



Leshan 乐善

Blow Molding Machine



Linear Guide Rail



www.china-leshan.com

Tel: +86-757-2837 6168

Add: No. 1 Xinhui Road, Wusha, Daliang, Shunde District Foshan City, Guangdong Province, China.

U SERIES

I N T R O D U C T I O N



GENERAL FEATURES

1. Can work with PE,PP,EVA and so on.
2. SIEMENS HMI (TP770) Touch Screen and computer, the operation is convenient and fast.
3. The machine equipped with exclusive screw and die head, suitable for different requirements.
4. Permanent magnet brushless motor with independent research and development by Leshan, fast speed, low energy consumption.
5. optimized design of the hydraulic circuit, scissors toggle clamping system, clamping plate is central force , clamping force will be more strong and balance.
6. The machine equipped with platform lifting function, suitable for different height of mould and different blow molding process requirement.
7. The pneumatic system, hydraulic system and electrical control components use famous brands all over the world, the service life is long.



Key
highlights

+ Die head

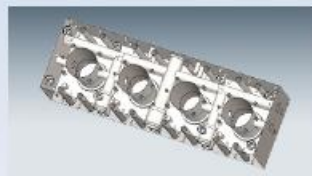
Set the thickness of the bottle
from Touch Screen

set the thickness curve numerical for
the bottle from Touch Screen, to get
a unique thickness of different point
through move up /down the
mandrel.



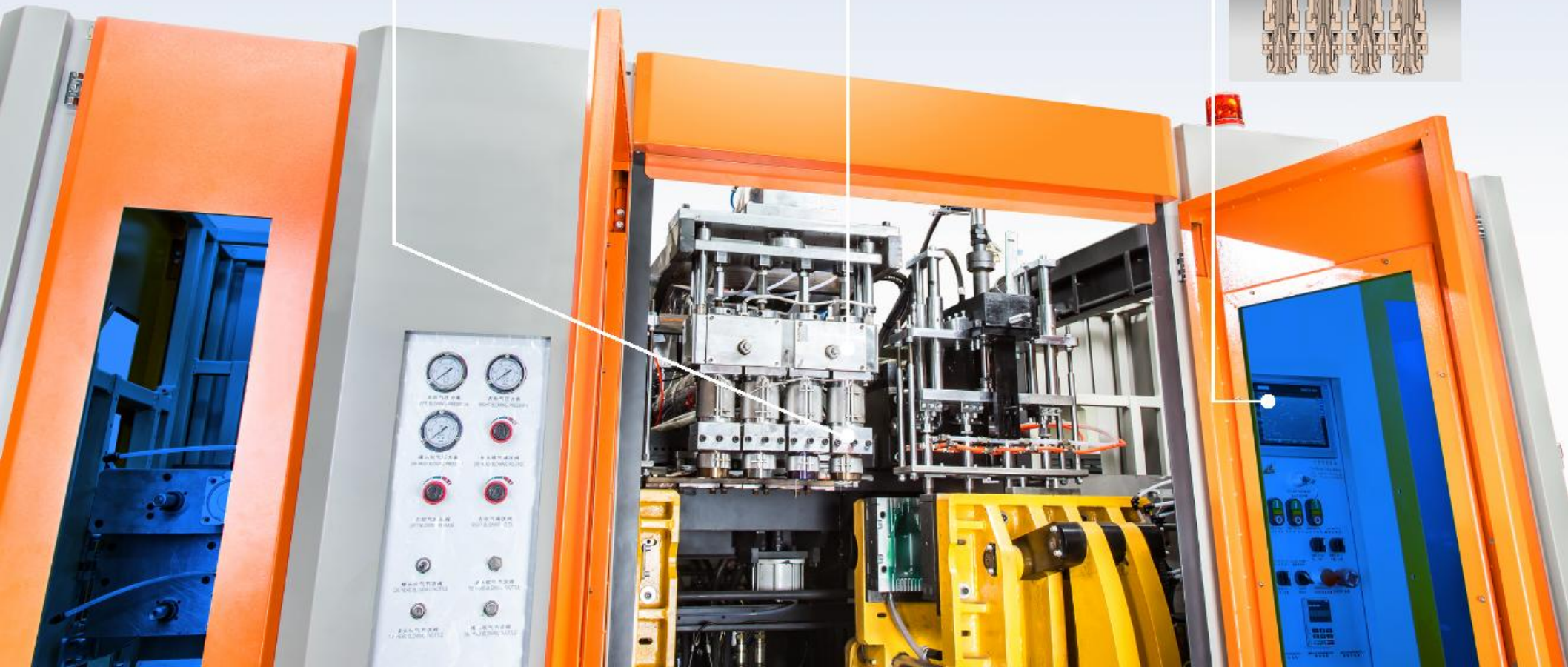
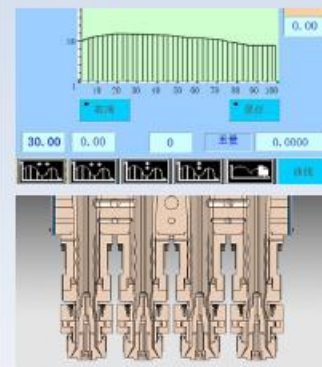
Debugging the length for multi-
ple-parison in balance.

Pairing every two parison into one
group, equipped with an adjusting
device which can control the length
for two parisons, there is an exclusive
adjusting device for every group to
control each parisons' flow speed.



Parisons come from multiple die
head is more vertical and balance.

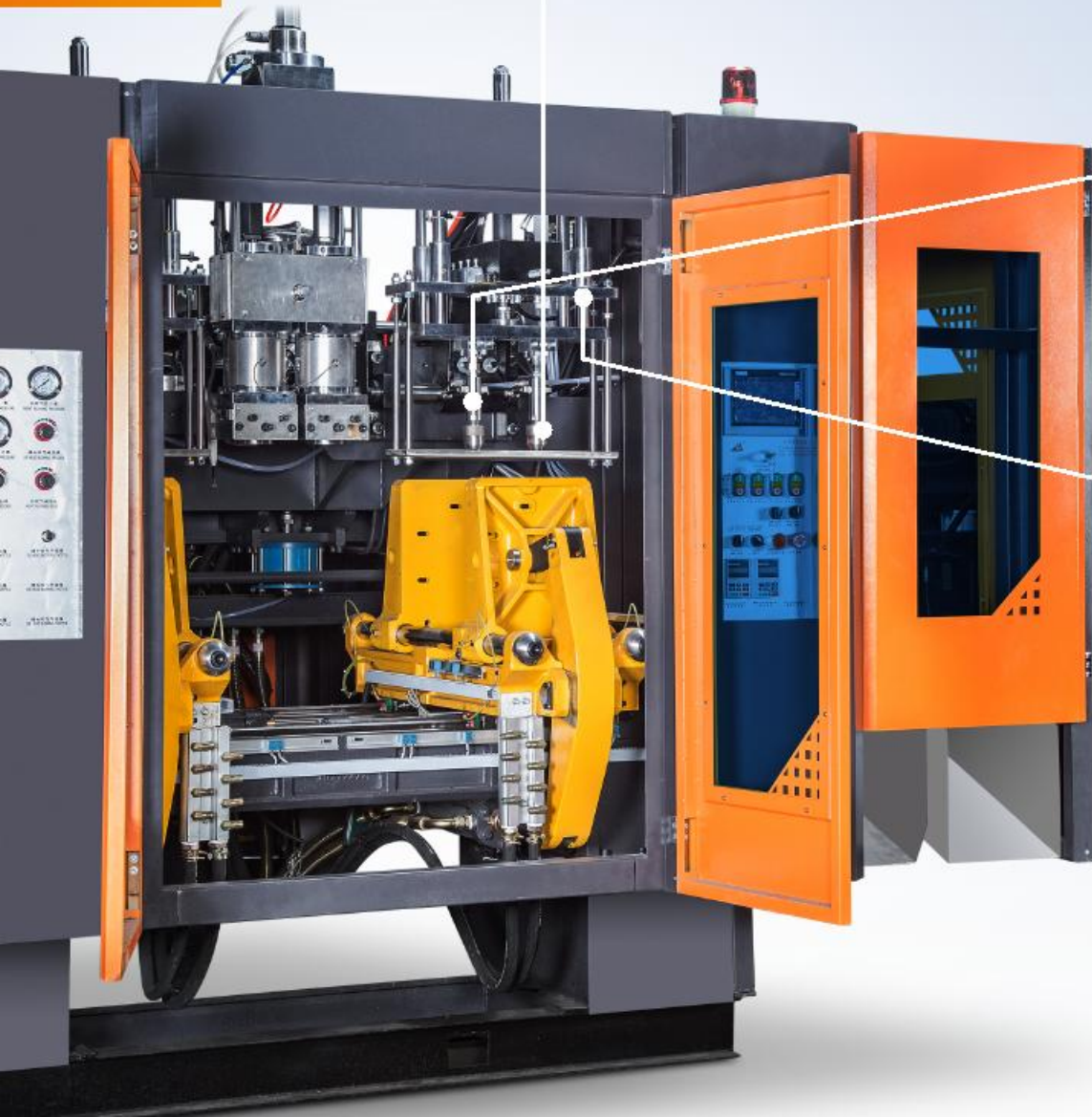
Adjusting screw for die tooling,
guarantee the parison even and no
bending



Leshan 乐善

Key
highlights

+
Blow pin



Improved the hardness for
cutting ring

The hardness for cutting ring is
5 degrees lower than the
hardness for mold insert.



Blow pin equipped with the
air circulation system.

Blow pin equipped with air valve,
air circulation can take away the
heat from the bottles, improve
the production efficiency by
shorten the cooling time.



Blow pin can move
left/right

Blow pin location is adjustable
according to the difference
bottles or difference bottle
distance.

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Key
highlights

+
Carriage

High precision linear guide rail

Surface hardening of Guide rail is of high frequency quenching, roughness less than 1.5S, low dynamic and static friction resistance, high repeat positioning accuracy, suitable for high frequency production.



Optional carriage stroke

The carriage stroke is 500-900, can adapt to different request.



Item	Unit	U Series (Linear Guide Rail)			
Model		SCJ-65U2x1.5F	SCJ-65U2x2.5F	SCJ-65U2x3.5F	SCJ-65U2x4.5F
Specification					
Category		Single Layer			
Max Volume	L	5	2	1.5	1
Die Head No.		1	2	3	4
Center Distance	mm	/	120,150	85,100	65/70/85/100
Net Weight	kg	8000			
Machine Dimension	m.LxWxH	3.8X3.6(2.15)X2.45			
Clamping Unit					
Min Clamping Distance Of Mould	mm	200			
Clamping Stroke	mm	250			
Extruder Diameter	kN	78			
Extruder Unit					
Extruder Diameter	mm	65			
Extruder Motor Power	kW	15			
Max Extrusion Capacity	kg/h	60			
Power Unit					
Total Power	kW	38.5	38.5	38.5	39

Item	Unit	U Series (Linear Guide Rail)					
Model		SCJ-65-45U2x1.5F		SCJ-65-45U2x2.5F		SCJ-65-45U2x4.5F	
Specification							
Category		Double Layer					
Max Volume	L	5		5		1	
Die Head No.		1		2		4	
Center Distance	mm	/		120,150		85, 100	
Net Weight	kg	8500					
Machine Dimension	m.LxWxH	3.8X3.6(2.15)X2.45					
Clamping Unit							
Min Clamping Distance Of Mould	mm	200					
Clamping Stroke	mm	250					
Extruder Diameter	kN	78					
Extruder Unit							
Extruder Diameter	mm	65	45	65	45	65	45
Extruder Motor Power	kW	15	5.5	15	5.5	15	5.5
Max Extrusion Capacity	kg/h	60	14	60	14	60	14
Power Unit							
Total Power	kW	49		49.5		49.5	

Item	Unit	U Series (Linear Guide Rail)							
Model		SCJ-65-25U2x1.5F		SCJ-65-45-25U2x1.5F			SCJ-65-45-25U+S2x2.5F		
Specification									
Category		Double Layer With View Stripe		Double Layer With View Stripe			Double Layer With View Stripe		
Max Volume	L	5		5			5		
Die Head No.		1		1			2		
Center Distance	mm	/		/			/		
Net Weight	kg	8500							
Machine Dimension	m.LxWxH	3.8X3.6(2.15)X2.45							
Clamping Unit									
Min Clamping Distance Of Mould	mm	200		200			200		
Clamping Stroke	mm	250		250			250		
Extruder Diameter	kN	80		80			78		
Extruder Unit									
Extruder Diameter	mm	65	25	65	45	25	65	45	25
Extruder Motor Power	kW	15	2.2	15	5.5	2.2	15	5.5	2.2
Max Extrusion Capacity	kg/h	60	2	60	14	2	60	14	2
Total Power	kW	42.2		53.8			61.2		

Item	Unit	U Series (Linear Guide Rail)		
Model		SCJ-75U2x1.10F	SCJ-65U2x2.5F	SCJ-75U2x4.10F
Specification				
Category		Single Layer		
Max Volume	L	10	5	2
Die Head No.		1	2	4
Center Distance	mm	/	120,200	85, 100
Net Weight	kg	9000		
Machine Dimension	m.LxWxH	4.34X3.15(2.2)X2.6		
Clamping Unit				
Min Clamping Distance Of Mould	mm	230		
Clamping Stroke	mm	350		
Extruder Diameter	kN	127		
Extruder Unit				
Extruder Diameter	mm	75		
Extruder Motor Power	kW	90/(105)		
Max Extrusion Capacity	kg/h	22/(30)		
Total Power	kW	58.5/(67.5)	59.5/(68.5)	58.5/(67.5)

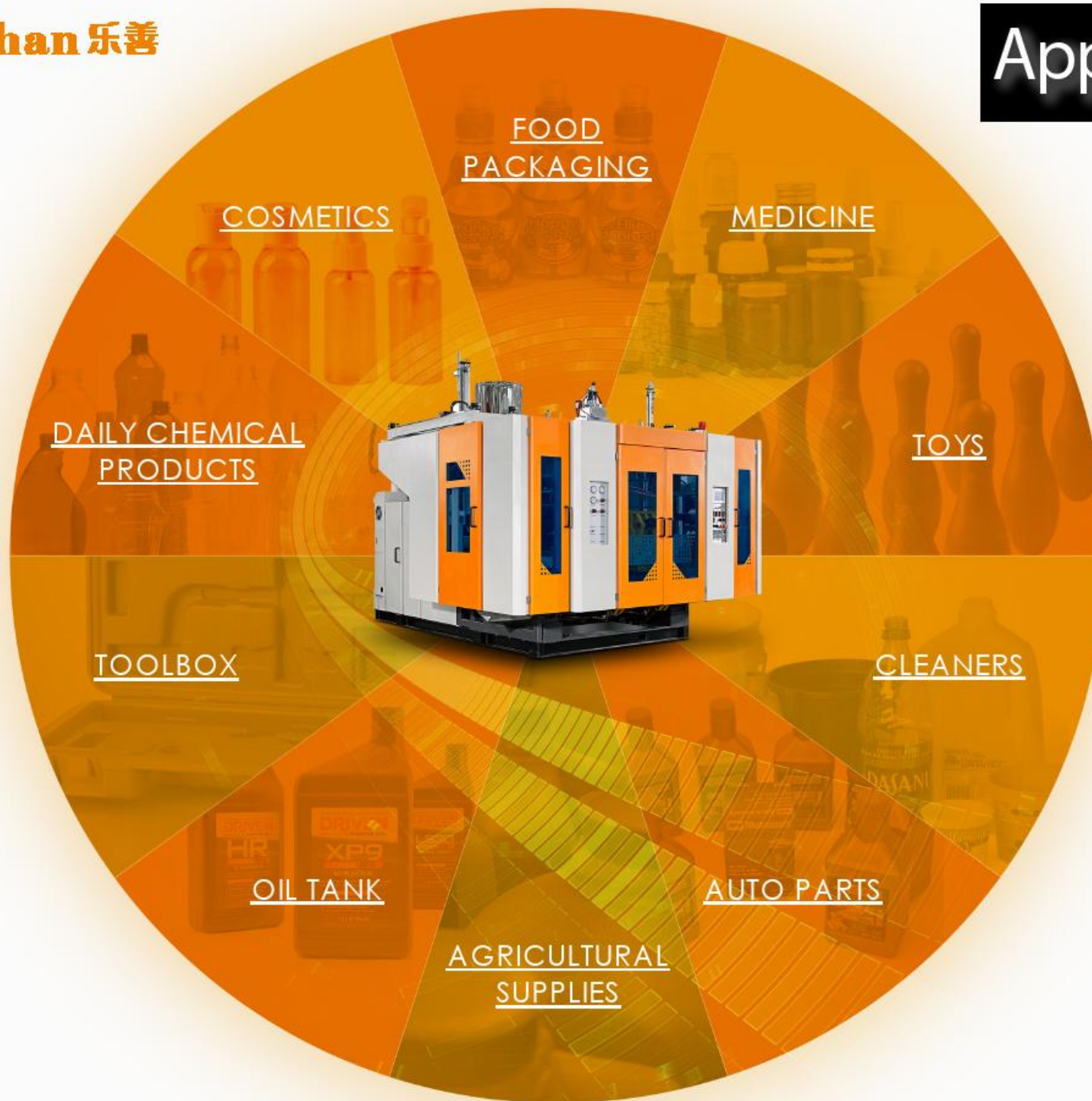
Item	Unit	U Series (Linear Guide Rail)					
Model		SCJ-75-55U2x1.10F		SCJ-75-55U2x2.10F		SCJ-65-45U2x4.5F	
Specification							
Category		Double Layer					
Max Volume	L	10		5		2	
Die Head No.		1		2		4	
Center Distance	mm	/		≤280		≤120	
Net Weight	kg	9500					
Machine Dimension	m.LxWxH	4.34X3.15(2.2)X2.6					
Clamping Unit							
Min Clamping Distance Of Mould	mm	230					
Clamping Stroke	mm	350					
Extruder Diameter	kN	127					
Extruder Unit							
Extruder Diameter	mm	75	55	75	55	75	55
Extruder Motor Power	kW	22	11	22/(30)	11	22/(30)	11
Max Extrusion Capacity	kg/h	90	30	90/(100)	30	90/(100)	30
Total Power	kW	77.2		77.7/(86.7)		75.7/(84.7)	

Item	Unit	U Series (Linear Guide Rail)				
Model		SCJ-75-55U2x2.5G		SCJ-75-55-45U2x2.5G		
Specification						
Category		Double Layer		Triple Layer		
Max Volume	L	2.5		1		
Die Head No.		2		2		
Center Distance	mm	160,170,180,190		120,125,130,140		
Net Weight	kg	8800		9000		
Machine Dimension	m.LxWxH	4.17X4.6(2.1)X2.7		4.17X4.7(2.1)X2.7		
Clamping Unit						
Min Clamping Distance Of Mould	mm	200		200		
Clamping Stroke	mm	200		200		
Extruder Diameter	kN	120		120		
Extruder Unit						
Extruder Diameter	mm	75	55	75	55	45
Extruder Motor Power	kW	30	11	30	11	5.5
Max Extrusion Capacity	kg/h	125	30	125	30	14
Total Power	kW	81.7		94.7		

Item	Unit	U Series (Linear Guide Rail)					
Model		SCJ-75-55-30U+T+S1x2.15G			SCJ-85-65-30U2x2.15G		
Specification							
Category		Triple Layer			Linear Guide Rail		
Max Volume	L	5			10		
Die Head No.		2			2		
Center Distance	mm	250,280			280		
Net Weight	kg	11000			12000		
Machine Dimension	m.LxWxH	5.6X2.2X3.4 5.6X3.9X3.4 (with labeling machine)			6.2X3.7X4.7		
Clamping Unit							
Min Clamping Distance Of Mould	mm	230			230		
Clamping Stroke	mm	390			290		
Extruder Diameter	kN	190			196		
Extruder Unit							
Extruder Diameter	mm	75	55	30	85	65	30
Extruder Motor Power	kW	30	7.5	5	30	15	2.2
Max Extrusion Capacity	kg/h	105	25	4	130	42	4
Total Power	kW	99.5			104.3		

Item	Unit	U Series (Linear Guide Rail)		
Model		SCJ-65K2X6.2D	SCJ-65U2X6.2G	SCJ-75K+S2X6.5D-A
Specification				
Category		Linear Guide Rail	Single Layer	Single Layer
Max Volume	L	0.25	0.22	0.3
Die Head No.		6	6	6
Center Distance	mm	70	70	80
Net Weight	kg	5000	7600	6500
Machine Dimension	m.LxWxH	3.465X3.304X2.16	3.23X3.45(2.15)X2.4	3.35X3.9X2.42
Clamping Unit				
Min Clamping Distance Of Mould	mm	160	160	200
Clamping Stroke	mm	150	145	200
Extruder Diameter	kN	31.4	47	70
Extruder Unit				
Extruder Diameter	mm	65	65	75
Extruder Motor Power	kW	15	15	30
Max Extrusion Capacity	kg/h	60	70	125
Total Power	kW	41.5	40	66.5

Item	Unit	U Series (Linear Guide Rail)		
Model		75U+S2X8.5G	85U+S2X8.5G	90U2X6.5G
Specification				
Category		Single Layer	Single Layer	Single Layer
Max Volume		380ml*8	380ml*8	1.25L*6
Die Head No.		8	8	6
Center Distance	mm	70、80	70、80	125
Net Weight	kg	9000	9200	12000
Machine Dimension	m.LxWxH	4x4.6x2.57	4.2x4.93x2.83	4.8X4.3X2.7
Clamping Unit				
Min Clamping Distance Of Mould	mm	250	250	230
Clamping Stroke	mm	200	200	200
Extruder Diameter	kN			
Extruder Unit				
Extruder Diameter	mm	75	75	90
Extruder Motor Power	kW	30	30	37
Max Extrusion Capacity	kg/h	120	130	160
Total Power	kW	64.5	65.7	85.1



Thickness⁺ control

This function can be used to achieve less weight

Deflasher⁺

automatically remove the burrs and tailings

Scraper⁺

suitable for products with spin dome, automatic removal of the spin dome and the flash.

Robot⁺

Able to equipped with front robot or rear robot .

Hoist⁺

suitable for lifting molds



Pre-sealed⁺ cutter

The tube is sealed at the end while cutting off the pipe, suitable for blowing wide products

Rotary pin⁺ holder

The direction of the pin can be achieved 30-150 degrees adjustable, suitable for blowing oblique products

Side injection function

Suitable for products without mouth, or product with 2 or more mouths in different directions

In-mold⁺ labeling

label into the mold before blowing the product the label will be stick perfectly with the product heat.

visual⁺ inspection

Inspect The product size and appearance by camera, this is a preferential function for those countries with a high labor cost or difficult recruitment



Leshan 乐善

Our clients

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.



Leshan 乐善

Turn key project

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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