



Leshan 乐善

Blow Molding Machine

B_{ig}

Accumulator & Single station series



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B SERIES

Accumulator & Single station series



Suitable for producing chemical barrel, Pesticides bucket, fuel tank, water tank, etc. .



The whole machine frame is welded with steel parts, durable and non deforming.



Various functions, simple operation



Delicate processing of the die head by use of imported machining centers from Japan, die head can be moved forward and backward



B SERIES

Accumulator & Single station series



Equipped with platform lifting function, can adapt to different mold height and different blow molding process requirements.



The hydraulic system uses a proportional technology, optimized design of hydraulic circuit, with features of electricity-saving, fast-auctioning, easy - operating



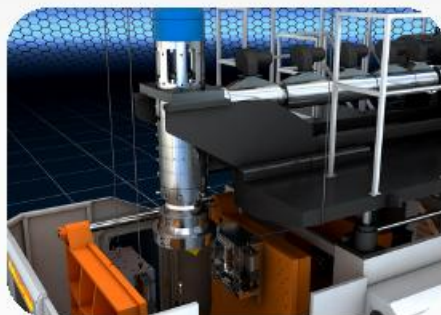
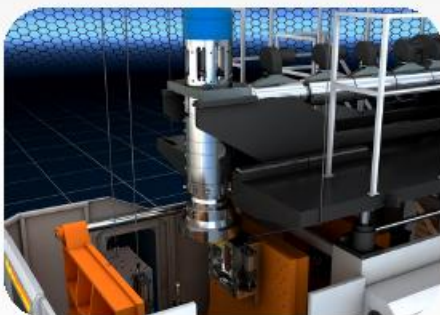
Use well-known pneumatic, hydraulic, electrical control components, long service life and stable performance.



Double proportional valve control oil flow rate and pressure: direction valve to control flow, deceleration valve to stop movement, every movement is fluent and fast. Automatic lubrication system to reduce workload of equipment maintenance.

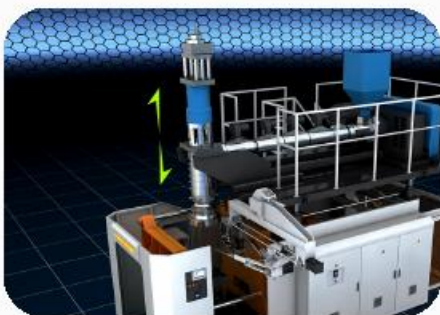
Equipped with slide system

Equipped with slide system, which provides easier mould installation and alignment for the head and the mould center.



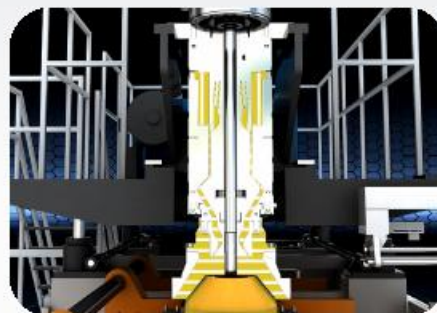
Equipped with automatic lifting platform system

Complied with transmission principle of Gear Motor and Lift Acceleration Machine, the whole platform can elevate with die head and extrusion system, so it can adapt to different mold height and different blow molding process requirements.



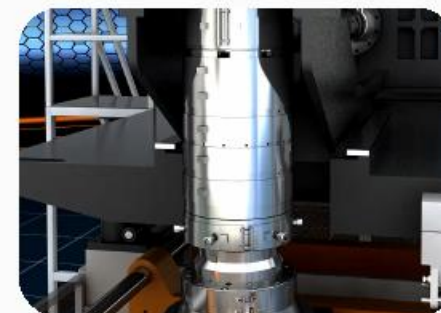
Double envelope, uniform parison

Accumulator die head with double envelope, fast extrusion, not reverse flow, the parison is more uniform.



The die head made of hard and wear-resistant material

Rubber piston to press the material from the accumulator die head, and the accumulator cavity adopts the special hard abrasion resistant material.



1.Up blowing or down bowing

Blowing pin can signed to be up blowing ,down blowing ,
inject-blowing from side, blowing with a thread

2.Parison widening function

Equipped with Down widening functions which will stretch the
parison to two sides, and the barrel will be more plump.

3.Parison pre-clip function

For large diameter parison, the machine is equipped with a
parison pre-clip function to binding the parison, so that the
blowing function can work sufficiently.

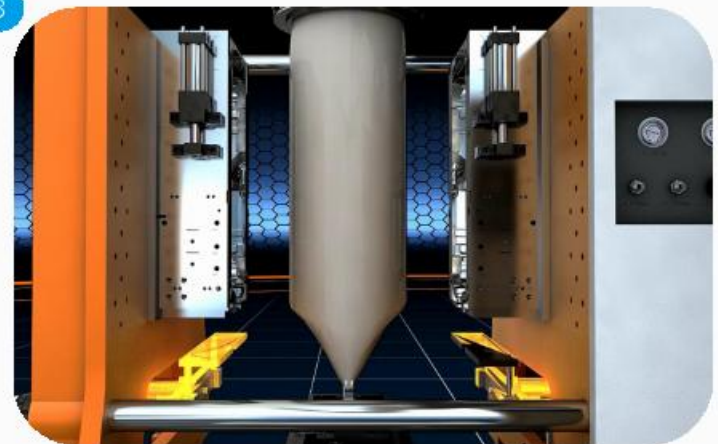
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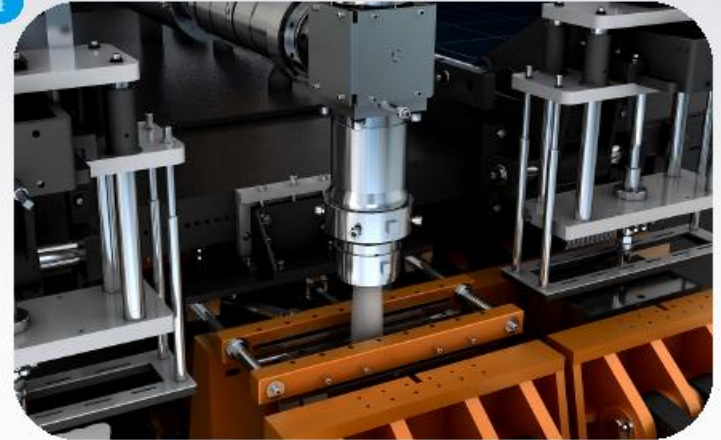
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4.Pre- seal cutter device

Pre- seal cutter will guarantee that the parison has same length of each cycle, it could avoid the waste resulted from long parison and prevent failure blow molding.

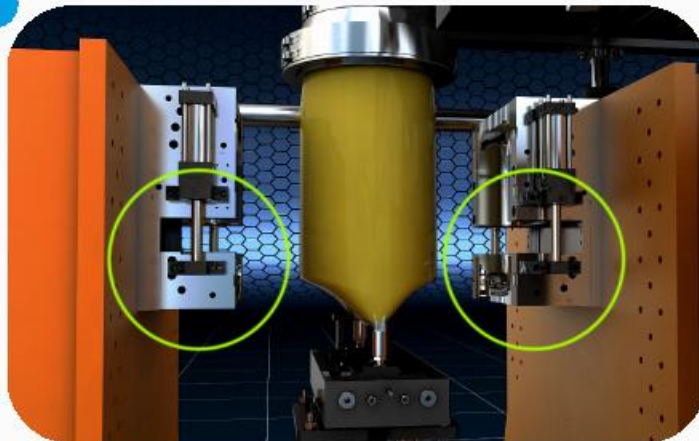
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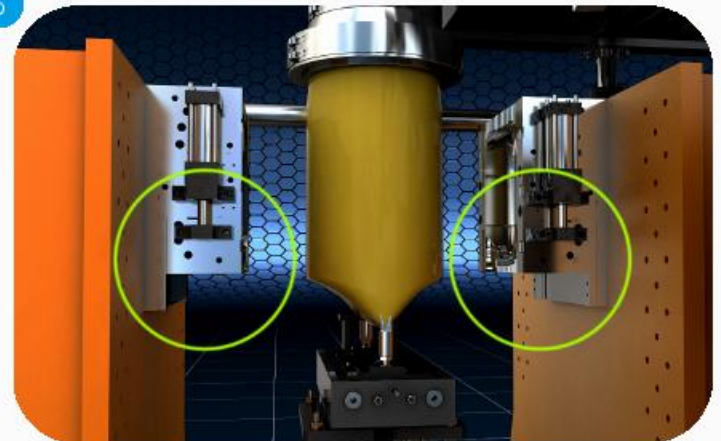
5.Mould stretch functions

To avoid the scratch to the middle sunken part during mould opening

5



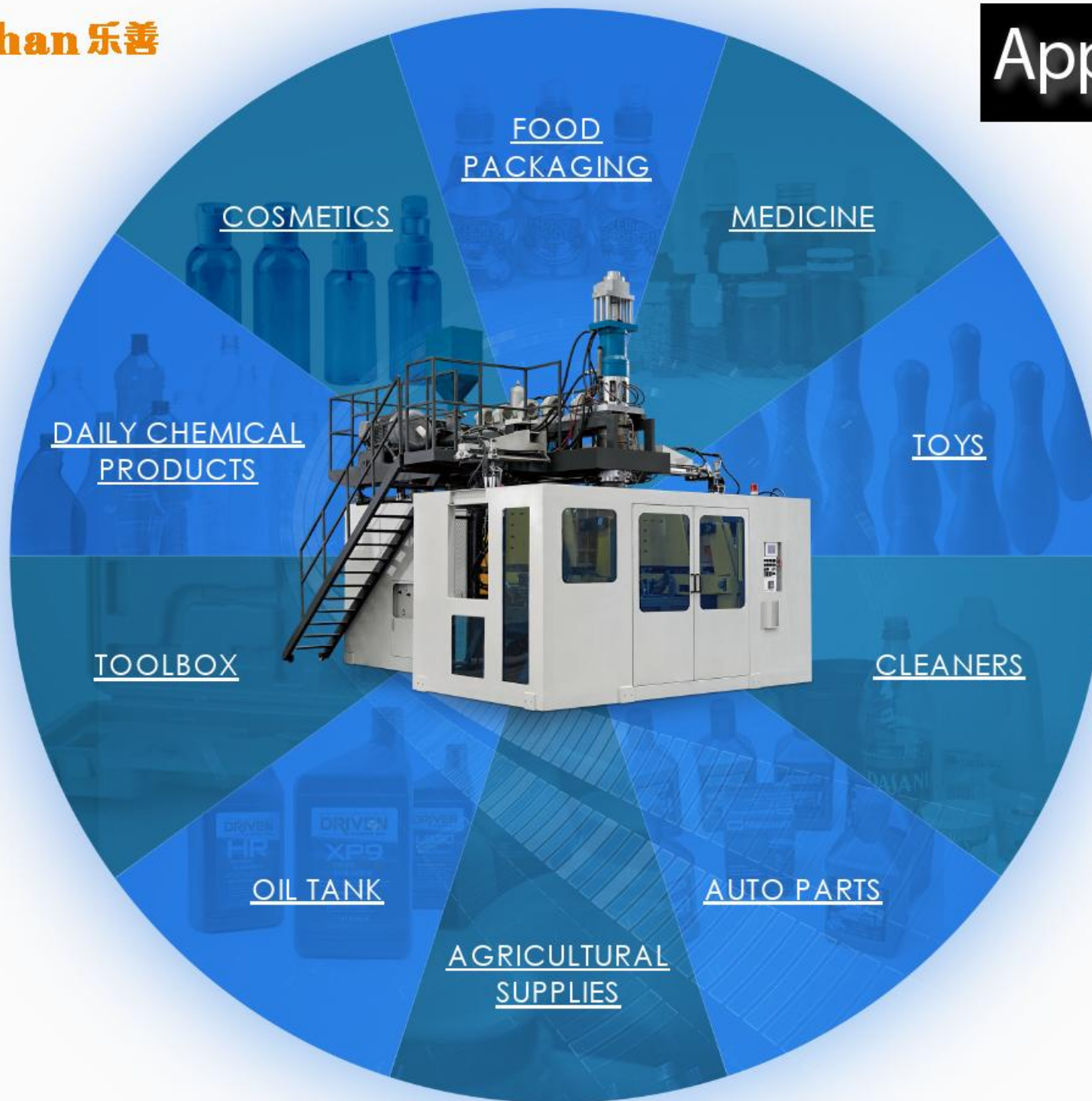
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Item	Unit	Accumulator & single station series	
Model		SCJ-85Y+H1X1.25D	SCJ-90Y+H1X1.30D
Specification			
Category		Single Layer	Single Layer
Max Volume	L	25	30
Die Head No.		1	1
Net Weight	kg	6000	9250
Machine Dimension	m.LxWxH	3.4x1.8x3	4.9x2.83x3.5
Clamping Unit			
Min Clamping Distance Of Mould	mm	500	450
Clamping Stroke	mm	400	450
Extruder Diameter	kN	400	450
Extruder Unit			
Extruder Diameter	mm	85	90
Extruder Motor Power	kW	30	37
Max Extrusion Capacity	kg/h	130	160
Power Unit			
Total Power	kW	76	85.5

Item	Unit	Accumulator & single station series	
Model		SCJ-90Y+H1+S1X1.60D	SCJ-100Y+H1+S1X1.60D
Specification			
Category		Single Layer	Single Layer
Max Volume	L	60	60
Die Head No.		1	1
Net Weight	kg	11500	11500
Machine Dimension	m.LxWxH	5.94X2.1X3.8	5.94X2.1X3.8
Clamping Unit			
Min Clamping Distance Of Mould	mm	450	450
Clamping Stroke	mm	550	450
Extruder Diameter	kN	360	450
Extruder Unit			
Extruder Diameter	mm	90	100
Extruder Motor Power	kW	37	75
Max Extrusion Capacity	kg/h	160	230
Power Unit			
Total Power	kW	98.5	149

Item	Unit	Accumulator & single station series	
Model		SCJ-90K+H2X1.30D	SCJ-100U+H2X1.30D
Specification			
Category		Single Layer	Single Layer
Max Volume	L	30	30
Die Head No.		1	1
Net Weight	kg	15000	20000
Machine Dimension	m.LxWxH	5X4.7X4	5.7X4X4.8
Clamping Unit			
Min Clamping Distance Of Mould	mm	450	450
Clamping Stroke	mm	500	500
Extruder Diameter	kN	170	200
Extruder Unit			
Extruder Diameter	mm	90	100
Extruder Motor Power	kW	37	75
Max Extrusion Capacity	kg/h	160	230
Power Unit			
Total Power	kW	89/(95)	145.5



Leshan Intelligent is chosen by a number of world-renowned enterprises, China top 500 enterprises, such as P&G, Mobil, Sinopec, Mengniu, Yili, Wahaha, Monarch etc..
Annual sales is up to 600 set of blow molding machine.



Mobil

ESSO



娃哈哈®

乐百氏®
ROBUST



统®
Monarch®

蒙牛®
MENSHU



海天

P&G

Due to confidentiality agreements, more customer information is not released.



From single machine to complete production unit,
from complete line to provide key project.

Leshan always treasure customer,
continuously providing improved product quality
and service to the customer.

+
Member

Leshan had focused on blow molding technology for 30 years. In our "turnkey project" team, there are veteran works who have over 20 years of experience in blow molding, engineers who have engaged in the design for EBM machine for 15 years, engineers who have design the factory for over 5 years, technician who have worked as an assembly fitter for over 10 years and professional with rich workshop management experience. There are also versatile talents who can work as an electrician, welder and fitter and technicians who are goo gar installation and commissioning g the EBM.



+ Service

Based on the principle of production technology and convenient logistics delivery, we divide the function of the workshop (new or modified) as raw material room, batching room, bottles blowing workshop, cap injection workshop, filling workshop and warehouse. Meanwhile, we design a package solution covering from raw material mixing ,raw material feeding and waste crushing and recycling, flash removing , and standing the bottle upside.



+ CONSTRUCTION

From selecting and inspecting the waterway, gas path parts, electrical parts, pipeline bridge part to drilling, welding, polishing, installation, cleaning, commissioning and testing finished products, every step is an independent contracting by LESHAN machine.



WORKING PROCESSING

1

Setting the output requirement of the bottle

Considering the breakdown maintenance of the EBM machine, molds and auxiliary machinery, LESHAN project center will set an safe coefficient to the contract.

The safe coefficient is related to the following factors:

1. the average NO-error operation time
2. accessibility of equipment maintenance
3. accessibility of spare parts
4. machine maintenance level
5. technical level of the maintenance personnel

2

Select blow molding machine

Leshan project center providing a variety of models of detailed data to clients, not just the screw diameter, extrusion and power.



WORKING PROCESSING

3

Equipped with auxiliary machinery, pipeline calculation

The process is divided into the following five parts

Cooling-water machine

Cold water machine selection, depends on the parison heating temperature to mold opening temperature, calculated to heat exchange. hydraulic system' s heat, reducer gearbox' s heat, barrel feeding mouth' s heat, the total servo cylinder' s heat.

Crusher

Main reference for selecting crusher: crushing ability, that is, how many per hour can be crushed, but select the ability for crushing, should be calculated accurately.

1. screen cloth hole diameter
2. The increase factor resulting from the intermittent operation of the crushing machine due to machine adjustment and other factors.

Feeding system

The trimming waste during production will be sent to crusher by conveyor belt automatically.
Weighting/proportioning/ mixing materials automatically, then send to each hopper of blow molding machine.
All closed pipeline way, preventing dust.
Industry PLC control, touch screen of human-computer interface.
Batching materials capacity: 1.5T/H
SUS304 stainless steel materials, more health and hygienic
Empty alarm functions

Air compressor, air accumulator

Accurate considering gas cooling, gas drying, gas filtration, oil removal, we place the air compressor and air accumulator in order.

Water pipe & gas pip

Comprehensive measure up the investment and usage costs in order to achieve the best economy. accurately calculate the best inner and outer diameter of the pipe.



WORKING PROCESSING

4

Design of workshop layout (core engineering)

All members in our project center are all elites of the industry. they all have abundant experience in mechanical workshop management and blow molding technology. They are familiar with the principle on mechanical layout and the best route of logistics operation. in the course of the design, we consider the operation of the machine. The maintenance space, fire control passageway, ventilation and lighting and staff access in and all- around way.

In the whole of China, LESHAN is the only one company who is able to plan the EBM production line so comprehensively.

5

An actuarial production lines operating costs

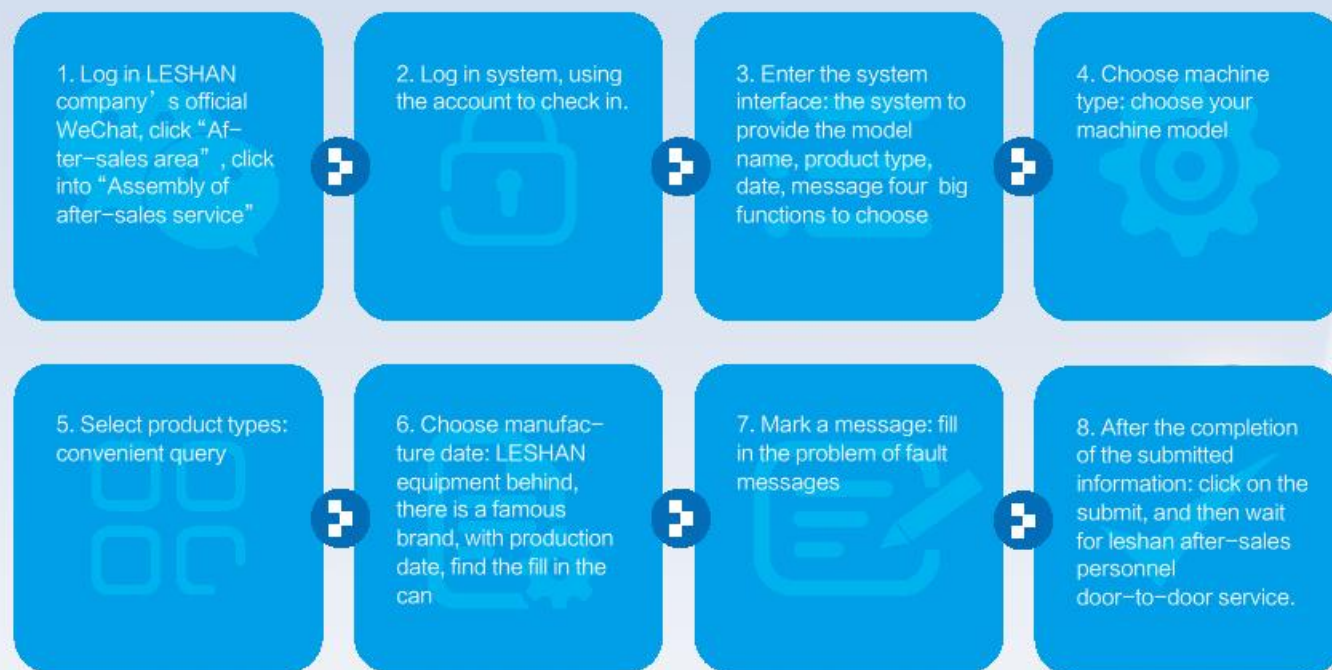
Our project center can accurately list the amount of investment for production lines and the production cost for in following one year for our customers



1. Wechat Assembly system

After-Sales personnel will provide solution within 2 hours after customer applying for after-sales service.

Assembly Processing



After-sales maintenance process



2.Spare part damage warning system

From ordering the machine, LESHAN will set up a file, setting spare parts damage warning system. When the spare parts almost reach a dead line, LEHSNA will contact and remind you to replace this part in advance, avoid causing unnecessary loss.

3.Install,commissioning and training

Leshan can send the after sales person abroad to install or commissioning the machine , and training the workers(charging items)



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