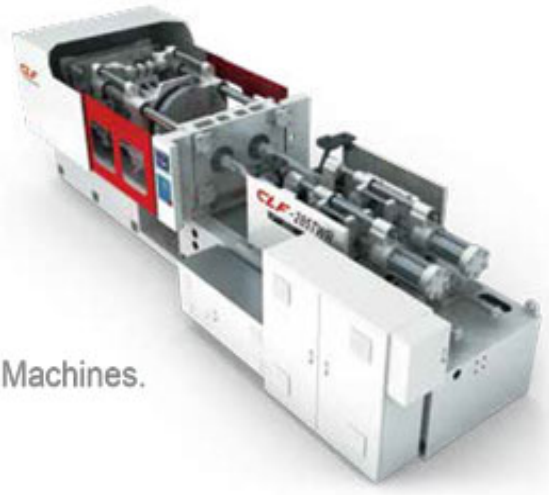
CLF

TWR/TXIIR
SERIES

Ratary Table / Separated Injection Multi-color
Plastic Injection Molding Machines.
Co-injection Multi-color Plastic Injection Molding Machines.



TWR SERIES

Ratary Table / Separated Injection Multi-color
Plastic Injection Molding Machines.

1 Increase Design Variations
DESIGN FLEXIBILITY

2 Avoid Secondary Processing
REDUCE THE COSTS

3 Diversified Uses of Colors and Materials
EMBELLISH THE APPEARANCE

- **Increase The Flexibility Of Product Design :** Molding process can minimize the use of internal space simultaneously. In addition, it can have different applications to increase the flexibility and variations of product design.The button part is designed in a dual-material method, it can be completed simultaneously during molding, reducing the assembly processes and achieving waterproof effects.
- **Reducing Processes To Keep Costs Down:** Can be combined with two parts of different materials or colors at the same time, reducing the need for secondary processing
- **Embellish the Appearance:** With a variety of Colors and Materials, it can exquisitely enrich the core value and quality of the product.


CLF-500TWR

TWR SERIES

Ratary Table / Separated Injection Multi-color Plastic Injection Molding Machines.

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DESIGN FLEXIBILITY

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REDUCE THE COSTS

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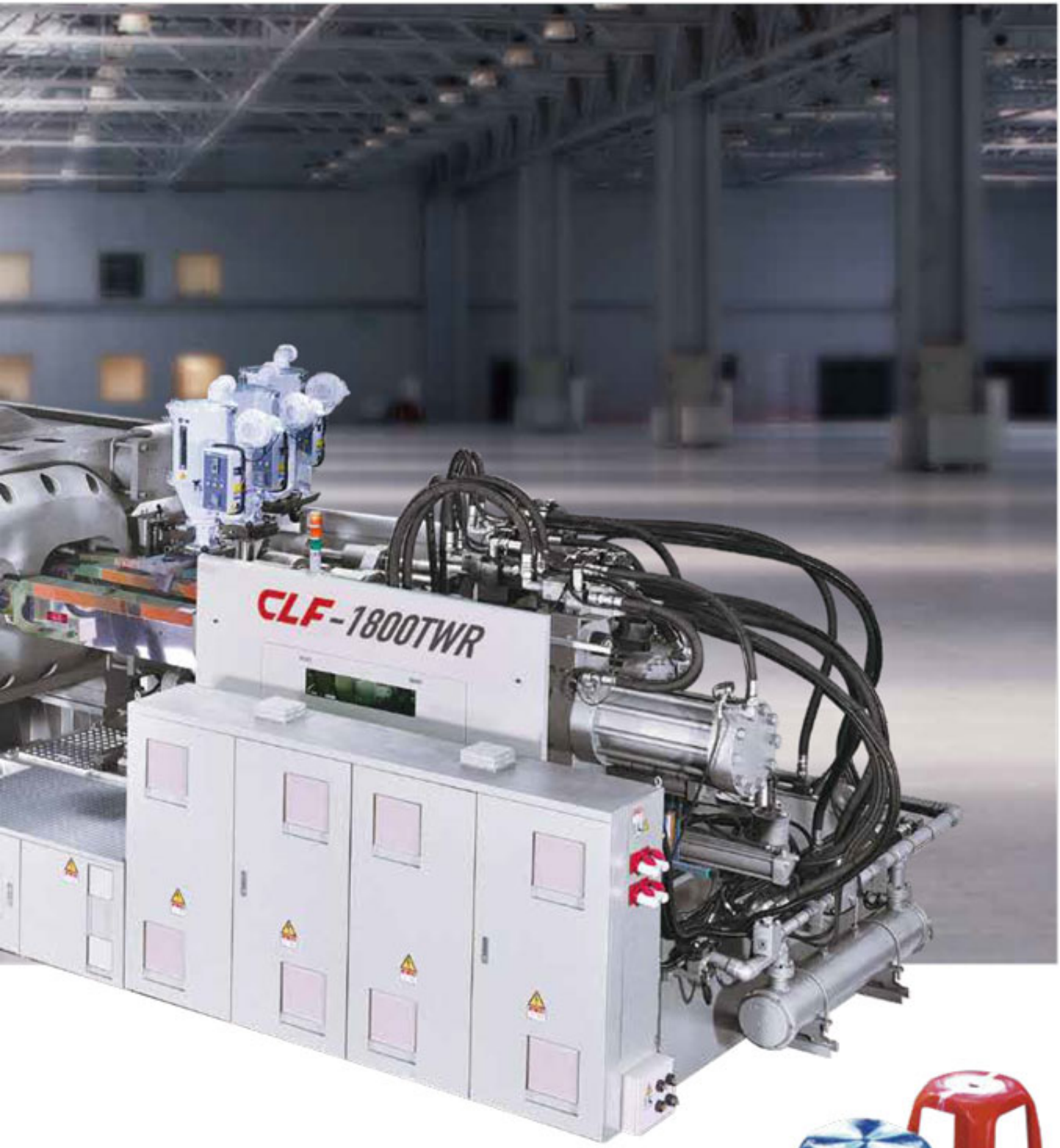
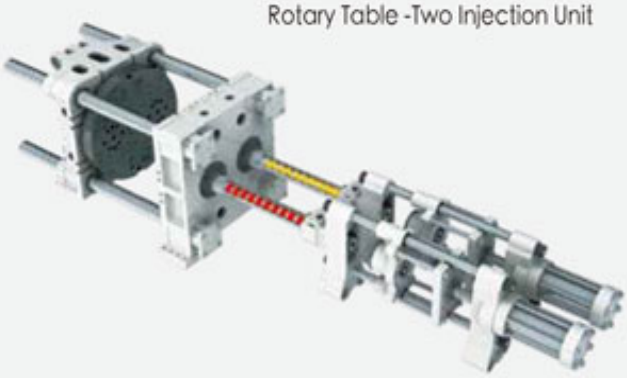

CLF-1800TWR

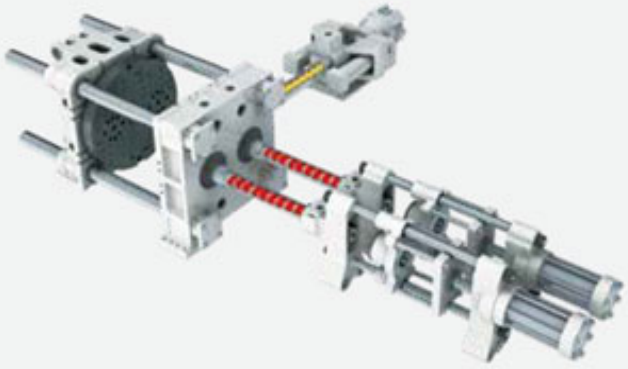
TWR / TXIIR Series

Rotary Table Multi-color

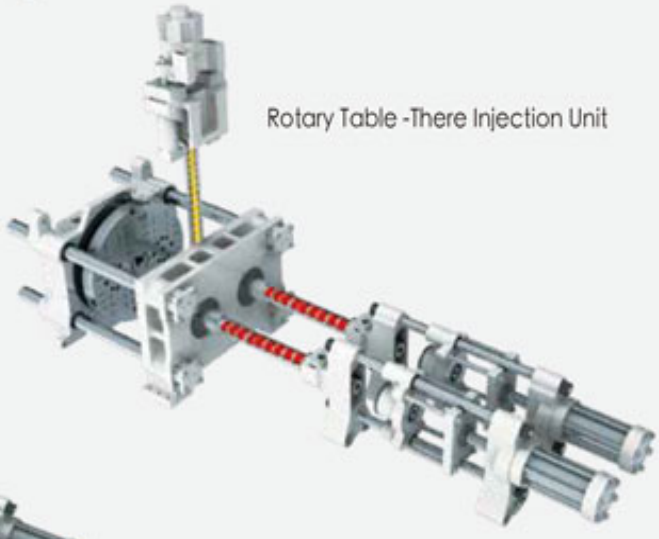
Rotary Table -Two Injection Unit



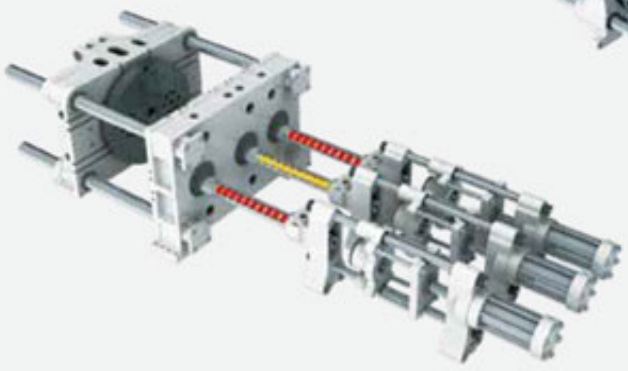
Rotary Table -There Injection Unit



Rotary Table -There Injection Unit

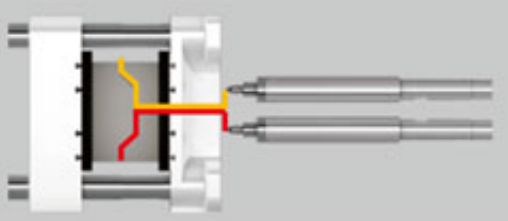


Rotary Table -There Injection Unit



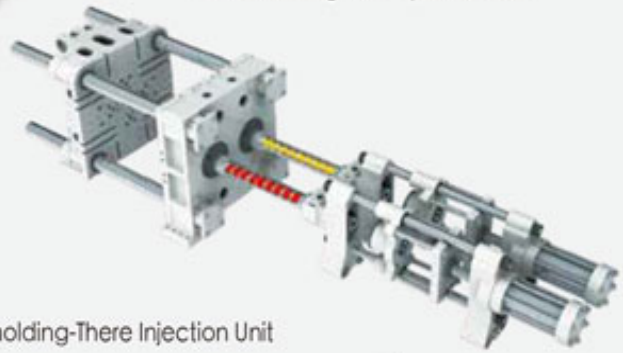
Overmolding

- Rotating Table for Movable Platen
- Rotating Holder for Product Transfer
- Two Separate Injection Units and Two-color Combination.

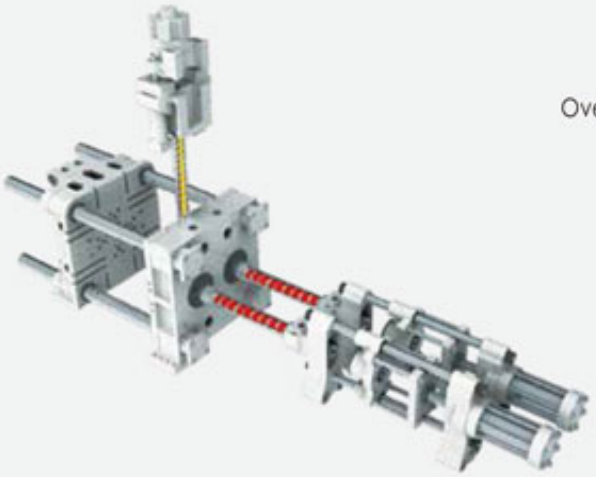


TWR / TXIIR Series
Separated Injection Multi-color

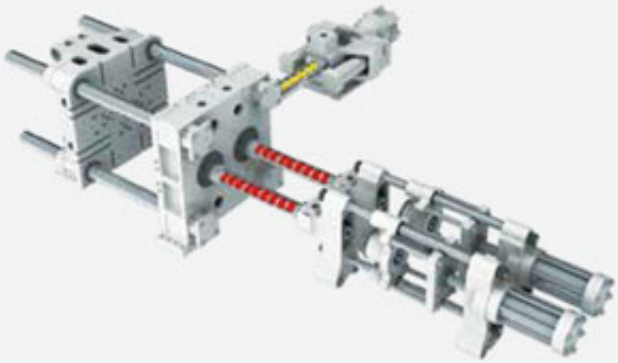
Overmolding-Two Injection Unit



Overmolding-Two Injection Unit

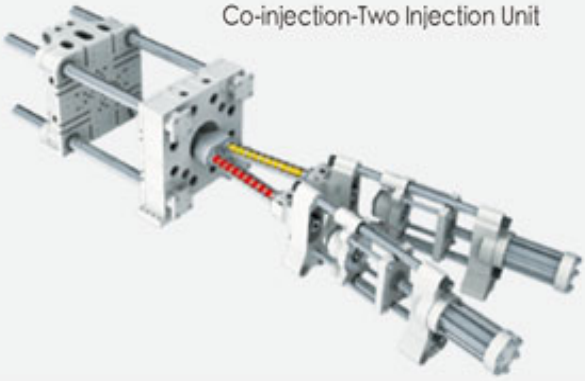


Overmolding-There Injection Unit

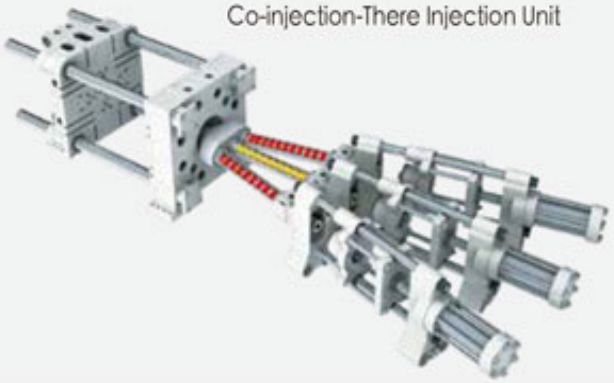


TWR / TXIIR Series
Co-injection Multi-color

Co-injection-Two Injection Unit

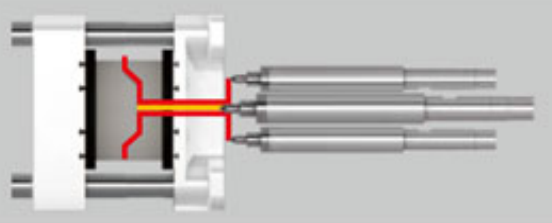


Co-injection-There Injection Unit

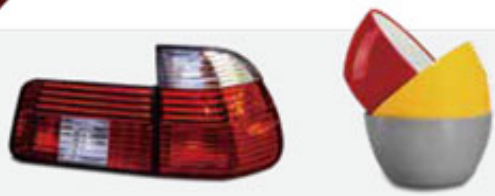


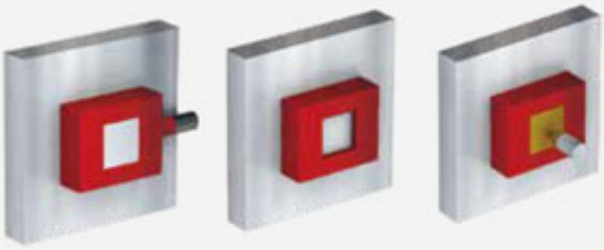
Co-injection

- Sandwich Injection Molding
- Marble Pattern Injection Molding
- Striped Product Injection Molding



TWR / TXIIR Series
Overmolding





BI-INJECTION MOLDING

- This injection molding technology employs two injection units. Both units shoot materials into the cavity through different ports, which produces a two-color effect.

SHAFT RETURN INJECTION MOLDING

- This injection molding technology is operated together with the core function. When the first injection is finished, the mold core returns to leave a space. Then the second injection performs to produce products with multi-color and multi-material effect.

ROTARY-TABLE INJECTION MOLDING

- This injection molding technology employs multiple same male molds and different female molds. The rotary table rotates male molds combined with multi-injection to produce multi-color and multi-material products.

ROTARY HOLDER INJECTION MOLDING

- This injection molding technology employs different male and female molds.The rotating shaft rotates the product holder to move the product. Such multiple injections produce products with special multi-color and multi-material effect.

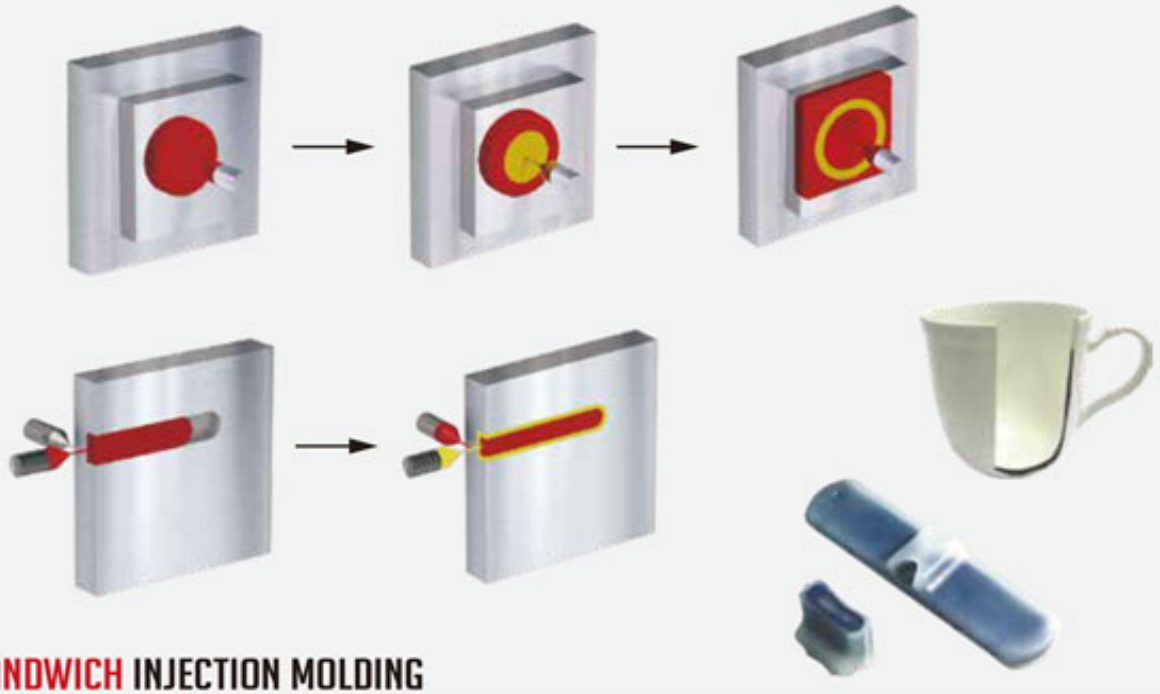
TWR / TXIIR Series
Co-Injection

MARBLE PATTERN INJECTION MOLDING

- This injection molding technology employs two injection units combined with a specially designed Mix injection nozzle. The first and second injection unit performs alternative multi-function controlled by time and position. This produces marble patterns with special multi-color effect.

STRIPED PRODUCT INJECTION MOLDING

- This injection molding technology employs two injection units combined with a specially designed co-injection nozzle. The first and second injection unit performs alternative multi-injection. This produces a stripe pattern on the product.

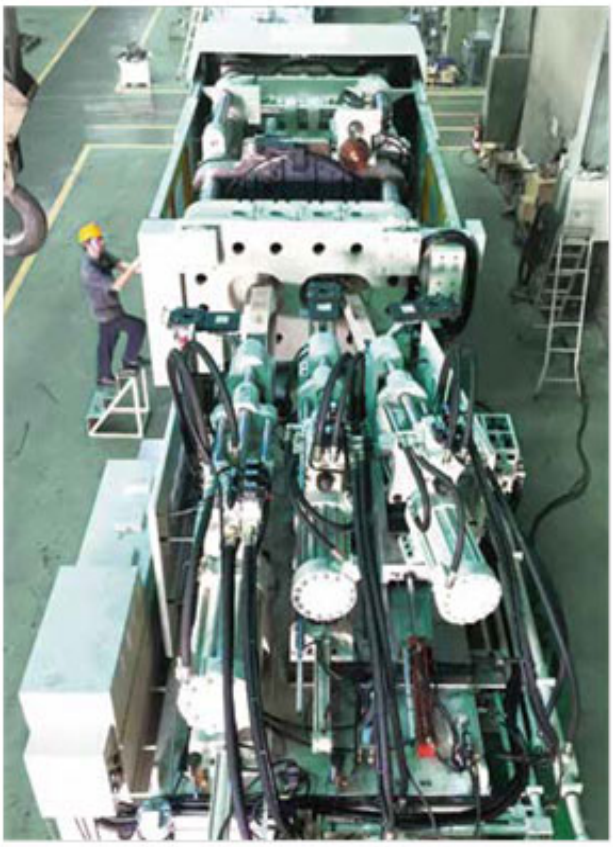


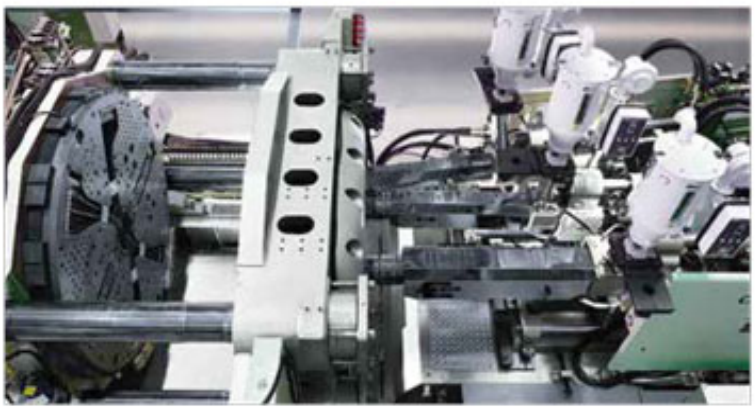
SANDWICH INJECTION MOLDING

- The sandwich injection molding is a multi-layer injection molding. This injection molding technology employs two injection units combined with specially designed sandwich injection nozzle. The injection system shoots surface and core materials to achieve special layers of products. The applicable core materials include recycled foam material or special-function resins.

TECHNOLOGICAL LEADERSHIP QUALITY PRIORITY

CLF Pursues Excellence & Everlasting Innovation





TECHNOLOGICAL LEADERSHIP QUALITY PRIORITY

CLF Pursues Excellence & Everlasting Innovation

CLF PLASTIC INJECTION MOLDING MACHINES, YOUR NO. 1 CHOICE FOR ANY INJECTION MOLDING APPLICATION

All critical parts of CLF machines such as mold platen are all machined in-house by Japanese-made and domestic high precision machine tools, such as Japan Toshiba floor type jig boring machines and Japan Kotobuki double column machining center. In addition, the hole accuracy of tie bar is also controlled in house to ensure the best running efficiency and product accuracy.


TOSHIBA
MACHINE

MACHINE MODEL		CLF-180TXIIR				CLF-230TXIIR				CLF-300TXIIR				CLF-420TXIIR			
International code		1800H205/205				2300H205/205				3000H500/500				4200H1345/1345			
INJECTION UNIT	Unit	1st. Inj. Unit		2nd. Inj. Unit		1st. Inj. Unit		2nd. Inj. Unit		1st. Inj. Unit		2nd. Inj. Unit		1st. Inj. Unit		2nd. Inj. Unit	
Screw diameter	mm	26	28	30	32	26	28	30	32	30	35	40	45	45	50	55	60
Theoretical injection volume	cm^3	74	86	99	113	74	86	99	113	141	192	251	318	477	589	713	848
Injection pressure	kg/cm^2	2817	2429	2116	1860	2817	2429	2116	1860	3750	2755	2110	1667	2880	2333	1928	1620
Injection rate	cm^3/sec	62	72	83	94	62	72	83	94	76	103	134	170	157	194	235	280
Shot weight (ps)	gram	68	78	90	102	68	78	90	102	128	175	229	289	434	536	649	772
Plasticization rate (PS)	kg/hr	18	23	30	34	18	23	30	34	34	46	67	100	69	90	109	129
Screw rotation	rpm	207				207				236				162			
No. of heating zones	zone	4				4				5				6			
Heating capacity	kw	3.4				3.4				7.9				15.1			
CLAMPING UNIT																	
Distance between tie bars	mm	740 × 400				900 × 480				960 × 540				1110 × 610			
Mold platen sizes	mm	900 × 620				1080 × 725				1160 × 820				1350 × 940			
Rotary tabe diameter	mm	780/810				950/980				1030/1060				1180/1220			
Mold opening stroke	mm	400				450				500				550			
Mold thickness	mm	120 - 550				150 - 600				200 - 650				200 - 700			
Dia. opening ring	mm	400				450				500				600			
Clamping force	ton [kn]	180				230				300				420			
Positioning ring diameter	mm	100				100				100				125			
Ejector stroke	mm	130				150				150				200			
GENERAL DATA																	
Pump driving motor	kw	22				22				37				60			
Oil tank capacity	liter	310				310				500				800			
Machine size(L x W x H)	m	5.6 × 1.65 × 1.7				6.5 × 1.8 × 1.9				7 × 2 × 2				7.5 × 2.2 × 2.1			
Net weight	ton	7.5				11				15				20.5			

MACHINE MODEL		CLF-500TWR						CLF-650TWR						CLF-1200TWR						CLF-1800TWR					
International code		5000H1470 / 1470						8500H1470 / 1470						12000H2436 / 2436						18000H4183 / 4183					
INJECTION UNIT	Unit	1st. Inj. Unit			2nd. Inj. Unit			1st. Inj. Unit			2nd. Inj. Unit			1st. Inj. Unit			2nd. Inj. Unit			1st. Inj. Unit			2nd. Inj. Unit		
Screw diameter	mm	50	55	60	50	55	60	50	55	60	50	55	60	65	70	75	65	70	75	75	80	85	75	80	85
Theoretical injection volume	cm^3	589	713	848	589	713	848	589	713	848	589	713	848	1095	1270	1458	1095	1270	1458	1878	2136	2412	1878	2136	2412
Injection pressure	kg/cm^2	2469	2040	1715	2469	2040	1715	2469	2040	1715	2469	2040	1715	2415	2082	1814	2415	2082	1814	2240	1968	1743	2240	1968	1743
Injection rate	cm^3/sec	187	226	269	187	226	269	187	226	269	187	226	269	319	369	424	319	369	424	411	467	528	411	467	528
Shot weight (ps)	gram	536	649	772	536	649	772	536	649	772	536	649	772	996	1156	1327	996	1156	1327	1709	1944	2195	1709	1944	2195
Screw rotation	rpm	199						199						224						165					
No. of heating zones	zone	6						6						8						8					
Heating capacity	kw	16.3						16.3						21.6						30					
CLAMPING UNIT																									
Distance between tie bars	mm	1250 × 600						1520 × 720						1720 × 820						2100 × 1000					
Mold platen sizes	mm	1600 × 1050						2040 × 1240						2260 × 1460						2350 × 1670					
Rotary table diameter	mm	1300						1550						1750						2120					
Center Distance of Injection Nozzle	mm	650						700						800						1000					
Mold thickness	mm	300 - 900						350 - 1100						400 - 1300						500 - 1400					
Mold opening stroke	mm	1000						1100						1300						1670					
Clamping force	ton [kn]	500 [5000]						850 [8500]						1200 [12000]						1600 [16000]					
Positioning ring diameter	mm	125						160						160						160					
Ejector stroke	mm	190						300						300						300					
GENERAL DATA																									
Pump driving motor	kw	75						75						150						200					
Oil tank capacity	liter	1250						1250						2000						2200					
Machine size (L x W x H)	m	9.2 × 2.5 × 2.2						9.7 × 2.7 × 2.4						13.2 × 3.2 × 2.9						15.2 × 3.7 × 3.3					
Net weight	ton	40						55						85						120					

*All specification, dimensions and design characteristics shown in this catalogue are subject to change without notice.

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TWR/TXIIR SERIES

Ratary Table / Separated Injection Multi-color Plastic Injection Molding Machines.
Co-injection Multi-color Plastic Injection Molding Machines.

DESIGNED BY POLARIS 2020.08 / 1000PCS +886-4-24517070

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