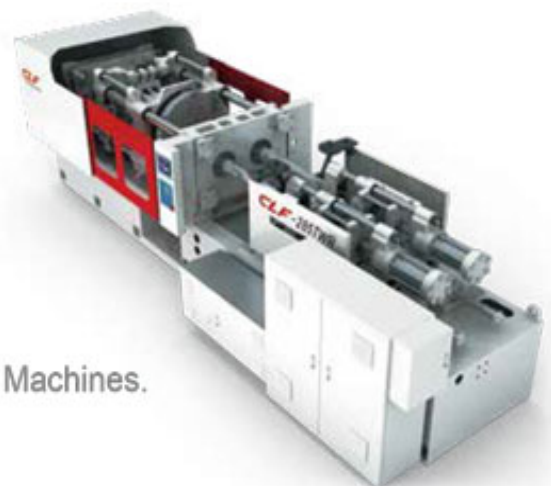


**CLF**



# TWR/TXIIR SERIES

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



## TWR/TXIIIR Series

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# TWR SERIES

Rotary 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.



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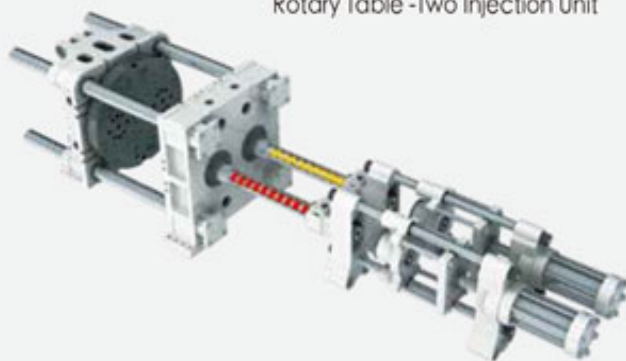
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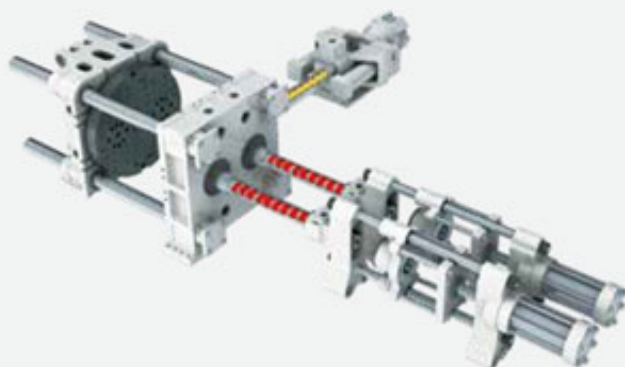
# TWR / TXIIR Series

Rotary Table Multi-color

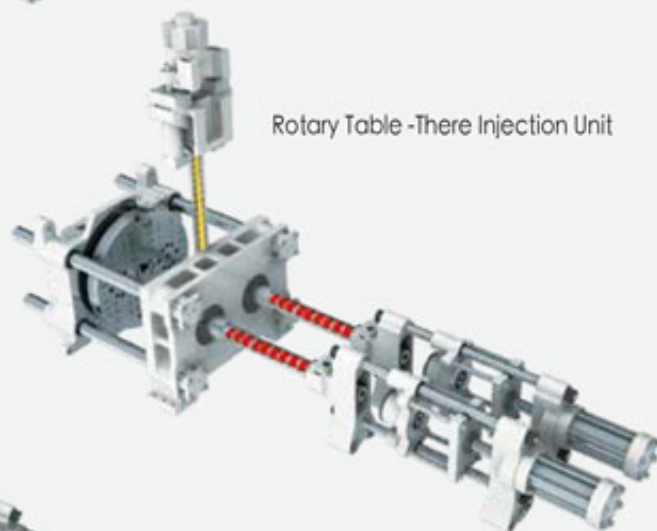
Rotary Table -Two Injection Unit



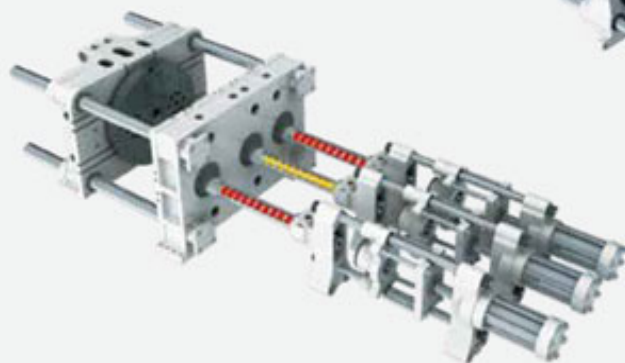
Rotary Table -Three Injection Unit



Rotary Table -Three Injection Unit

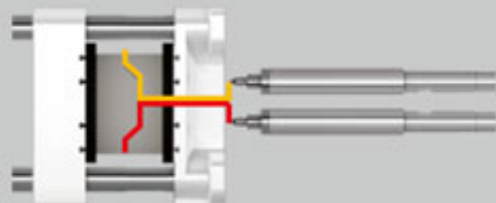


Rotary Table -Three Injection Unit



## Overmolding

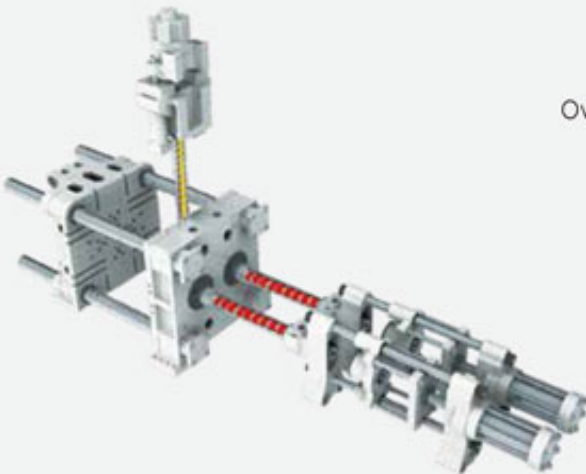
- Rotating Table for Movable Platen
- Rotating Holder for Product Transfer
- Two Separate Injection Units and Two-color Combination.



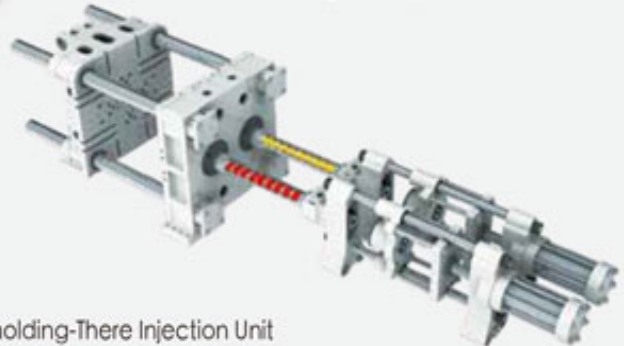
## TWR / TXIIR Series

### Separated Injection Multi-color

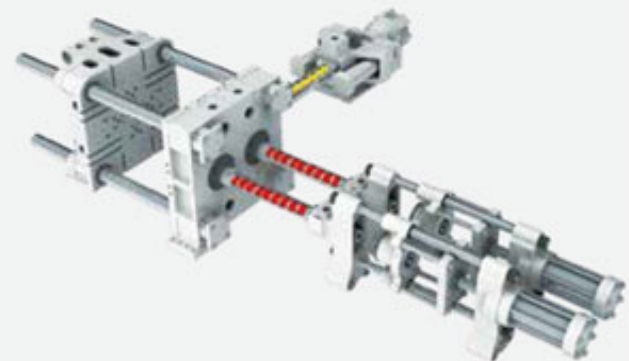
Overmolding-Two Injection Unit



Overmolding-Two Injection Unit



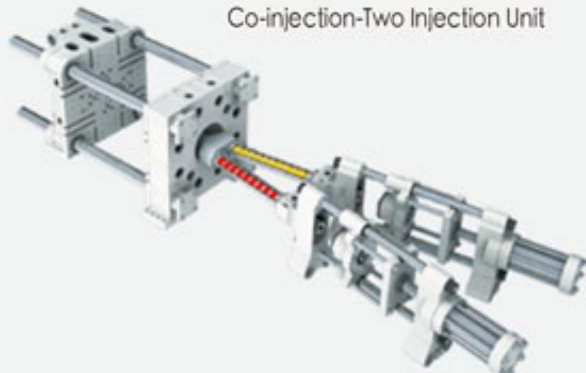
Overmolding-Three Injection Unit



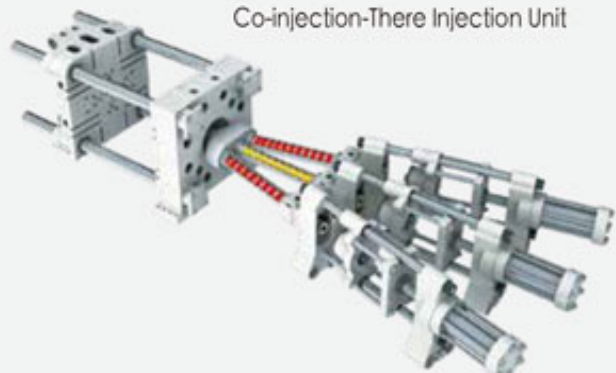
## TWR / TXIIR Series

### Co-injection Multi-color

Co-injection-Two Injection Unit

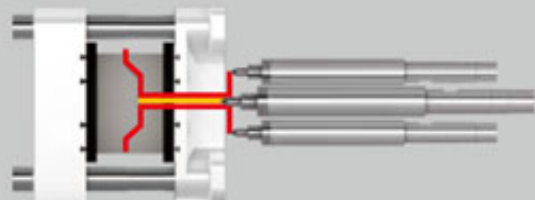


Co-injection-Three Injection Unit



### Co-injection

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



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# 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.



### 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.



### 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 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



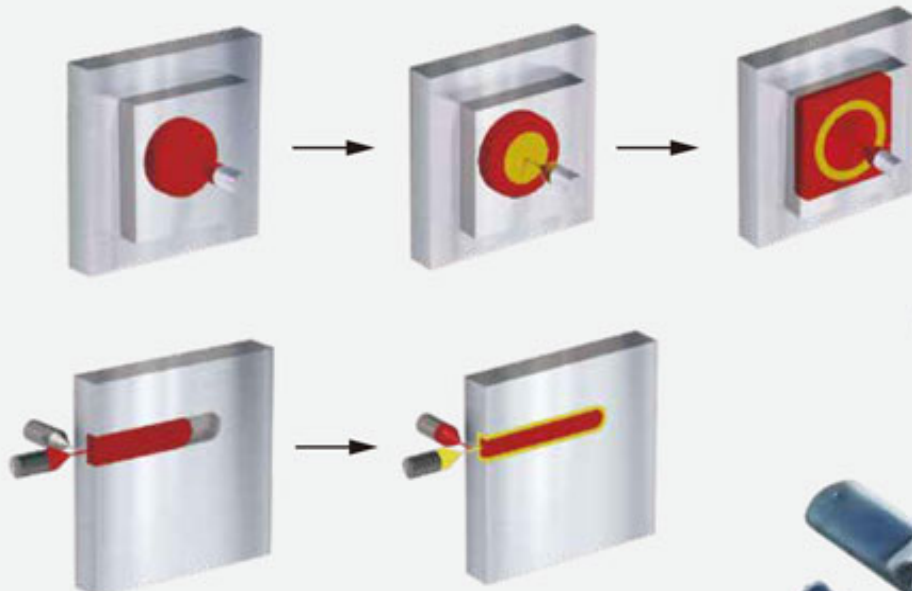
### MARBLE PATTERN INJECTION MOLDING

- 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

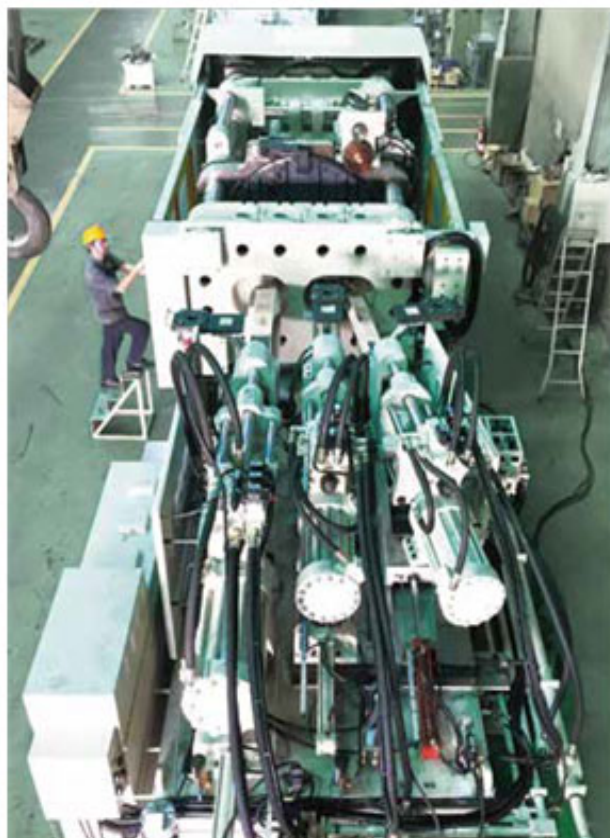
- The sandwich injection molding is a multi-layer injection molding. This injection molding technology employs two injection units combined with specially designed sandwich injection nozzle. The injection system shoots surface and core materials to achieve special layers of products. The applicable core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

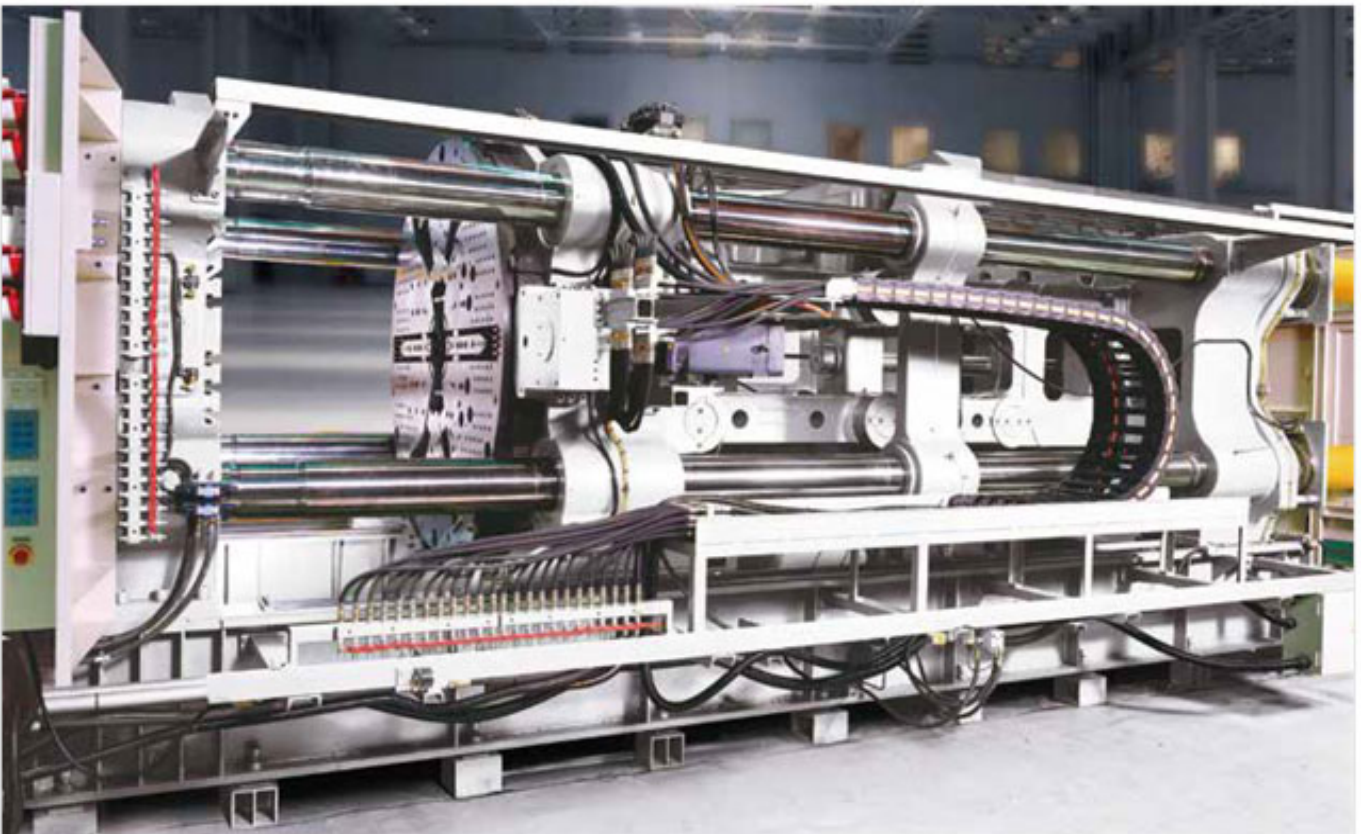
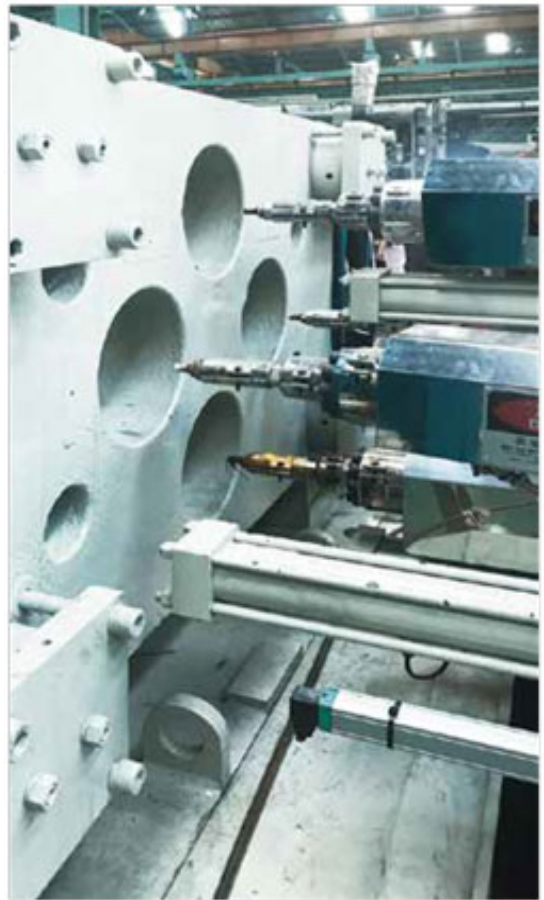
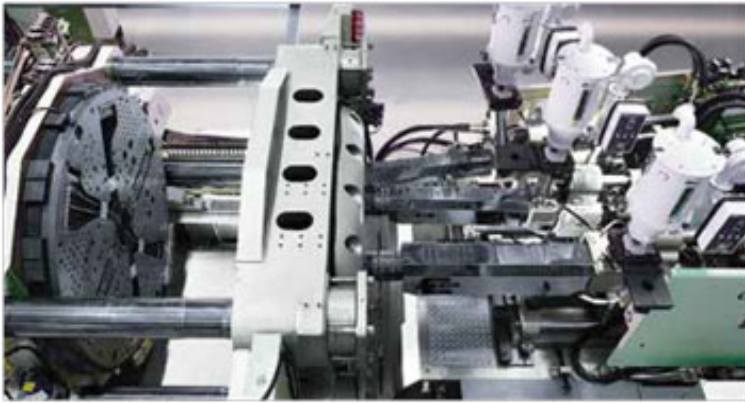
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# TECHNOLOGICAL LEADERSHIP QUALITY PRIORITY

CLF Pursues Excellence & Everlasting Innovation





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## 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.





| MACHINE MODEL                |                      | CLF-180TXIR      |      |                |      | CLF-230TXIR     |      |                |      | CLF-300TXIR    |      |                |      | CLF-420TXIR     |      |                |      |
|------------------------------|----------------------|------------------|------|----------------|------|-----------------|------|----------------|------|----------------|------|----------------|------|-----------------|------|----------------|------|
| International code           |                      | 1800H/205/205    |      |                |      | 2300H/205/205   |      |                |      | 3000H/500/500  |      |                |      | 4200H/1345/1345 |      |                |      |
| INJECTION 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 <sup>3</sup>      | 74               | 86   | 99             | 113  | 74              | 86   | 99             | 113  | 141            | 192  | 251            | 318  | 477             | 589  | 713            | 848  |
| Injection pressure           | kg/cm <sup>2</sup>   | 2817             | 2429 | 2116           | 1860 | 2817            | 2429 | 2116           | 1860 | 3750           | 2755 | 2110           | 1667 | 2880            | 2333 | 1928           | 1620 |
| Injection rate               | cm <sup>3</sup> /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             |      |                |      | 238            |      |                |      | 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 table 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                  |                      | 5000H-1470 / 1470 |      |                |      |                |      | 8500H-1470 / 1470 |      |                |      |                |      | 12000H-2436 / 2436 |      |                |      |                |      | 18000H-4183 / 4183 |      |                |      |                |      |
| INJECTION 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 |      | 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 <sup>3</sup>      | 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 <sup>2</sup>   | 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 <sup>3</sup> /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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DESIGNED BY POLARIS 2020.08 / 1000PCS +886-4-24517070

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