Four die head



六模头 Six die head

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL		
		HT II-6L/6(4)	HTS II-8L	TDB-10F
机型 Model				
基本参数 Specification				
工位数 Station		双 Double	双 Double	单 Single
制品最大容积 Max. Product volume	L	1	1	10
空循环 Dry cycle	pc/h	700x2	700x2	600
HDPE塑料挤出量 Output of HDPE	kg/h	110	220	85
机器重量 Weight of machine	kg	8000	24000	5000
机器外形尺寸 Size of machine	m,LxWxH	4.4x3.2x2.7	6.5x5.2x3.7	4.1x2.3x3.1
模头 Die Head				
最大口模直径 Max. Die diameter	mm	45	70	180
模头加热功率 Die Head Heating power	KW	21/20	28	10.5
模头加热段数 Die Head Heating Zone		14/10	21	4
六模头中心距 Central distance of Hexa diehead	mm	90	130	
储料量 Capacity of Accumulator head				2
开合模系统 Clamping Unit				
开合模行程 Platen Distance	mm	160~400	160~400	410~800
移模行程 Moldmoving stroke	mm	600	900	
锁模力 Clamping force	KN	110	200	95
挤出系统 Extruder Unit				
螺杆直径 Screw Diametre	mm	80	100	70
螺杆长径比 Screw Length/Diametre Ratio		25:1	28:1	25:1
螺杆加热功率 Screw heating power	KW	19	26	13.2
螺杆加热区段 No.of heating zone (Screw)		4	5	3
动力系统 Power Unit				
油泵电机功率 Hydraulic Pump Driving Power	KW	15	31.5+4	12.5+4
螺杆电机功率 Screw Motor Power	KW	30	75	22
装机总功率 Total Power	KW	78	170	63.5
备注 Remarks				
气体用量 Air consumption	m ³ /min	0.8	0.8	0.6
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	0.4
用水量 Water consumption	L/min	80	60	50
模具最大尺寸 Max.Size of Mold	mm,WxH	590x300	740x330	480x530

*备注：以上规格参数，设计如有变更，恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

10-12L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

HSEII-12L (全电动)
FULLY ELECTRICAL

细节图 Detail drawing

技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL			
		HT-12L	HTS-12L	HS-12L	HSE-12L
机型 Model		HT-12L	HTS-12L	HS-12L	HSE-12L
基本参数 Specification					
工位数 Station		单 Single	单 Single	单 Single	单 Single
制品最大容积 Max. Product volume	L	12	12	12	12
空循环 Dry cycle	pc/h	700	700	700	500
HDPE塑料挤出量 Output of HDPE	kg/h	85/110	110	110	110
机器重量 Weight of machine	kg	6000	7000	15000	17000
机器外形尺寸 Size of machine	m,LxWxH	4.1x2.2x3.1	4.2x2.3x3.1	5.5x2.7x3.3	6.1x2.7x4.5
模头 Die Head					
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	220	200	200	180
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	9.1	9.1	8	15
模头加热段数(单模头) Die Head Heating Zone (Single-head)		3	3	3	7
双模头中心距 Central distance of Bi-head	mm	240/260	240/260	240/260	240/260
最大口模直径(双模头) Max. Die diameter (Bi-head)	mm	120	120	120	140
模头加热功率(双模头) Die Head Heating power (Bi-head)	KW	15	15	15	20
模头加热段数(双模头) Die Head Heating Zone (Bi-head)		7	7	7	11
开合模系统 Clamping Unit					
开合模行程 Platen Distance	mm	240~620	240~620	270~620	360~780
移模行程 Moldmoving stroke	mm	520	550	600	650
锁模力 Clamping force	KN	110	158	220	260
挤出系统 Extruder Unit					
螺杆直径 Screw Diameter	mm	70/80	80	80	70
螺杆长径比 Screw Length/Diameter Ratio		25:1	25:1	25:1	30:1
螺杆加热功率 Screw heating power	KW	13.2/19	19	19	15.6
螺杆加热区段 No.of heating zone (Screw)		3/4	4	4	4
螺杆电机功率 Screw Motor Power	KW	22/30	30	30	37
动力系统 Power Unit					
油泵电机功率 Hydraulic Pump Driving Power	KW	15	15	17+4	
装机总功率 Total Power	KW	59.3/73.1	73.1	79	115
吹气系统 Blowing system	驱动形式 Driving form				伺服驱动 Servo drive
抬模头系统 Head lifting system	驱动形式 Driving form				伺服驱动 Servo drive
去飞边系统 Deflash system	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
移模 Shifting mold	驱动形式 Driving form				伺服驱动 Servo drive
开合模 Mold opening and closing	驱动形式 Driving form				伺服驱动 Servo drive
切刀 Slicer	驱动形式 Driving form				气动 Pneumatic
机械手 Manipulator	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
子模 Submodule	驱动形式 Driving form				伺服驱动 Servo drive
备注 Remarks					
气体用量 Air consumption	m ³ /min	0.8	0.8	1.2	≥3
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	≥0.8
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	≥0.4	≥0.4
用水量 Water consumption	L/min	60	60	80	220
模具最大尺寸 Max.Size of Mold	mm,WxH	510x500	540x500	590x500	630x510

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

10-12L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

HTS II-12L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

HTS II-5L

No. of cavity	Center distance	A		B		H		Φ		A		H	
		1	2	1	2	1	2	1	2	1	2	1	2
1		230	140	300	230	140	300	140	300	140	300	140	300
2	160 (150)	140	90	200	150	80	200	140	200	140	200	140	200
3	110			85	85	220	85	220	85	220	85	220	85
4	80 (80)							70	200	70	200	70	200



新料层 New material
 回料层 Recycled material
 粘层 MR
 内层阻隔层 EVOH



技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL			
		HTS II-12L	HTS II-12L	HS II-12L	HSE II-12L
机型 Model					
基本参数 Specification					
工位数 Station		双 Double	双 Double	双 Double	双 Double
制品最大容积 Max. Product volume	L	12	12	12	12
空循环 Dry cycle	pc/h	700×2	700×2	700×2	450×2
HDPE塑料挤出量 Output of HDPE	kg/h	130	130	180	200
机器重量 Weight of machine	kg	10000	11000	18000	24000
机器外形尺寸 Size of machine	m,LxWxH	4.1×2.9×3.1	4.3×2.96×3.1	5.5×3.1×3.3	8.1×3.8×4.5
模头 Die Head					
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	220	200	200	180
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	9.1	9.1	9.1	15
模头加热段数(单模头) Die Head Heating Zone (Single-head)		3	3	3	7
双模头中心距 Central distance of Bi-head	mm	240/260	240/260	240/260	240/260
最大口模直径(双模头) Max. Die diameter (Bi-head)	mm	120	120	120	140
模头加热功率(双模头) Die Head Heating power (Bi-head)	KW	15	15	15	20
模头加热段数(双模头) Die Head Heating Zone (Bi-head)		7	7	7	11
开合模系统 Clamping Unit					
开合模行程 Platen Distance	mm	240~620	240~620	270~620	360~780
移模行程 Moldmoving stroke	mm	550	550	600	650
锁模力 Clamping force	KN	110	158	220	260
挤出系统 Extruder Unit					
螺杆直径 Screw Diameter	mm	90	90	100	90
螺杆长径比 Screw Length/Diameter Ratio		25:1	25:1	25:1	30:1
螺杆加热功率 Screw heating power	KW	17.4	17.4	21	21
螺杆加热区段 No.of heating zone (Screw)		4	4	4	5
螺杆电机功率 Screw Motor Power	KW	15	15	17+4	75
动力系统 Power Unit					
油泵电机功率 Hydraulic Pump Driving Power	KW	37	37	45	
装机总功率 Total Power	KW	78.5	78.5	96.1	165
吹气系统 Blowing system	驱动形式 Driving form				伺服驱动 Servo drive
抬模头系统 Head lifting system	驱动形式 Driving form				伺服驱动 Servo drive
去飞边系统 Deflash system	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
移模 Shifting mold	驱动形式 Driving form				伺服驱动 Servo drive
开合模 Mold opening and closing	驱动形式 Driving form				伺服驱动 Servo drive
切刀 Slicer	驱动形式 Driving form				气动 Pneumatic
机械手 Manipulator	驱动形式 Driving form				伺服驱动+气动 Servo drive+pneumatic
子模 Submodule	驱动形式 Driving form				伺服驱动 Servo drive
备注 Remarks					
气体用量 Air consumption	m ³ /min	0.8	0.8	1.6	≥4
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	≥0.8
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	≥0.4	≥0.4
用水量 Water consumption	L/min	60	60	100	350
模具最大尺寸 Max.Size of Mold	mm,WxH	540×500	540×500	590×500	630×510

备注: 以上规格参数, 设计如有变更, 恕不另行通知。
 Note: The specifications and design are subject to change without previous advice.

12-25L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

HTII-18L (全自动吹瓶机)
FULLY AUTOMATIC EXTRUSION
BLOW MOULDING MACHINE

标准空气阀 Standard air valve



紧急制动按钮 Emergency brake button



润滑系统 Lubrication oil pump system



蓄能器 Energy accumulator



技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL		
		HS II-15L	HT II-18L	TDB-25F
机型 Model				
基本参数 Specification				
工位数 Station		双 Double	双 Double	单 Single
制品最大容积 Max. Product volume	L	15	18	25
空循环 Dry cycle	pc/h	700×2	700×2	600
HDPE塑料挤出量 Output of HDPE	kg/h	230	130	110
机器重量 Weight of machine	kg	28000	11000	11000
机器外形尺寸 Size of machine	m,L×W×H	6.2×5.7×4.1	4.8×3.4×3.2	4.5×2.6×3.5
模头 Die Head				
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	200	220	300
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	9.1	9.1	17.7
模头加热段数(单模头) Die Head Heating Zone (Single-head)		3	3	5
储料量 Capacity of Accumulator head				4
双模头中心距 Central distance of Bi-head	mm	240/260	240/260	
最大口模直径(双模头) Max. Die diameter (Bi-head)	mm	120	120	
模头加热功率(双模头) Die Head Heating power (Bi-head)	KW	15	15	
模头加热段数(双模头) Die Head Heating Zone (Bi-head)		7	7	
开合模系统 Clamping Unit				
开合模行程 Platen Distance	mm	430~880	370~750	350~780
移模行程 Moldmoving stroke	mm	750	700	
锁模力 Clamping force	KN	240	158	215
挤出系统 Extruder Unit				
螺杆直径 Screw Diametre	mm	100	90/100	80
螺杆长径比 Screw Length/Diametre Ratio		28:1	25:1	25:1
螺杆加热功率 Screw heating power	KW	26	17.4/19.2	19
螺杆加热区段 No.of heating zone (Screw)		5	4	4
动力系统 Power Unit				
油泵电机功率 Hydraulic Pump Driving Power	KW	21+4	15	21+4
螺杆电机功率 Screw Motor Power	KW	75	37/45	30
装机总功率 Total Power	KW	175	78.5	95
备注 Remarks				
气体用量 Air consumption	m ³ /min	2.5	0.8	0.8
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	≥0.4	0.3	0.4
用水量 Water consumption	L/min	200	60	60
模具最大尺寸 Max.Size of Mold	mm,W×H	730×550	690×540	550×650

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

25-30L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

**HSE-30L (全电动)**
FULLY ELECTRICAL

细节图 Detail drawing

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL		
		HS-30L	HT II-30L	HS II-30L
机型 Model				
基本参数 Specification				
工位数 Station		单 Single	双 Double	双 Double
制品最大容积 Max. Product volume	L	30	30	30
空循环 Dry cycle	pc/h	480	400×2	480×2
HDPE塑料挤出量 Output of HDPE	kg/h	200	230	300
机器重量 Weight of machine	kg	28000	18000	36000
机器外形尺寸 Size of machine	m,LxWxH	8×4.1×4.1	6.4×5.2×4	8×6.8×4.1
模头 Die Head				
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	240	220	240
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	26	15	26
模头加热段数(单模头) Die Head Heating Zone (Single-head)		8	5	8
开合模系统 Clamping Unit				
开合模行程 Platen Distance	mm	460~960	450~1150	460~960
移模行程 Moldmoving stroke	mm	750	980	900
锁模力 Clamping force	KN	300	250	300
挤出系统 Extruder Unit				
螺杆直径 Screw Diameter	mm	90	100	100
螺杆长径比 Screw Length/Diameter Ratio		30:1	28:1	30:1
螺杆加热功率 Screw heating power	KW	21	26	23
螺杆加热区段 No.of heating zone (Screw)		5	5	5
动力系统 Power Unit				
油泵电机功率 Hydraulic Pump Driving Power	KW	31.5+4	21+4	31.5+4
螺杆电机功率 Screw Motor Power	KW	75	75	90
装机总功率 Total Power	KW	160	141	208.5
备注 Remarks		≥2		
气体用量 Air consumption	m ³ /min	≥0.8	1.2	≥3
吹气压力 Blow pressure	Mpa	≥0.4	0.6	≥0.8
冷却水压力 Cooling water pressure	Mpa	350	0.3	≥0.4
用水量 Water consumption	L/min	740×680	100	500
模具最大尺寸 Max.Size of Mold	mm,WxH		680×830	870×680

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

25-30L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE



No. of cavity	Center distance	A		B		H		Φ		A		H	
		A	B	A	B	A	B	Φ	H	A	B	A	H
1		250	180	300	250	180	300	240	300	240	300		
2	240 260	210	110	250	210	110	250	180	250	180	250		
3	160			130	90	220	120	220	120	220			
4	120						90	200	90	200			

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL	
		HSE-30L	HSE II-30L
机型 Model			
基本参数 Specification			
工位数 Station	L	单 Single	双 Double
制品最大容积 Max. Product volume	pc/h	30	30
空循环 Dry cycle	kg/h	450	400×2
HDPE塑料挤出量 Output of HDPE	kg	200	300
机器重量 Weight of machine	m,LxWxH	25000	35000
机器外形尺寸 Size of machine		8.3x5.5x4.5	8.3x6.7x4.5
模头 Die Head	mm		
最大口模直径(单模头) Max. Die diameter (Single-head)	KW	250	250
模头加热功率(单模头) Die Head Heating power (Single-head)		26	26
模头加热段数(单模头) Die Head Heating Zone (Single-head)		8	8
开合模系统 Clamping Unit			
开合模行程 Platen Distance	mm	490~960	490~960
移模行程 Moldmoving stroke	mm	750	900
锁模力 Clamping force	KN	300	300
挤出系统 Extruder Unit			
螺杆直径 Screw Diametre	mm	90	100
螺杆长径比 Screw Length/Diametre Ratio		30:1	30:1
螺杆加热功率 Screw heating power	KW	21	23
螺杆加热区段 No.of heating zone (Screw)		5	5
螺杆电机功率 Screw Motor Power	KW	75	90
动力系统 Power Unit			
吹气系统 Blowing system	驱动形式 Driving form	伺服驱动	Servo drive
抬模头系统 Head lifting system	驱动形式 Driving form	伺服驱动	Servo drive
去飞边系统 Deflash system	驱动形式 Driving form	伺服驱动+气动	Servo drive+pneumatic
移模 Shifting mold	驱动形式 Driving form	伺服驱动	Servo drive
开合模 Mold opening and closing	驱动形式 Driving form	伺服驱动	Servo drive
切刀 Slicer	驱动形式 Driving form	气动	Pneumatic
机械手 Manipulator	驱动形式 Driving form	伺服驱动+气动	Servo drive+pneumatic
子模 Submodule	驱动形式 Driving form	伺服驱动	Servo drive
备注 Remarks			
装机总功率 Total Power	KW	160	190
气体用量 Air consumption	m ³ /min	≥5	≥8
吹气压力 Blow pressure	Mpa	≥0.8	≥0.8
冷却水压力 Cooling water pressure	Mpa	≥0.4	≥0.4
用水量 Water consumption	L/min	350	600
模具最大尺寸 Max.Size of Mold	mm,WxH	740x680	870x680

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

30-50L 全自动吹瓶机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE



TDB-25F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



TDB-50F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL	
		HT-50L	TDB-50F
机型 Model			
基本参数 Specification			
工位数 Station		单 Single	单 Single
制品最大容积 Max. Product volume	L	35	50
空循环 Dry cycle	pc/h	240	400
HDPE塑料挤出量 Output of HDPE	kg/h	230	130/160
机器重量 Weight of machine	kg	15000	14000
机器外形尺寸 Size of machine	m,LxWxH	5.8x3.2x3.6	5.6x3.1x3.7
模头 Die Head			
最大口模直径(单模头) Max. Die diameter (Single-head)	mm	320	350
模头加热功率(单模头) Die Head Heating power (Single-head)	KW	15	27.4
模头加热段数(单模头) Die Head Heating Zone (Single-head)		6	6
储料量 Capacity of Accumulator head	L		6.6
开合模系统 Clamping Unit			
开合模行程 Platen Distance	mm	400~1050	450~1150
锁模力 Clamping force	KN	300	260
挤出系统 Extruder Unit			
螺杆直径 Screw Diameter	mm	90+50x2	90
螺杆长径比 Screw Length/Diameter Ratio		25:1	25:1/28:1
螺杆加热功率 Screw heating power	KW	17.4+6.8x2	17.4*20.5
螺杆加热区段 No.of heating zone (Screw)		4+3x2	4/5
动力系统 Power Unit			
油泵电机功率 Hydraulic Pump Driving Power	KW	42	21+4
螺杆电机功率 Screw Motor Power	KW	37+11x2	37/45
装机总功率 Total Power	KW	137	107/118
备注 Remarks			
气体用量 Air consumption	m ³ /min	1.2	1
吹气压力 Blow pressure	Mpa	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	0.4	0.4
用水量 Water consumption	L/min	100	85
模具最大尺寸 Max.Size of Mold	mm,WxH	680x650	700x950

备注：以上规格参数，设计如有变更，恕不另行通知。
Note: The specifications and design are subject to change without previous advice.

50-120L 全自动吹塑中空成型机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE

**TDB-80F (全自动吹塑中空成型机)**
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

TDB-机架 Clamping Structure



TDB-挤出系统 Upper Parison Sealing Device



TDB-下吹装置 Bottom Blowing Unit

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL	
		TDB-80F	TDB-120F
机型 Model			
基本参数 Specification			
工位数 Station		单 Single	单 Single
制品最大容积 Max. Product volume	L	120	120
空循环 Dry cycle	pc/h	240	120
HDPE塑料挤出量 Output of HDPE	kg/h	160	160
机器重量 Weight of machine	kg	16000	20000
机器外形尺寸 Size of machine	m,LxWxH	5.42x2.45x3.9	5.8x2.9x4.3
模头 Die Head			
最大口模直径 Max. Die diameter	mm	420	420
模头加热段数 Die Head Heating Zone		6	6
储料量 Capacity of Accumulator head	L	12.8	12.8
模头加热功率 Die Head Heating power	KW	30	30
开合模系统 Clamping Unit			
开合模行程 Platen Distance	mm	500~1400	500~1400
移模行程 Moldmoving stroke	mm		
锁模力 Clamping force	KN	440	740
挤出系统 Extruder Unit			
螺杆数目 Screw Number			
螺杆直径 Screw Diameter	mm	100	100
螺杆长径比 Screw Length/Diameter Ratio		25:1	25:1
螺杆加热功率 Screw heating power	KW	21	21
螺杆加热区段 No.of heating zone (Screw)		4	4
动力系统 Power Unit			
油泵电机功率 Hydraulic Pump Driving Power	KW	31.5+4	31.5+4
螺杆电机功率 Screw Motor Power	KW	45	45
装机总功率 Total Power	KW	135	135
备注 Remarks			
气体用量 Air consumption	m ³ /min	1.2	1.6
吹气压力 Blow pressure	Mpa	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	0.3	0.3
用水量 Water consumption	L/min	100	150
模具最大尺寸 Max.Size of Mold	mm,WxH	800x1000	900x1450

备注: 以上规格参数, 设计如有变更, 恕不另行通知。
Note: The specifications and design are subject to change without previous advice.

120-160L 无拉杆中空成型机

FULLY AUTOMATIC TIE-BARLESS EXTRUSION BLOW MOULDING MACHINE (ACCUMULATOR)



TDW-160EF (无拉杆中空成型机)
FULLY AUTOMATIC TIE-BARLESS EXTRUSION
BLOW MOULDING MACHINE (ACCUMULATOR)

性能和优点

- 适用于生产各种托盘，桌面板、路障等大型中空吹塑制品；
- 采用高产量挤出系统，储料式模头；
- 标配伺服液压控制系统。

PERFORMANCE AND ADVANTAGES

- Suitable for the production of all kinds of pallets, table panels, roadblocks and other large hollow blow molding products;
- Accumulator type of head with high output extrusion system;
- Standard hydraulic servo system.



技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL		
		TDB-160F	TDB-160D	TDW-160EF
机型 Model				
基本参数 Specification				
工位数 Station		单 Single	单 Single	单 Single
制品最大容积 Max. Product volume	L	160	160	160
空循环 Dry cycle	pc/h	120	120	100
HDPE塑料挤出量 Output of HDPE	kg/h	210	300	210/300
机器重量 Weight of machine	kg	23000	26000	22000
机器外形尺寸 Size of machine	m,LxWxH	6.54x2.9x4.5	6.8x3.2x5.6	7.6x3.1x5.5
模头 Die Head				
最大口模直径 Max. Die diameter	mm	600	600	600/700
模头加热段数 Die Head Heating Zone		6	7	6
储料量 Capacity of Accumulator head	L	18	28	18/22
模头加热功率 Die Head Heating power	KW	40	51.5	40/46
开合模系统 Clamping Unit				
开合模行程 Platen Distance	mm	500~1400	800~1800	500~1900
锁模力 Clamping force	KN	740	740	1200
挤出系统 Extruder Unit				
螺杆直径 Screw Diameter	mm	100	120	100/120
螺杆长径比 Screw Length/Diameter Ratio		28:1	28:1	28:1
螺杆加热功率 Screw heating power	KW	26	30	26/32
螺杆加热区段 No. of heating zone (Screw)		5	5	5
动力系统 Power Unit				
油泵电机功率 Hydraulic Pump Driving Power	KW	31.5+4	31.5/42.5+11	31.5+11
螺杆电机功率 Screw Motor Power	KW	75	90	75/90
装机总功率 Total Power	KW	180	240/251	180/210.5
备注 Remarks				
气体用量 Air consumption	m ³ /min	1.6	1.6	2
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	0.4
用水量 Water consumption	L/min	180	180	300
模具最大尺寸 Max. Size of Mold	mm,WxH	900x1450	1000x1900	1200x1900

备注：以上规格参数，设计如有变更，恕不另行通知。
Note: The specifications and design are subject to change without previous advice.

160-250L 全自动双L生产线

FULLY AUTOMATIC DOUBLE L RING PRODUCING LINE SERIES

性能和优点

- 适用于生产160-250L化工桶双L环化工包装桶等;
- 采用高产量挤出系统, 连续式模头;
- 选配液压伺服控制系统。

PERFORMANCE AND ADVANTAGES

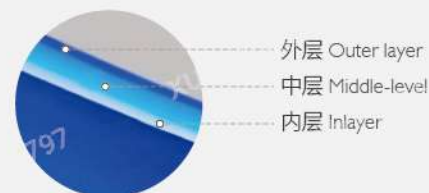
- It is applicable to the production of 160-250L chemical barrels, double L-ring chemical packaging barrels, etc;
- Adopt high-yield extrusion system and continuous die;
- Optional hydraulic servo control system.



TDBII-250F/1-3P (全自动双L生产线)
FULLY AUTOMATIC
DOUBLE L RING PRODUCING LINE SERIES



TDB-250F/3P (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



外层 Outer layer
中层 Middle-level
内层 Inlayer

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL			
机型 Model		TDB-250F	TDB-250F/P	TDB-250F/3P	TDBII-250F/1-3P
基本参数 Specification					
工位数 Station		单 Single	单 Single	单 Single	双 Double
制品最大容积 Max. Product volume	L	250	250	250	250
空循环 Dry cycle	pc/h	300	300	300	
HDPE塑料挤出量 Output of HDPE	kg/h	380	200×2	110×2+200	380+200×2=780
机器重量 Weight of machine	kg	35000	36000	38000	60000~65000
机器外形尺寸 Size of machine	m,LxWxH	8.2×3.2×5.5	8.2×3.2×5.5	8.2×3.2×5.5	13.6×6×5.3
模头 Die Head					
最大口模直径 Max. Die diameter	mm	290	290	290	350
模头加热段数 Die Head Heating Zone		7	8	8	10
储料量 Capacity of Accumulator head	L	22	22	22	
模头加热功率 Die Head Heating power	KW	45	53	53	67.3
开合模系统 Clamping Unit					
开合模行程 Platen Distance	mm	800~1800	800~1800	800~1800	800~1800
移模行程 Moldmoving stroke	mm				
锁模力 Clamping force	KN	740	740	740	1500
挤出系统 Extruder Unit					
螺杆数目 Screw Number		1	2	3	3
螺杆直径 Screw Diameter	mm	120	90×2	70×2+90	120+90×2
螺杆长径比 Screw Length/Diameter Ratio		30:1	30:1	30:1	30:1
螺杆加热功率 Screw heating power	KW	38	26.5×2	14×2+26.5	98
螺杆加热区段 No.of heating zone (Screw)		5	4×2	4×3	5+4+4
动力系统 Power Unit					
油泵电机功率 Hydraulic Pump Driving Power	KW	42.5+21+11	42.5+21+11	42.5+21+11	31.5×2+11
螺杆电机功率 Screw Motor Power	KW	132	75×2	37×2+75	132+75×2=310
装机总功率 Total Power	KW	304.5	335	340	510
备注 Remarks					
气体用量 Air consumption	m ³ /min	2	2	2	4
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	0.8
冷却水压力 Cooling water pressure	Mpa	0.3	0.3	0.3	0.4
用水量 Water consumption	L/min	300	300	300	500
模具最大尺寸 Max.Size of Mold	mm,WxH	1100×1600	1100×1600	1100×1600	1100×1600

备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

250-350L 无拉杆中空成型机

FULLY AUTOMATIC TIE-BARLESS EXTRUSION BLOW MOULDING MACHINE (ACCUMULATOR)

**性能和优点**

- 适用于生产各种托盘，桌面板、路障等大型中空吹塑制品；
- 采用高产量挤出系统，储料式模头；
- 标配伺服液压控制系统。

PERFORMANCE AND ADVANTAGES

- Suitable for the production of all kinds of pallets, table panels, roadblocks and other large hollow blow molding products;
- Accumulator type of head with high output extrusion system;
- Standard hydraulic servo system.

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL
机型 Model		TDW-350F
基本参数 Specification		
工位数 Station		单 Single
制品最大容积 Max. Product volume	L	350
空循环 Dry cycle	pc/h	100
HDPE塑料挤出量 Output of HDPE	kg/h	380
机器重量 Weight of machine	kg	45000
机器外形尺寸 Size of machine	m,LxWxH	8.6x3.2x5.6
模头 Die Head		
最大口模直径 Max. Die diameter	mm	900
模头加热段数 Die Head Heating Zone		8
储料量 Capacity of Accumulator head	L	35
模头加热功率 Die Head Heating power	KW	60
开合模系统 Clamping Unit		
开合模行程 Platen Distance	mm	750~1800
移模行程 Moldmoving stroke	mm	
锁模力 Clamping force	KN	1800
挤出系统 Extruder Unit		
螺杆数目 Screw Number		
螺杆直径 Screw Diametre	mm	120
螺杆长径比 Screw Length/Diametre Ratio		30:1
螺杆加热功率 Screw heating power	KW	53
螺杆加热区段 No.of heating zone (Screw)		5
动力系统 Power Unit		
油泵电机功率 Hydraulic Pump Driving Power	KW	31.5+11
螺杆电机功率 Screw Motor Power	KW	132
装机总功率 Total Power	KW	287.5
备注 Remarks		
气体用量 Air consumption	m³/min	2
吹气压力 Blow pressure	Mpa	0.6
冷却水压力 Cooling water pressure	Mpa	0.4
用水量 Water consumption	L/min	300
模具最大尺寸 Max.Size of Mold	mm,WxH	1600x1900

备注：以上规格参数，设计如有变更，恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

350-1500L 大型中空成型机

FULLY AUTOMATIC EXTRUSION BLOW MOULDING MACHINE



HTW-1000L (大型中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



TDB-1200L (大型中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



技术参数 TECHNICAL PARAMETER

项目/ITEM	单位/UNITS	机型/MODEL			
		TDB-1000F	TDB-1200L	TDB-1200F-2P	HT-1500L
机型 Model					
基本参数 Specification					
工位数 Station		单 Single	单 Single	单 Single	单 Single
制品最大容积 Max. Product volume	L	1000L	1200L	1200L	1500L
空循环 Dry cycle	pc/h	30	30	30	30
HDPE塑料挤出量 Output of HDPE	kg/h	420	550	600	420
机器重量 Weight of machine	kg	65000	70000	75000	50000
机器外形尺寸 Size of machine	m,LxWxH	9.8x2.7x7	12.7x7x7	12.7x6.7x6.5	9x3.5x6.5
模头 Die Head					
最大口模直径 Max. Die diameter	mm	1000	640	640	800
模头加热段数 Die Head Heating Zone		7	9	10	8
储料量 Capacity of Accumulator head	L	45	45	45	35
模头加热功率 Die Head Heating power	KW	75	70	102	60
开合模系统 Clamping Unit					
开合模行程 Platen Distance	mm	700~1900	1100~2700	1100~2700	600~2000
锁模力 Clamping force	KN	1200	1200	1200	1400
挤出系统 Extruder Unit					
螺杆直径 Screw Diameter	mm	135	150	100x2	135
螺杆长径比 Screw Length/Diameter Ratio		28:1	30:1	30:1	28:1
螺杆加热功率 Screw heating power	KW	40	50	23x2	40
螺杆加热区段 No.of heating zone (Screw)		5	5	5x2	5
动力系统 Power Unit					
油泵电机功率 Hydraulic Pump Driving Power	KW	42.5+4+11	42.5+11+5.5	42.5+11+5.5	42.5+11+5.5
螺杆电机功率 Screw Motor Power	KW	160	200	90x2	160
装机总功率 Total Power	KW	334	379	387	319
备注 Remarks					
气体用量 Air consumption	m ³ /min	5	6	6	3
吹气压力 Blow pressure	Mpa	0.6	0.6	0.6	0.6
冷却水压力 Cooling water pressure	Mpa	0.4	0.4	0.4	0.4
用水量 Water consumption	L/min	350	350	350	350
模具最大尺寸 Max.Size of Mold	mm,WxH	1550x1550	1800x1600	1800x1600	1400x1900

备注：以上规格参数，设计如有变更，恕不另行通知。
Note: The specifications and design are subject to change without previous advice.

TONGDA MACHINE同心合力 一起壮大
GROWING WITH PARTNERS

www.tongdamachine.net

ISO9001 CE

TDB-25APC

DRINKING WATER BOTTLE BLOWING MACHINE

TDB系列 (PC5加仑、3加仑纯净水桶、灯罩专用吹塑中空成型机)

**性能和优点**

- 适用于生产2-5加仑PC材料吹塑制品;
- 采用高产量挤出系统, 储料式模头。

PERFORMANCE AND ADVANTAGES

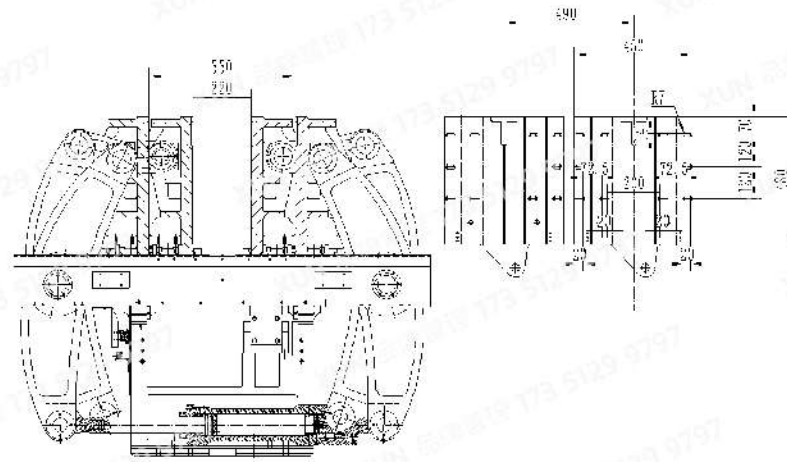
- Suitable for producing 2-5 gallon 10-25liter PC material blow product;
- Accumulator type of head with high output extrusion system.

**技术参数 TECHNICAL PARAMETER**

项目/ITEM	单位/UNITS	机型/MODEL
机型 Model		TDB-25APC
基本参数 Specification		
工位数 Station		单 Single
制品最大容积 Max. Product volume	L	25
空循环 Dry cycle	pc/h	600
HDPE塑料挤出量 Output of HDPE	kg/h	160(PC)
机器重量 Weight of machine	kg	12000
机器外形尺寸 Size of machine	m,LxWxH	6.3x2.6x3.8
模头 Die Head		
最大口模直径 Max. Die diameter	mm	82.5/150
模头加热段数 Die Head Heating Zone		5
储料量 Capacity of Accumulator head	L	1.9
模头加热功率 Die Head Heating power	KW	13.5
开合模系统 Clamping Unit		
开合模行程 Platen Distance	mm	350~780
移模行程 Moldmoving stroke	mm	
锁模力 Clamping force	KN	215
挤出系统 Extruder Unit		
螺杆数目 Screw Number		1
螺杆直径 Screw Diametre	mm	82
螺杆长径比 Screw Length/Diametre Ratio		38:1/30:1
螺杆加热功率 Screw heating power	KW	40
螺杆加热区段 No.of heating zone (Screw)		7
动力系统 Power Unit		
油泵电机功率 Hydraulic Pump Driving Power	KW	45+4
螺杆电机功率 Screw Motor Power	KW	
装机总功率 Total Power	KW	102.5
备注 Remarks		
气体用量 Air consumption	m ³ /min	1
吹气压力 Blow pressure	Mpa	0.6
冷却水压力 Cooling water pressure	Mpa	0.3
用水量 Water consumption	L/min	150
模具最大尺寸 Max.Size of Mold	mm,WxH	550x650

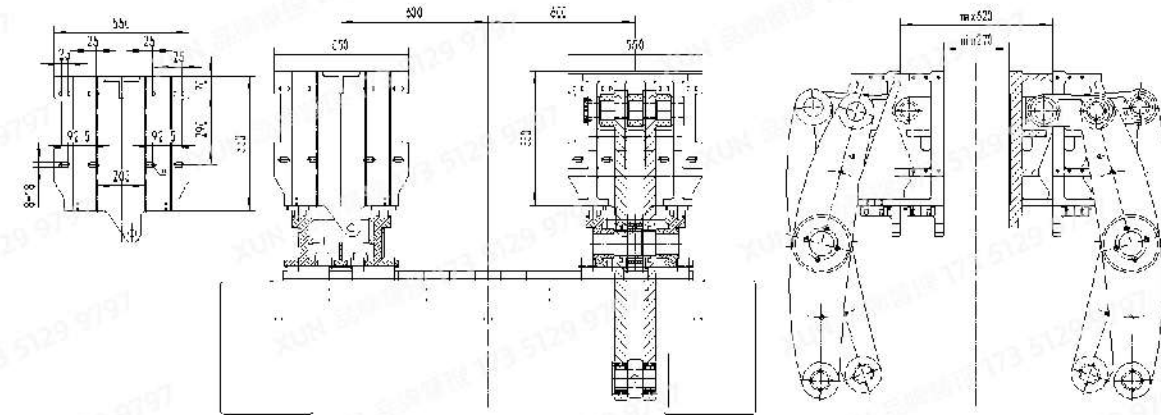
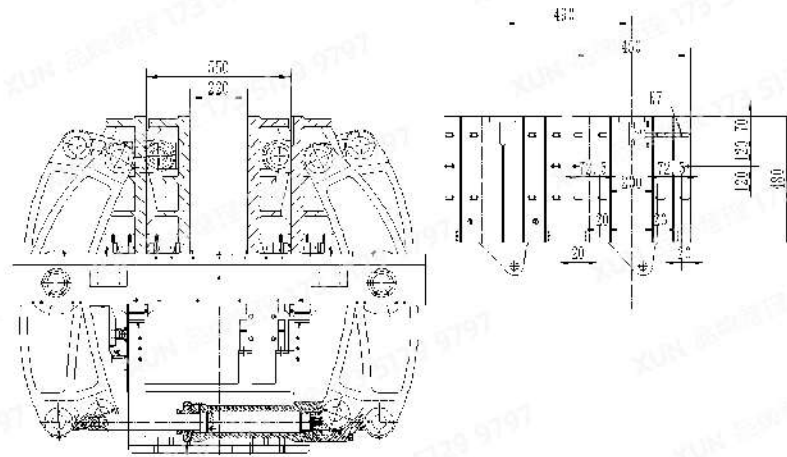
备注: 以上规格参数, 设计如有变更, 恕不另行通知。

Note: The specifications and design are subject to change without previous advice.

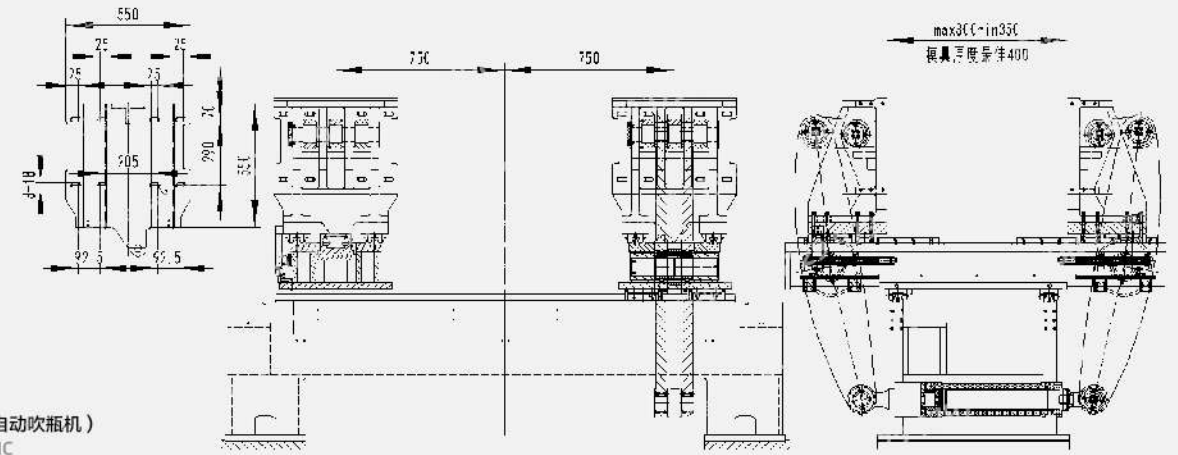


HS-5L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

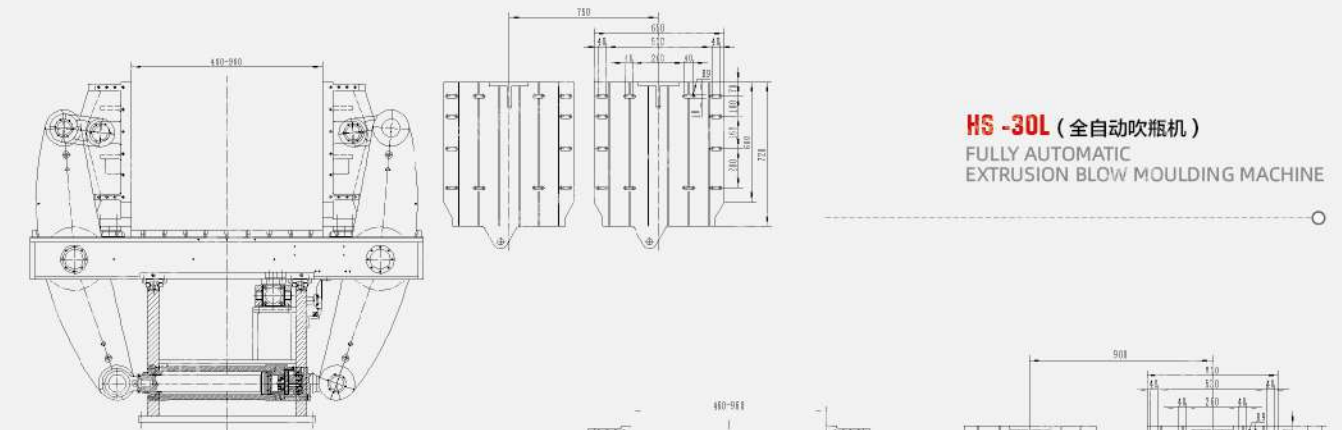
HS II-5L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



HS II-12L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

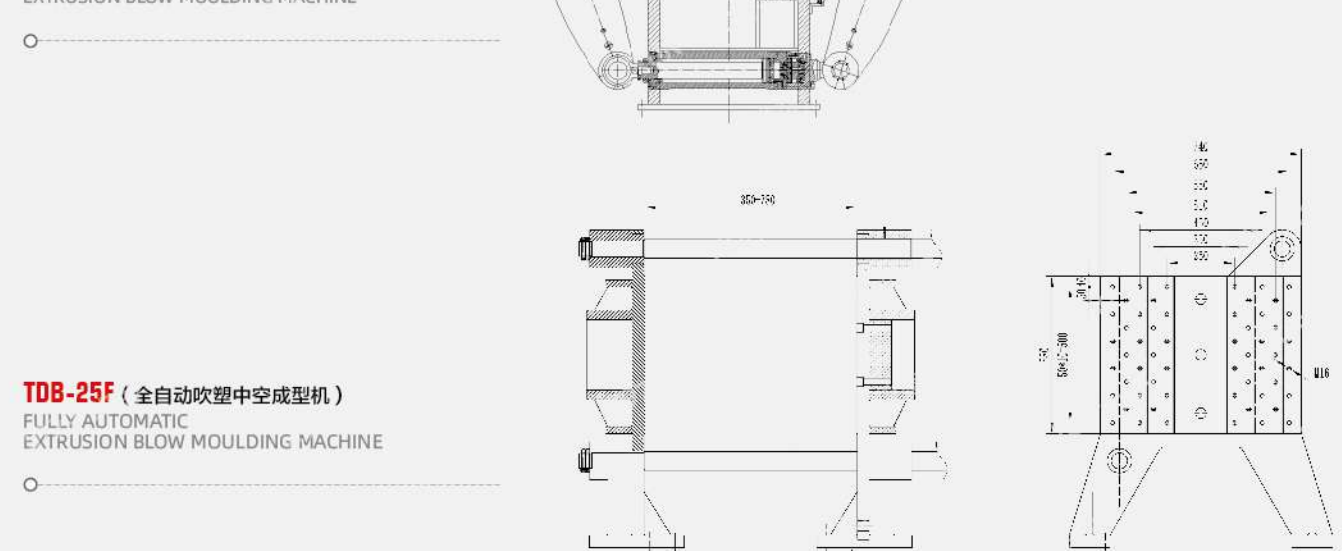


HS II-15L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

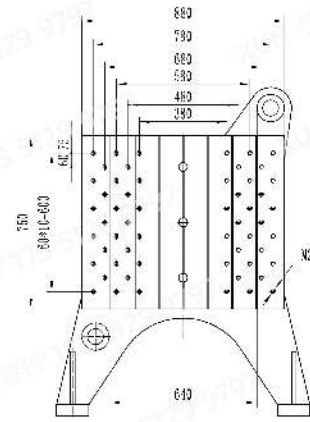
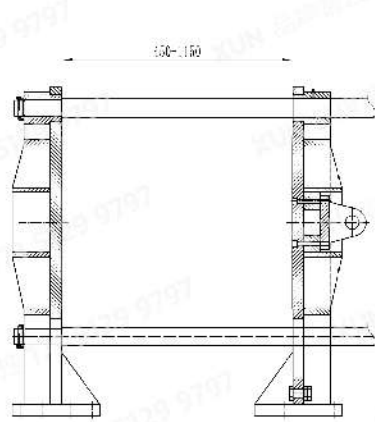


HS-30L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

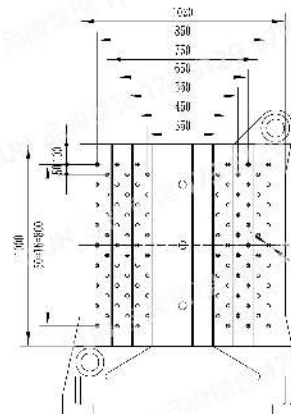
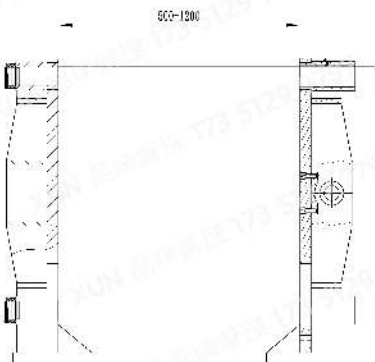
HS II-30L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



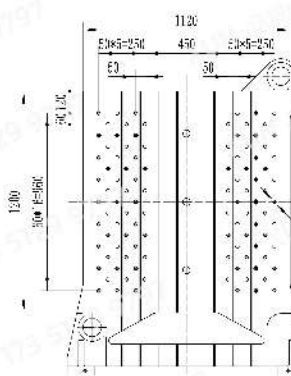
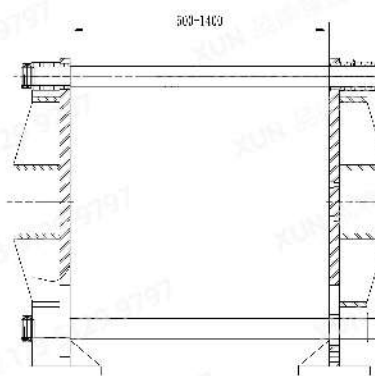
TDB-25F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



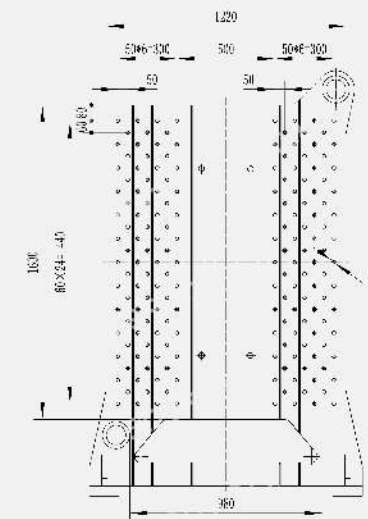
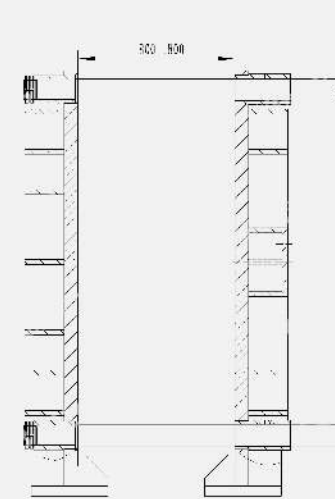
TDB-50F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



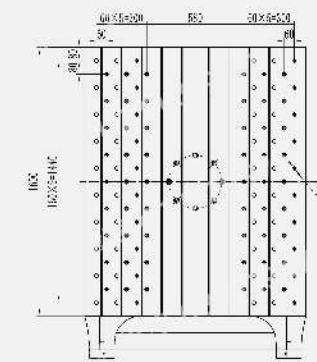
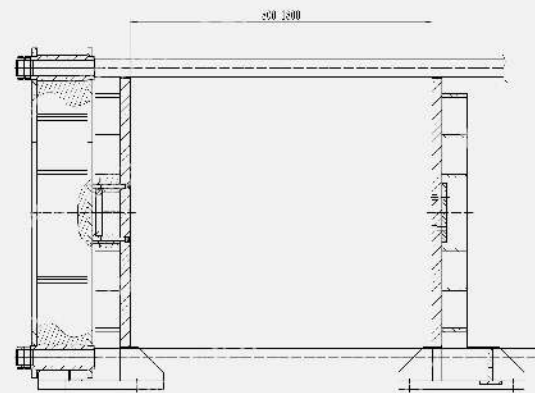
TDB-80F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



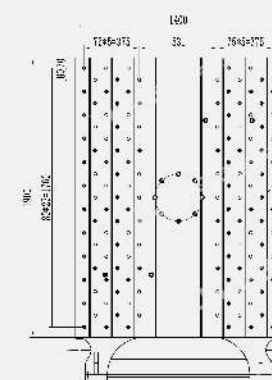
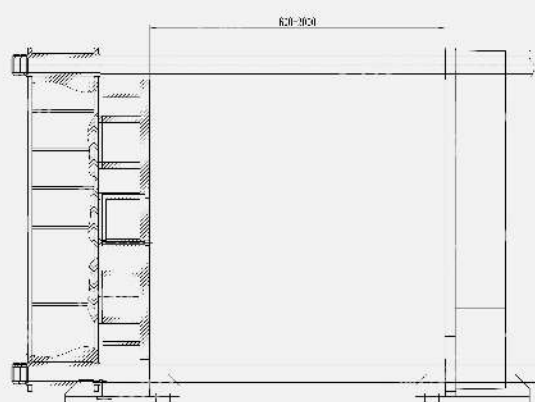
TDB-120F/160F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



TDB-1600 (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



TDB-250F (全自动吹塑中空成型机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE



HT-1500L (全自动吹瓶机)
FULLY AUTOMATIC
EXTRUSION BLOW MOULDING MACHINE

AUXILIARY MACHINE

辅机



上料机
Feeding machine



破碎机
Crusher

拌料机
Mixer



分体式上料机
Auto loader



静音集中型粉碎机
Noise proof crusher



两料比例阀
Material proportion valve



计量式色母机
Color master batch machine



冷却水塔
Cooling tower



切口机
Cutting machine



称重式混料机
Weighing mixer



欧化立式混料机
Europe vertical mixer



活塞空压机
Piston air compressor



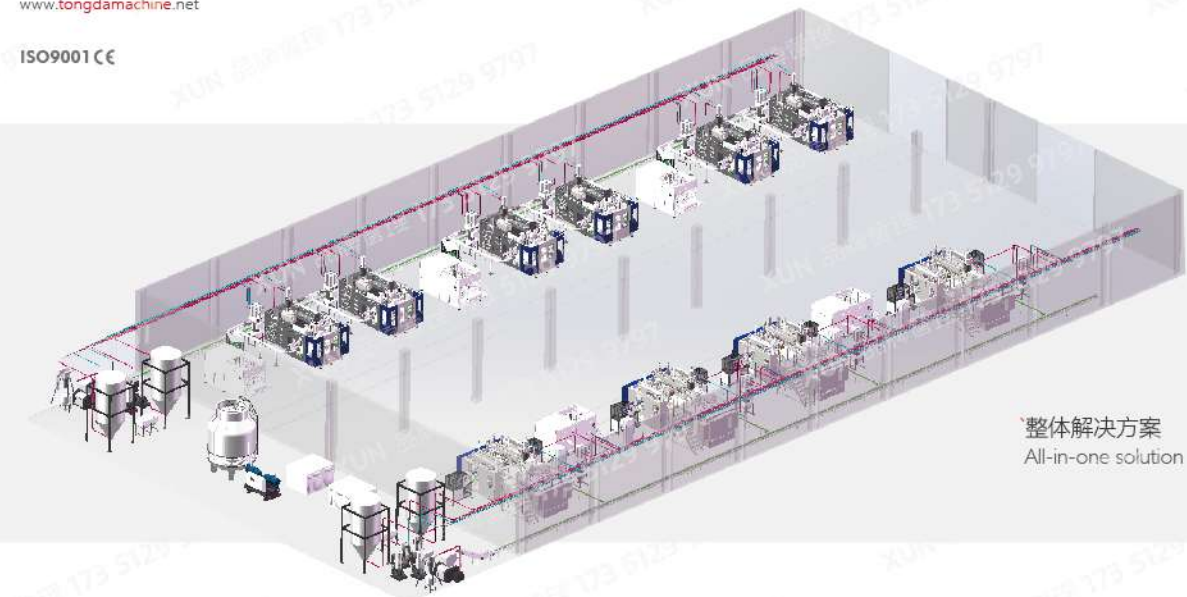
塑料干燥机
Hopper dryer



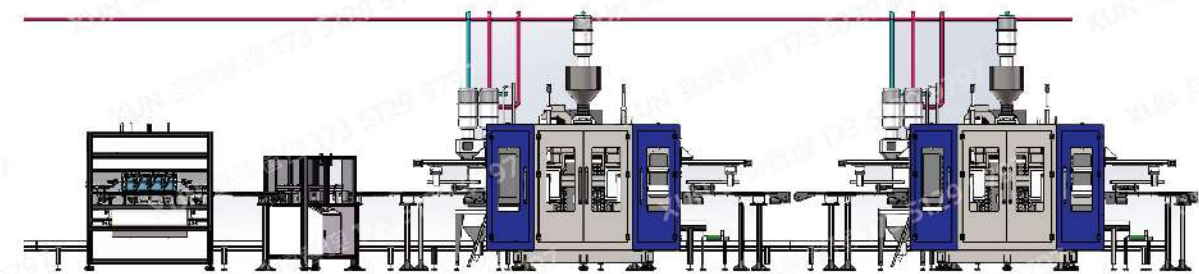
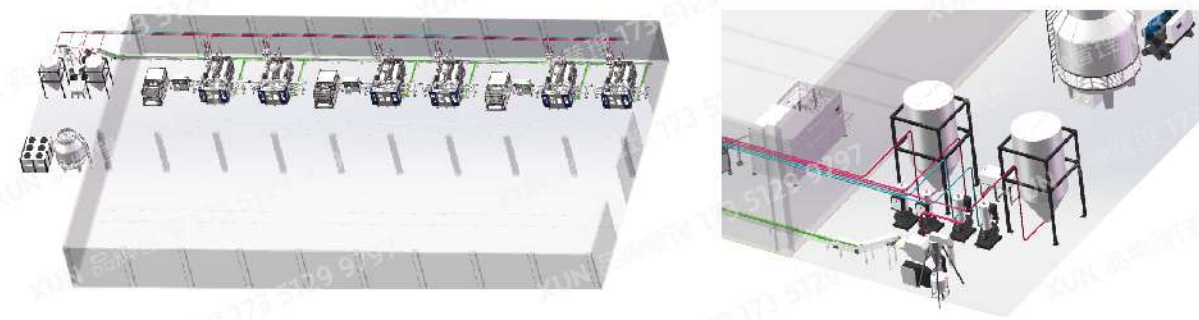
水冷式冰水机
Water cooling type chiller



膜内贴标机
Labeling machine



整体解决方案
All-in-one solution



测漏机
Leak tester



打包机
Packing machine

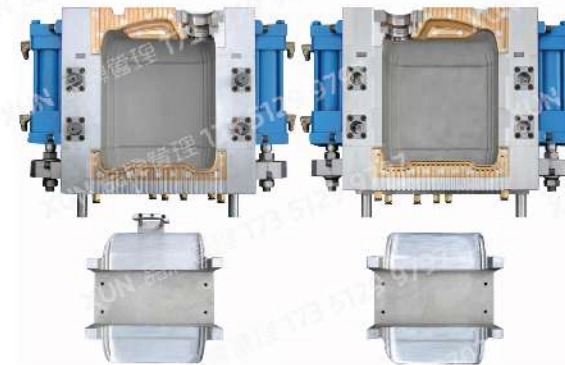
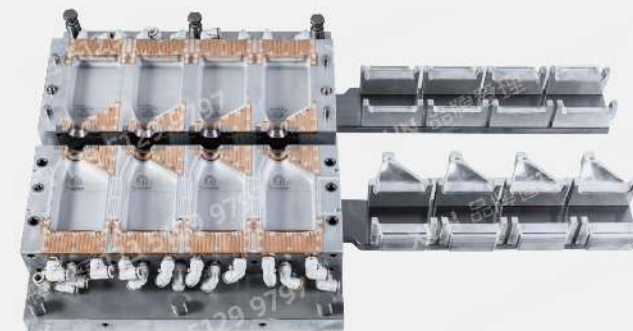


折盖机
Folding machine

MOULD

模具

吹塑模具/注塑模具
BLOW MOLD / INJECTION MOLD



MAJOR CUSTOMERS

主要客户

践行“客户第一”，满足客户需求

Practice 'customer first' and meet customer needs



GLOBAL SALES SERVICE CENTER

全球销售服务中心

截至目前，我们的产品已经远销美国、英国、澳大利亚、希腊、波兰、俄罗斯、南美、南非、伊朗、印度尼西亚、苏丹、约旦、埃塞俄比亚、乌克兰、尼日利亚、爱沙尼亚、罗马尼亚、智利等90多个国家和地区，销售超过8000台套同大机械设备。我们在全球范围内设有17个海外销售网点，并与众多行业服务伙伴建立了广泛的合作关系。

As of now, our products have been exported to over 90 countries and regions, including the United States, the United Kingdom, Australia, Greece, Poland, Russia, South America, South Africa, Iran, Indonesia, Sudan, Jordan, Ethiopia, Ukraine, Nigeria, Estonia, Romania, Chile, and more, with over 8000 sets of machinery and equipment of the same size sold. We have 17 overseas sales outlets worldwide and have established extensive cooperative relationships with numerous industry service partners.

90+
个

国家和地区业务覆盖
Country and regional business coverage

17
个

国外销售服务中心
Foreign sales service center

16
个

国内销售服务中心
Domestic sales service center

台州 / 天津 / 临沂 / 淄博 / 沈阳 / 西安
郑州 / 武汉 / 重庆 / 成都 / 上饶 / 金华
广州 / 厦门 / 上海 / 宁波



SALES SERVICE

销售服务

关注客户需求
FOCUS ON
CUSTOMER NEEDS

关注客户需求，令客户拥有更好的试模体验。获取宝贵的市场反馈，精准把握市场发展动态、判断客户切实所需方向，灵活丰富的机型及技术选择。
Pay attention to customer needs and provide them with a better trial experience. Obtain valuable market feedback, accurately grasp market development trends, and determine the direction that customers truly need. Flexible and rich selection of models and technologies.

全程贴心服务
WHOLE PROCESS
CONSIDERATE SERVICE

拥有健全的服务网络、完善的售后服务体系，全球33家专业售后服务团队，及时响应的服务机制不断提升用户满意度。真诚服务每一家客户，迅速反应，及时解决客户提出的问题，我们会定期派调试工程师走访客户，同大24小时陪伴在您身边。

We have a sound service network, a comprehensive after-sales service system, 33 professional after-sales service teams worldwide, and a timely response service mechanism to continuously improve user satisfaction. Sincere service to every customer, quick response, and timely resolution of customer issues. We will regularly send debugging engineers to visit customers, and Tongda will be by your side 24 hours a day.

提供整体解决方案
PROVIDE OVERALL
SOLUTION

24年塑料机械制造经验，提供自动化生产线，提高生产效率和提高产品质量，相互促进、降低成本、增加效益，助力客户生产效益最大化。
24 years of experience in plastic machinery manufacturing, providing automated production lines to improve production efficiency and product quality, promoting each other, reducing costs, increasing benefits, and helping customers maximize production efficiency.



01

需求分析	REQUIREMENT ANALYSIS
产品	Product
商业用途	Commercial use
材料技术	Material technology
模具过程	Mold process
生产要求	Production requirements
能源需求	Energy needs
自动化程度	Degree of automation
ROI分析	ROI analysis
确定可行性计划	Determine feasibility plan



02

订单生产	ORDER PRODUCTION
确定订单	Confirm order
下达生产任务	Release production tasks
生产制造	Production and manufacturing
关键品质检验	Quality inspection of key products
总装	Final assembly
调试	Debugging
整机检验	Complete machine inspection
发货	Delivery



03

服务	SERVICE
工程师驻厂安装	Engineer on-site installation
工艺支持	Process support
使用培训	Use training
培训FAT	Training FAT
维护和保养	Care and maintenance
全生命周期服务	Full life cycle service





63/64
TONGDA MACHINE

同心合力 一起壮大
GROWING WITH PARTNERS

www.tongdamachine.net

ISO9001CE

FUTURE OUTLOOK

未来展望

同大与未来同步

稳定的产品质量和诚信可靠的供货信誉及售后服务
工业自动化与智能制造的全套解决方案
“智”运营，“碳”未来，工业4.0转型升级
专业化规模化发展的快车道
同大期待与您携手共进

同心合力 一起壮大

SYNCHRONIZE WITH THE FUTURE

Stable product quality, honest and reliable supply reputation, and after-sales service
A complete solution for industrial automation and intelligent manufacturing
Intelligent "Operation", Carbon "Future", Industrial 4.0 Transformation and Upgrading
The Fast Track of Professional and Scaled Development
Tongda looks forward to working together with you

GROWING WITH PARTERS

地址：江苏张家港市凤凰镇韩国工业园凤凰大道21号
电话：0512-56370112 0512-56370113
传真：0086-512-58920956
邮箱：info@tongdamachine.com
邮编：215614

Add: NO.21 Fenghuang Avenue, Fenghuang Town, Zhangjiagang City, Jiangsu Province, China
Tel: 0512-56370112 0512-56370113
Fax: 0086-512-58920956
Email: info@tongdamachine.com
Post code: 215614



