Sumitomo SHI DEMAG

Double-shot

All-electric Double-shot Injection Molding Machine

PHOTO : SE400HS-CI

Lineup

SE30DU-CI	(290kN)
SE75DU-CI	(730kN)
SE130DU-CI	(1270kN)
SE230HS-CI	(2250kN)
SE280HS-CI	(2740kN)
SE400HS-CI	(4000kN)

Sumitomo Heavy Industries, Ltd.

Pursuing greater possibilities of parts with the Double-shot

Enhancing product added-value by combining different materials

Two-material molding allows parts of multiple colors or differing materials to be produced in a single process.
This approach opens the door to higher levels of design aesthetics and functionality that cannot be obtained from single-material molding. Moreover, because it noticeably improves production efficiency by reducing the number of components, processing steps and required floor space, two-material molding enhances the added-value of products.

Molding example (PC+PMMA)

Molding performance and lineup matched to manufacturer needs

Specialized for two-material molding, our Double-shot series solves productivity, stability and maintainability issues by integrating a number of highly reliable proprietary technologies into an all-electric machine with an established reputation for precision and stability. With clamping forces ranging from 290 kN to the world's highest* 4,000 kN class and a wide selection of modules to choose from, we have a solution for most any manufacturer's needs.

*World's largest class of all-electric double-shot molding machines

Manufacturer needs and solutions

High productivity	Toggle clamping system	Our highly reliable toggle technology accumulated over the years realizes fast, assured mold opening and closing.
	Rotary ejector rod Rotation speed Rotation precision	The mold rotary unit uses a servomotor drive and mechanical stop to ensure no time is wasted while rotating. At the same time, it keeps molding stable over repetitious production cycles.
Stable precision molding	Double Center Press Platens SKII control Direct drive	Tried-and-trusted components are on board. It is designed and built to answer the growing needs for thin-wall filling.
Filling for thin-wall parts	High-speed injection Flash mode/control	
Mold support	Wide platen Proprietary temperature control piping	Freedom of mold design and mountable weight is greatly increased, making possible to produce longer parts.
Ease of setup/maintenance	Independently turning plasticizing units Temperature control piping for rotary unit N9 controller	Setup, maintainability and operability have been greatly improved with features like temperature control piping for the rotary unit, screw cleaning and F/R single display.

YouTube

SE30DU-CI SE75DU-CI SE130DU-CI SE230HS-CI SE280HS-CI SE400HS-CI

World's largest class of all-electric double-shot molding machines

Solutions made possible by two-material molding

If you consider the vast range of material combinations available, the imaginable solutions offered by two-material molding are virtually endless. Our double-shot machines enable all kinds of molding possibilities and provide manufacturers the means to achieve high value-added production.

Variety of applications

Combining different colors or grades of the same material or different materials entirely opens the door to new applications in molding that were not possible before.

Different colors and materials can be combined into a single part.

Functionality

Molded parts can be given properties of resins with conflicting elements like improved sealing or resistance.


Ex.: Integrally molding cap body and packing

Dimensional accuracy

Since parts can be designed without consideration for downstream processing, dimensional variation caused by shrinkage is reduced. Moreover, improved dimensional stability can be expected in production of thinner-wall parts.


Even easily mismatching structures ... can be accurately molded.

Design aesthetics

Parts with notable design features such as texture and color can be made.


Different colors and materials can be combined into a single part.

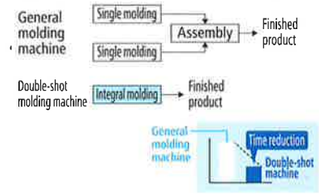
Durability

Strength and resistance to heat, weather and wear will be improved because the appropriate resin can be placed in the appropriate location.


Ex.: Tray
Shock-absorbing material is used on the outside to enhance durability.

Production efficiency

Two-material molding noticeably improves production efficiency by reducing the number of processing steps, components, manufacturing time and required floor space.



Molded part examples

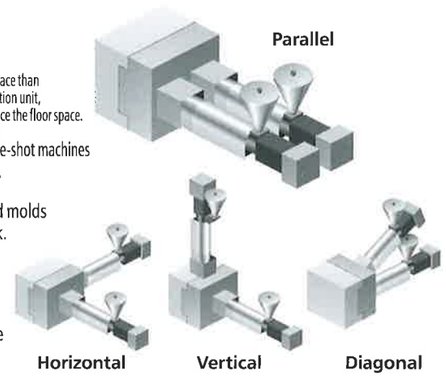
Elastomers

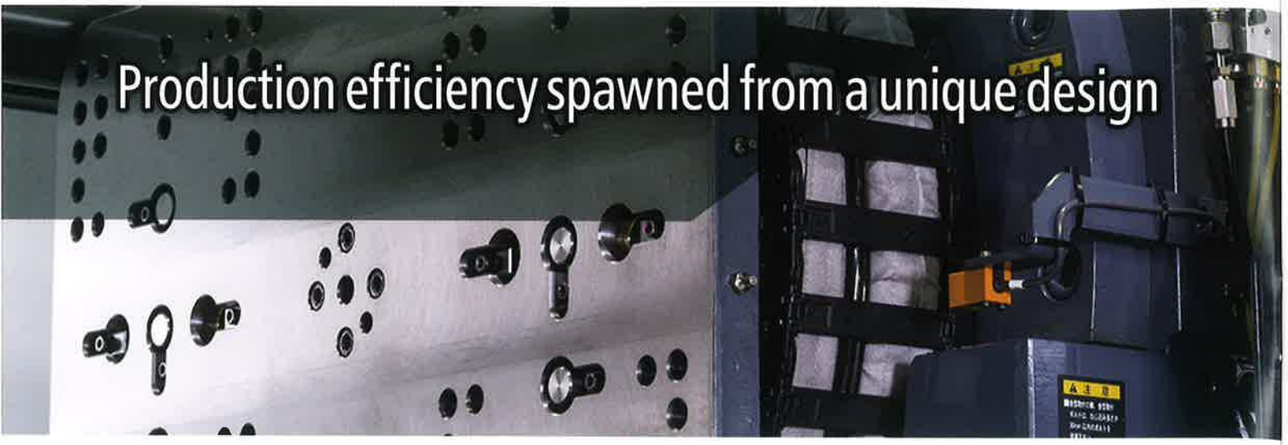
Translucent/Transparent resins

Benefits of parallel type double-shot machine

Compared to vertically, horizontally and diagonally arranged layouts, there are many benefits to positioning injection units parallel.

Space savings	Double-shot machine with injection units arranged in parallel requires less space than vertically arranged type machine, which needs the height for the second injection unit, or horizontally arranged (right-angle layout) type machine, which requires twice the floor space.
Suited for wide variety, small lot production	Because not only hot runners but cold runners can be used, double-shot machines make it easy to produce a wide variety of parts in small quantities.
Easy setup	Use of integrated mold make it easy to align nozzles and molds so that injection units do not hamper maintenance work.
Shorter cycle times	More effective features to shorten cycle time is incorporated into machines.
Cleanroom compatible	Safety door is hermetically sealed and gases can be easily recovered from the purging cover.

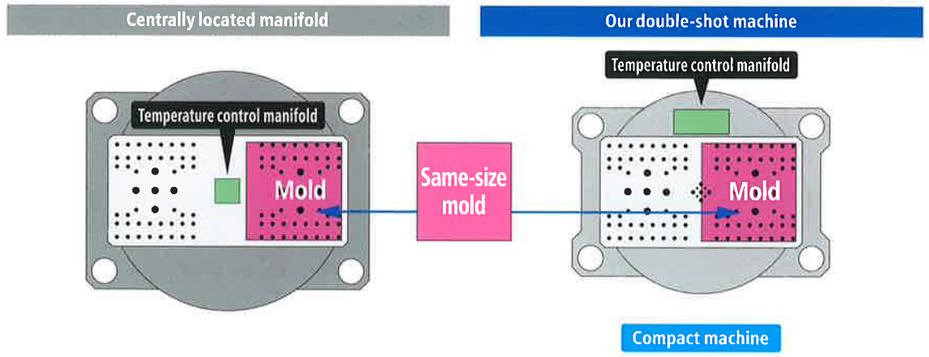




Production efficiency spawned from a unique design

Piping routed to support greater freedom of molds

Since the manifold is not placed in the center of the rotary table, there will be no wasted space. This allows to mount the same size mold to smaller machines and leads to the achievement of "big jobs with a small machine" through an efficient mold use.

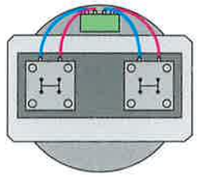


Temperature control piping on movable side for mold rotation

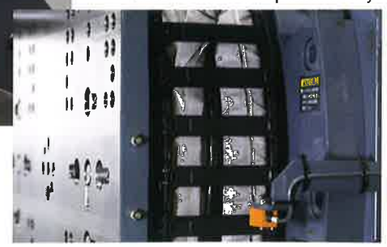
Option **Patented**

Hoses are routed through the cableveyor that runs along the outer edges of the rotary table to supply cooling water, mold heater and core pull (pneumatic or hydraulic) to the movable side mold. This shortens mold cooling time, improves transcription with heater and allows use of molds with core pull. Moreover, it facilitates hose maintenance and replacement.

Sumitomo's unique temperature control manifold to not get in the way during production setup.



The cableveyor makes hose maintenance quick and easy.



Piping lines are selectable according to application.

SE30DU-CI	1 line
SE75DU-CI	2 lines *4 lines
SE130DU-CI	2 lines *4 lines
SE230HS-CI SE280HS-CI SE400HS-CI	2&4 lines *8 lines

* Available upon request

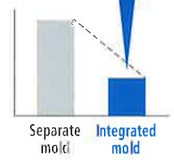
Shorter setup time with integrated mold

Thanks to an original design, our double-shot machine can easily mount large integrated mold. Compared to separate molds, integrated molds require considerably less time to set up, which translates into more efficient production operations.

Example comparison of mold mounting

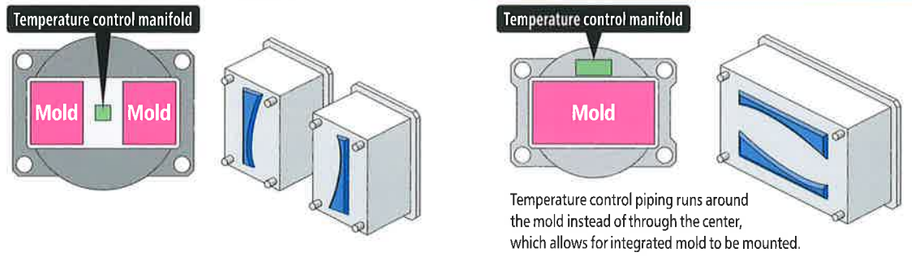
Separate (two-type) mold		Integrated mold
Loading mold A	Attaching mold B opening stopper	Loading mold
Positioning	* Mold closing	Positioning (Based on the movable side)
Confirmation of level	* Mold B bolts temporary tightening	Die height adjustment (mold contact)
Die height adjustment (mold contact)	Detaching mold B opening stopper	Bolt tightening
Bolt tightening	* Mold opening>>Rotation>>Mold closing	Detaching opening stopper
Detaching mold opening stopper	* Mold B bolts tightening	Mold alignment and uniformity check (Mold opening>>Rotation>>Mold closing)
Mold opening>>Rotary table rotation	* Mold halves alignment and uniformity check (Mold opening>>Rotation>>Mold closing)	
Split mold B and assembled onto each half of mold A	If not fit properly, procedure is repeated from *.	

50%~80% less time required



Long parts available thanks to wider range of mountable molds

An original temperature control manifold and wider tie-bar clearance enable large mold to be mounted. It enables the molding of long parts, which was not possible with the separate (two-part) mold.

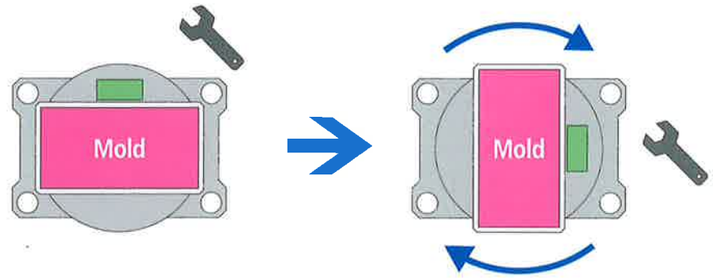


Temperature control piping runs around the mold instead of through the center, which allows for integrated mold to be mounted.

90° rotation stop feature that greatly improves workability

SE400HS-CI

The hard-to-reach top manifold faces the operator's side, making it easier to tighten bolts and perform other works. This greatly improves the workability on the large class machine SE400HS-CI.



Features designed for cycle time reduction

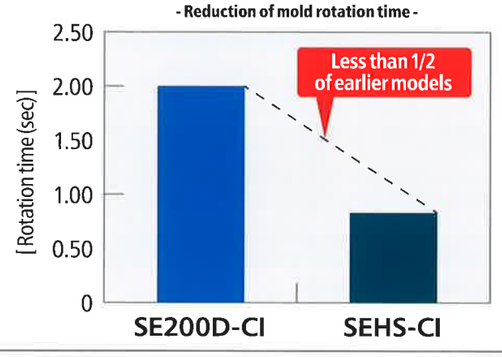
Greatly shortened mold rotation time

The performance of mold rotary unit and mold opening/closing unit have been thoroughly reviewed comparing with the conventional machine. Accordingly, rotating time has been reduced to less than half of the earlier models, which leads to significant improvement in productivity.

- Mold rotation time -

SE30DU-CI	0.5sec
SE75DU-CI	0.8sec
SE130DU-CI	0.6sec
SE230HS-CI	0.8sec
SE280HS-CI	0.8sec
SE400HS-CI	1.5sec

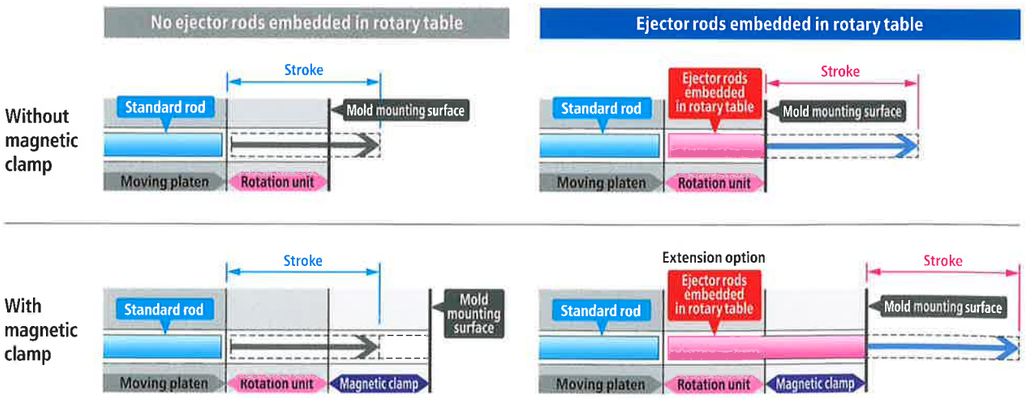
- Reduction of mold rotation time -



Ejector rods embedded in the rotary table

SE30DU-CI SE75DU-CI SE130DU-CI | Option | Patented

The ejection stroke can be effectively utilized to shorten the molding cycle.

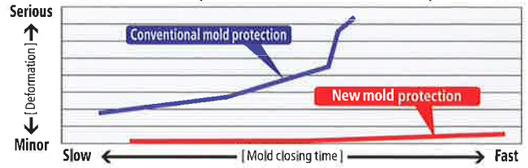


Fine-tune individual control before/after mold rotation

Even with two perfectly identical two-material molds, there is actually a difference after rotating the mold. With our double-shot machine, molding inaccuracies of the sort have been improved by making it possible to individually control conditions before and after the rotation. Moreover, because torque is meticulously detected, molds are subjected to less stress, which relieves the worries of damaging expensive molds and allows to extend the maintenance interval.

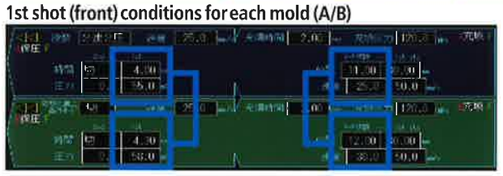
Original | Our double-shot machine | Common mold protection

- Performance comparison between new and old mold protection -

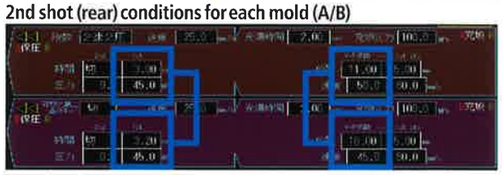


Example of mold protection settings

1st shot (front) conditions for each mold (A/B)

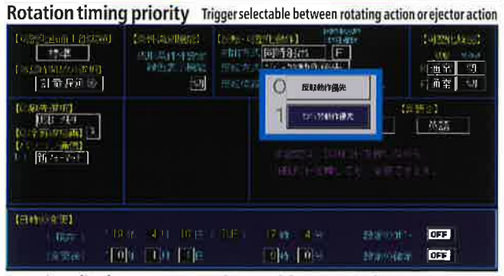


2nd shot (rear) conditions for each mold (A/B)



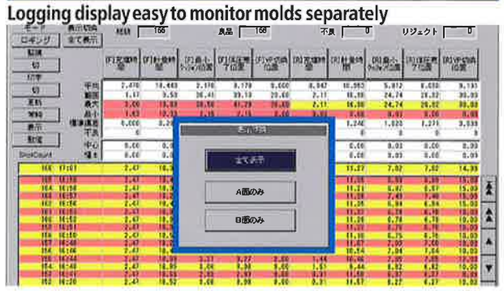
Rotating mode setting

Rotation timing priority Trigger selectable between rotating action or ejector action



Applicable to various filling patterns

Logging display easy to monitor molds separately

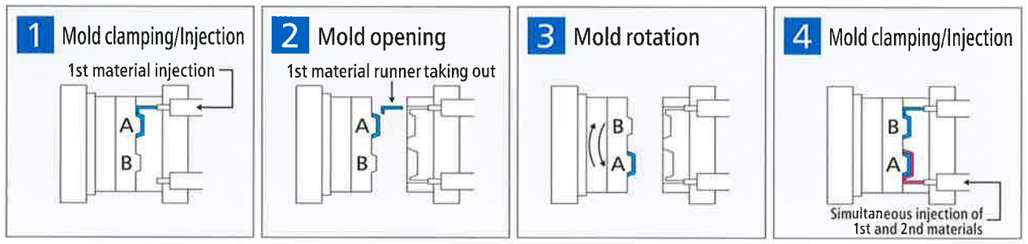


Capability for a wide range of molding processes and special resins

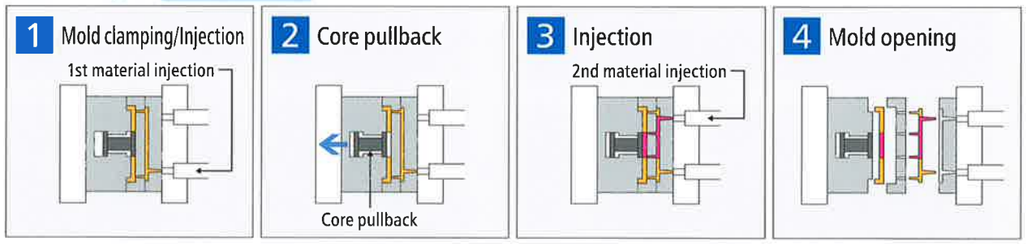
Diverse molding processes support molding complex shaped parts

The double-shot machine easily handles complex shaped parts by rotary type, core back type and rotary + core back type injection molding. Besides the two-material molding, the series can also be applied for laminate and insert molding.

Rotary type

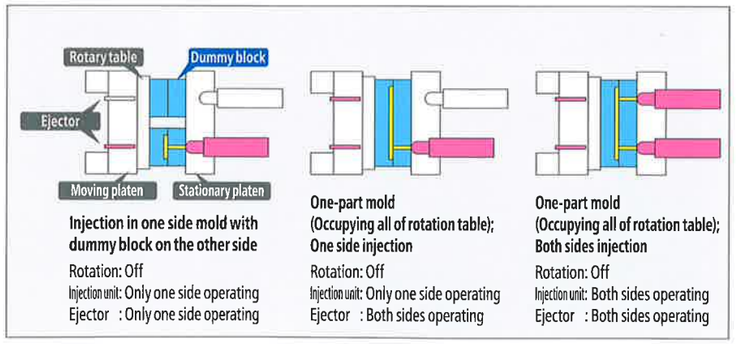


Core back type Option



Single-color molding

The double-shot machine can be used as a single-color molding machine without rotating molds.



Injection in one side mold with dummy block on the other side
Rotation: Off
Injection unit: Only one side operating
Ejector : Only one side operating

One-part mold (Occupying all of rotation table); One side injection
Rotation: Off
Injection unit: Only one side operating
Ejector : Both sides operating

One-part mold (Occupying all of rotation table); Both sides injection
Rotation: Off
Injection unit: Both sides operating
Ejector : Both sides operating

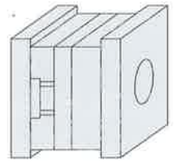
Multi-toggle

Multi-toggle is a mechanism that applies a low clamp force at the start of filling and then increases pressure as filling progresses. It improves gas release, prevents burrs from forming and lessens the frequency of mold cleaning. These benefits are especially appreciated in two-material molding where elastomers are often used.

Improved gas release

A low clamping force is applied at the start of filling to improve gas release.

Prevention of burr



Clamp force is increased as filling progresses to prevent burrs.

Particularly effective measure against elastomer gas

SL Screw Option

A new plasticizing system with a screw as the core, which was designed after visually analyzing the resin melting behavior against temperature and pressure with previous screws. It prevents melt resin stagnation and subsequent carbonization, and releases gas and moisture to realize stable plasticization.

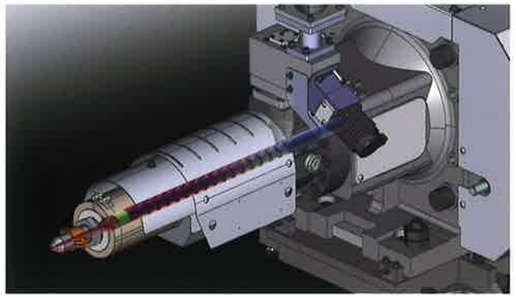
Defects improved or solved by SL Screw

Black spot, burning and discoloring
Increased appearance defects/ screw maintenance

Gas generation and moisture contamination
Increased appearance defects/ mold maintenance

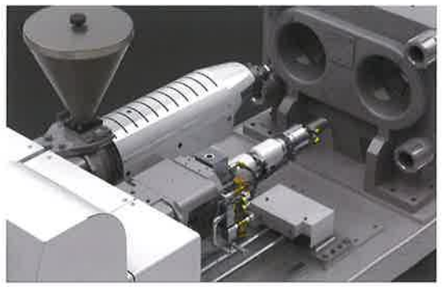
Screw, tip or cylinder wear
Increased cylinder maintenance

Unstable plasticization
Inconsistent product precision/productivity



LSR molding supported Option

Liquid Silicone Rubber (LSR) is often used in two-material molding. Our LSR screw assembly uses a rotating sealing method that realizes small-capacity precision metering and low-speed filling. Highly stable LSR molding without burrs will be achieved.



Main Specifications

Item	Unit	SE30DU-CI	SE75DU-CI	SE130DU-CI	SE230HS-CI	SE280HS-CI	SE400HS-CI
■Mold clamping unit							
Mold clamp system		Double toggle (5 points)	Double toggle (5 points)	Double toggle (5 points)	Double toggle (5 points)	Double toggle (5 points)	Double toggle (5 points)
Maximum clamping force	kN	290	730	1270	2250	2740	4000
Clearance between tie-bars (WxH)	mm	370 x 290	560 x 360	660 x 360	920 x 560	920 x 560	1110 x 640
Dimensions of rotary table (WxH)	mm	280 x 280	560 x 390	660 x 420	920 x 600	920 x 600	1140 x 870
Daylight	mm	520	710	825 (800) *5	1070 (1040) *5	1070 (1040) *5	1225
(Mold thickness extension 100 mm selected)		—	—	—	—	—	(1325)
Mold opening stroke	mm	230	300	375 (350) *5	510 (480) *5	510 (480) *5	625
Maximum platen speed	mm/s	1200	1300	1200	1200	1200	1200
Mold height (min. - max.)	mm	180～290	160～410	180～450	210～560	210～560	250～600
(Mold thickness extension 100 mm selected)		—	—	—	—	—	(250～700)
Locating hole diameter	mm	2-φ60	2-φ60	2-φ120	2-φ120	2-φ120	2-φ120
(Locating ring with inner diameter φ100 selected)		—	—	—	—	—	(2-φ100)
Ejector ejection points		Motor driven type (1 points) x 2	Motor driven type (3 points) x 2	Motor driven type (5 points) x 2	Motor driven type (5 points) x 2	Motor driven type (5 points) x 2	Motor driven type (9 points) x 2
Ejector ejection force	kN	7.8 x 2	20 x 2	21 x 2	45 x 2	45 x 2	60 x 2
(Ejector ejection up selected)		—	—	—	—	—	100 x 2
Maximum ejector speed	mm/s	333	333	333	333	333	267
Ejector stroke	mm	70	91	100 (91) *6	150	150	220
Ejector rod protrusion amount	mm	–83 (61) *6	–62 (82) *6	–53 (82) *6	97	97	150
Maximum mold weight	kg	50	175 x 2	300 x 2	750 x 2	750 x 2	1650 x 2
(Moving side maximum)		(100)	(200 x 2)	(250 x 2)	(500 x 2)	(500 x 2)	(1300 x 2)

■Injection unit

Plasticizing capacity		C30			C65				C250			
		MN			MN		S		M			
Screw diameter	mm	16	18	20	16	18	20	22	25	28	32	36
Maximum injection pressure *1,*2	MPa	266	210	170	266	210	235	194	281	284	217	171
Maximum hold pressure *1,*2	MPa	212	168	136	266	210	216	178	225	227	174	137
Theoretical injection capacity	cm^3	11	14	17	11	14	27	33	56	86	113	143
Injection weight (GPPS)	g	11	13	17	11	13	26	32	54	83	108	137
Plasticizing capacity *3	kg/h	9.5	13	16	8.8	12	13	18	26	37	53	76
Injection rate	cm^3/s	101	127	157	101	127	157	190	147	185	241	305
Screw stroke	mm	55			55		87		114	140		
Maximum injection speed	mm/s	500			500				300			
Maximum screw rotation speed	min^{-1}	430			400				400			
Quantity of temperature control zones		4			4			5	4	5		
Heater capacity	kW	2.7	2.7	3.1	2.7	2.7	3.5	3.9	5.5	6.6	7.6	8.5
Nozzle pressing force	kN	2.9			5.8				A 11 / B 14 *7			
Nozzle protrusion	mm	30 / 50			30 / 45 / 65 / 80				45 / 65 / 85			
Hopper capacity (Standard model hopper selected)	L	(2.5 x 2)			(6.0 x 2)				(15 x 2)			

Plasticizing capacity		C250 *8			C360			C510			C250 *8			C360			C510			C250			C560			C900		
		M			M			M			M			M			M			M			M			L		
Screw diameter	mm	28	32	36	32	36	40	40	45	50	28	32	36	32	36	40	40	45	50	28	32	36	40	45	50	45	50	56
Maximum injection pressure *1,*2	MPa	284	217	171	273	215	167	245	193	156	284	217	171	273	215	167	245	193	156	284	217	171	274	216	175	267	216	172
Maximum hold pressure *1,*2	MPa	227	174	137	218	172	134	196	154	125	227	174	137	218	172	134	196	154	125	284	217	171	274	216	175	213	172	137
Theoretical injection capacity	cm^3	86	113	143	129	163	201	201	254	314	86	113	143	129	163	201	201	254	314	86	112	142	201	254	314	329	406	509
Injection weight (GPPS)	g	83	108	137	124	156	193	193	244	302	83	108	137	124	156	193	193	244	302	83	108	136	193	244	301	316	390	489
Plasticizing capacity *3	kg/h	37	53	76	53	76	101	101	136	193	37	53	76	53	76	101	101	136	193	37	53	76	101	136	193	149	202	246
Injection rate	cm^3/s	185	241	305	241	305	377	377	477	589	185	241	305	241	305	377	377	477	589	215	281	356	439	556	687	556	687	862
Screw stroke	mm	140			160			160			140			160			160			140			160			207		
Maximum injection speed	mm/s	300			300			300			300			300			300			350			350			350		
Maximum screw rotation speed	min^{-1}	400			400			400			400			400			400			400			400			400		360
Quantity of temperature control zones		5			5			5			5			5			5			5			5			6		
Heater capacity	kW	6.6	7.6	8.5	7.6	8.5	10.4	10.4	11.1	11.3	6.6	7.6	8.5	7.6	8.5	10.4	10.4	11.1	11.3	6.6	7.6	8.5	10.3	11.5	12.6	17.0	19.2	21.1
Nozzle pressing force	kN	A 11 / B 14 *7			A 11 / B 14 *7			24			A 11 / B 14 *7			A 11 / B 14 *7			24			A 11 / B 14 *7			A 24 / B 29 *7			A 29 / B 47 *7		
Nozzle protrusion	mm	45			45 / 65			45 / 65			45			45 / 65			45 / 65			45 / 65 / 80			45 / 65 / 80			50 / 65 / 85		
Hopper capacity (Standard model hopper selected)	L	(30 x 2)									(30 x 2)									(C003:30 x 2) (C003a:50 x 2)								

■Machine dimensions and weight

Machine dimensions (LxWxH) *4	mm	3453 x 1079 x 1526	4017 x 1318 x 1658	5508 x 1419 x 1860	6403 x 1854 x 1997	6403 x 1854 x 1997	7533 x 2252 x 2191		
(Mold thickness extension 100 mm selected)		—	—	—	—	—	(7633 x 2252 x 2191)		
Machine weight	t	3.0	5.0	7.6	17.0	17.0	25.1	26.1	27.5

*1 The maximum injection pressure and the maximum holding pressure are calculated values. These values indicate not the resin pressure but the output of the unit.
*2 The maximum injection pressure and the maximum holding pressure are not values that can be sustained continuously.
*3 The plasticization capacity value indicates the capacity when the SM screw is loading.
*4 The full length of the machine is the measurement taken when the smallest screw is loaded at the forward position of the injection unit.
*5 When the machine is equipped with an ejector unit with brake, the mold opening-closing stroke is limited to the value in ( ).
*6 Values in ( ) are for machines with ejector rods embedded in the rotary table.
*7 Selectable between A and B
*8 When the C250 plasticization device is selected, it is necessary to select both sides. (This restriction does not apply to the SE400HS-CI.)

® We appreciate your kind understanding that as a result of our effort to enhance performance, there may be slight modifications to the specifications.
Ⓢ The dimensions are Japanese specification.
◇ This series originally comply to safety standards of Japan, the US, in addition, also China GB22530 and KC mark.

Standard Equipment

Plasticizing and injection unit (FR common)	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Standard SD screw assembly (open nozzle, nitride screw)	○	○	○
2. Programming control of injection 5 stages / 2 stages (switching)	○	○	○
3. Programming control of holding pressure 4 stages / 2 stages (switching)	○	○	○
4. Screw pull back (after holding pressure end/after dose end)	◎	○	○
5. Screw position digital display (setting 0.01mm)	○	○	○
6. Holding pressure time 0.01sec setting	○	○	○
7. V-P switchover controller (pressure, position)	○	○	○
8. Filling delay timer	○	○	○
9. Auto purging with nozzle touch or IJ unit retract confirmation	○	○	○
10. Cylinder temperature PID control 5 zones	○	○	○
11. 2-modes temperature control (production/standby)	○	○	○
12. Screw cold start prevention with variable timer	○	○	△
13. Injection unit retraction delay selector (with delay timer)	○	○	○
14. Sprue break stroke remote setting	○	○	○
15. Screw speed digital indicator	○	○	○
16. Purging cover (with limit switch)	○	○	○
17. Purging saucer (stainless steel)	○	○	○
18. Swivel injection unit (With nozzle center adjust device)	○	○	○
19. Remaining cooling time indicator	○	○	△
20. Dose delay timer	○	○	○
21. Injection/Holding response 10-mode	○	○	△
22. Holding pressure speed setting	○	○	△
23. Pull back delay control	○	○	○
24. Flash Speed Mode	○	○	△
25. Flash control	○ (75/130 only)	×	△
26. Flow front check	×	×	△
27. Synchro dose	○	○	△
28. Reverse control software	○	○	△
29. Temperature control for nozzle	○	○	△
30. Stepped heat-up operation	○	○	△
31. Energy saving cylinder cover (Two layer structure)	○	○	△
32. Water cooling jacket temperature control device	○	○	△
33. Screw centering mechanism	○	○	△
34. Mold open operation during dose (Needle nozzle drive control)	○	○	△
35. Filling pressure multi-level control	○	○	△
36. Resin residence protection	○	○	△
37. One touch dose	○	○	△
38. Auto grease lubrication unit	○	○	△

Control unit	DU-CI	HS-CI (230/280)	HS-CI (400)
1. 12.1 inch TFT Color LCD screen	○	○	○
2. Input setting device : Sheet-key and touch panel	○	○	△
3. Internal memory of molding conditions (200 conditions)	◎	◎	◎
4. Operation support function	◎	△	△
5. Molding profiles display function (mold profiles storage, cursor, display and so on)	○	○	○
6. Screen snap shot function	○	○	○
7. Take-out robot connection circuit (with turn complete signal) *1	○	○	○
8. 3 languages selection (Japanese/English/Chinese)	○	○	△
9. Operation guide for maintenannce (Screen display of inspection timing, grease application timing, item, method)	○	○	○
10. Auto start/stop function (Lowered temp, heater on, machine shut down)	○	○	○
11. Process display function	◎	◎	◎
12. SSR heater drive circuit	◎	△	△
13. Input of industrial unit for speed, position, pressure and rotation rate	○	○	○
14. Machine status output signal (5ch) *1	○	○	○
15. USB connection circuit (printer, memory)	○	○	○
16. PC connection circuit (RS232C)	○	○	○
17. Protection for molding condition	○	○	○
18. Abnormal processing selection	○	○	○
19. Initial reject and interruption reject function	○	○	○

Clamp unit	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Programming control of opening/closing speed (5 stages/3 stages)	○	○	○
2. Mold protection	○	○	○
3. Low pressure clamping unit	○	○	○
4. Mold opening/closing pause	○	○	○
5. Remote control of clamp force	○	○	○
6. Remote control of mold space	○	○	○
7. Clamp force feedback control	○	○	○
8. Ejector (with selective multi-functions & return check)	○	○	○
9. Ejector protrusion delay timer	○	○	○
10. Ejector remote control (speed, stroke and pressure)	○	○	○
11. Ejector 2-speed control	○	○	○
12. Ejector protrusion holding device	○	○	○
13. Ejector protrusion interlock (possible only at mold open limit during manual operation)	○	○	○
14. Ejector protrusion during mold opening	○	○	○
15. Ejector protrusion during mold closing	○	○	○
16. Ejector plate return signal (Input signal for molding machine) Connection by metal concent 2 lines on the mold reversal table *1	○	○	○
17. Mold opening/closing signal (Spear control signal) Dry A contact *1	○	○	○
18. Valve gate drive circuit (control circuit only, 2 lines) *1	○	○	○
19. Stand by mode for mold installation (low mold opening/closing speed)	○	○	○
20. Safety door with acrylic window	○	○	×
21. Safety door with polycarbonate window	×	×	○
22. Emergency stop push button (Operation side and non operation side)	○	○	△
23. Clamp cover with acrylic window	○	○	×
24. Clamp cover with polycarbonate window	×	×	○
25. Threaded holes for takeout robot mounting	○	○	○
26. Grease central lubrication for clamp unit	○	○	△
27. Mold close interlock device (Electrical, mechanical type)	○	○	△
28. Mold opening/closing with low vibration or high speed mode	○	○	△
29. Moving platen support (Sliding type)	○	○	×
30. Moving platen support device (liner guide type)	×	×	◎
31. Double center press platen (Fixed platen side, Moving side)	×	◎	△
32. Center press platen (Fixed platen side)	○	×	×
33. Displacement prevention in mold mounting (Clamp force set to 0 ton)	○	○	△
34. Ejected products sensor circuit *1	○	○	△
35. Oil pan under mold clamp unit (Detachable for cleaning and maintenance)	×	○	△
36. High speed mold rotating unit (With remote speed control and dust cover)	○	○	△
37. Multi-toggle	○	○	○
38. Ejector unit with brake	×	×	○
39. Clamping force balance monitor (4ch)	×	×	○
40. Rotary table lock pin	×	×	△

Monitor unit	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Actual value display function	○	○	○
2. Heater breakage monitor	○	○	○
3. Auxiliary facility monitor (1ch) *1	○	○	○
4. Abnormal monitor (Max. cushion, min. cushion, Filling pressure, mold protection, cycle time, weighing time)	○	○	○
5. Automatic setting for abnormality monitoring condition	○	○	○
6. Abnormality history display (abnormal item, occurrence time display)	○	○	△
7. Product quality monitor	○	○	○
8. Quality control function (Actual value statistics function, various graphing function, 100,000 shots stored data check function)	○	○	○
9. Product control (Product quality control device, automatic production stop, stocker signal, Logging, Counter) *1	○	○	○
10. Auto start device (Auxiliary facility)	○	○	○
11. Cylinder heater temperature monitor (all zones)	○	○	○
12. Self diagnosis function	○	○	○
13. Alarm buzzer	○	○	○
14. Shot counter	○	○	○
15. Molding cycle time monitor (attended/unattended selection)	○	○	○
16. Total production control circuit	○	○	○
17. List setting screen	○	○	○
18. Function to prevent use of monitor	○	○	○
19. Maintenance key switch	○	○	○

Others	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Auto grease supply unit (cartridge grease type)	○	○	○
2. Three-directional ejection frame	○ (130only)	○	○
3. Mold cooling water block (2 systems) (flow indicator and valve are options)	○	○	○
4. Standard tool (offset wrench for nozzle)	○	○	○
5. Standard spare parts (Touch-up paint, fuse)	○	○	○

Screw assembly

* Elastomer resins often used in two-material molding can generally be used without requiring a special screw type or assembly.

Note: The above specification is not available for some molding machine models.

◎ : Good match between screw type and assembly material △ : Selectable with restrictions

○ : Applicable ● : Specification not applicable or available for selection

Feature	Example resins	Compounding agent	Screw type: SD screw	Screw type: SF screw	Screw type: SM screw	Assembly material: Plated	Assembly material: For Optical use	Assembly material: Antiwear, anticorrosive, antiwear, anticorrosive II	Assembly material: Antiwear, anticorrosive II	Assembly material: Antiwear, anticorrosive II & High temperature	Example molded parts
Engineering plastics supported	PA・PBT・PP・ABS・POM・PC	Strengthening (GF30% or less), Combustion retarding	◎	△	△	●	●	◎	◎	○	Mechanical parts, electronic components, etc.
Super-engineering plastics supported	LCP・PA9T	Strengthening (Under GF35%), Combustion retarding	○	△	△	●	●	○	◎	○	Connector, electronic components, etc.
	PA6T・PPS・PA46	Strengthening (GF30% or more), Combustion retarding, Anticorrosion	○	△	△	●	●	△	○	△	Connector, electronic components, etc.
Optical resins supported	Cyclic polyolefin、PMMA、PC	Not strengthening	△	◎	△	○	◎	△	△	△	Optical components, transparent parts, etc.
High temperature specification	LCP、PEI、PEEK	Strengthening, Not strengthening	◎	△	△	●	●	△	△	◎	Mechanical parts, etc.

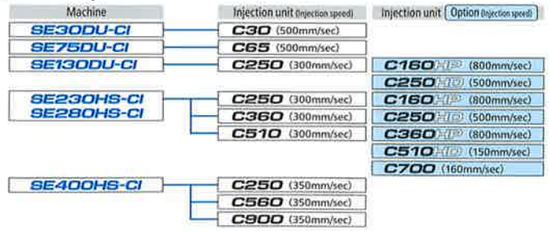
Optional Equipment

Plasticizing selection	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Hard chromium plating screw assembly	○	○	○
2. Wear & corrosion resistant II & III screw assembly	○	○	×
3. Wear & corrosion resistant A screw assembly	×	×	○
4. Wear & corrosion resistant B screw assembly	×	×	△
5. High-temperature screw assembly (Max. temp. 450ºC)	○	○	○
6. SF screw	○	○	×
7. SM screw	×	×	◎
8. SK screw tip (Material : STD, MK, TiN)	○	○	◎
9. Needle valve nozzle (Pneumatic nozzle actuating cylinder)	○	○	○
10. High capacity heater	○	○	○
11. Zone 1 high capacity heater	○	○	○

Plasticizing and injection unit	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Resin temperature finder	○	○	○
2. Standard type hopper	○	○	○
3. V/P switchover by mold cavity pressure	○	○	○
4. Needle valve nozzle drive circuit	○ (75/130 only)	○	○
5. FTC nozzle electric control circuit (Built-in)	○ (30 only)	×	×
6. High temperature heater control circuit (Up to 499 °C / 930 °F.)	○	○	○
7. Hopper swivel mounting plate	○ (75/130 only)	○	○
8. Plating resin inlet of cooling water jacket	○	○	○

Control and monitor unit	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Leak circuit breaker (AC200V, 220V 3ø 3W+E, Japan and Asia only)	○	○	△
2. Mold temperature monitor (2 Zone. stationary platen non-operation side)	○	○	△
3. Mold temperature monitor (2 Zone. mold reversal table)	×	○	△
4. Auxiliary facility monitor (STD. + 2ch) *1	○	○	△
5. Analog data output connection circuit	○	○	△
6. Mold temperature controller (Stationary platen's non-operation side. K=CA 2 zone)	○	○	△
7. Mold temperature controller (mold reversal table. K=CA 2 zone)	×	○	△
8. Automatic starting system (Heater + water supply + external output signal)	○	○	△
9. Printer connection circuit PC/AT compatible	○	○	×
10. Revolving alarm lamp (Mounted on the toggle support non-operation side)	○	○	△
11. Revolving alarm lamp (Mounted on the toggle support operation side)	×	×	○
12. Multi function 3 colors LED alarm lamp (Mounted on the toggle support non-operation side)	○	○	△
13. Multi function 3 colors LED alarm lamp (Mounted on the toggle support operation side)	×	×	○
14. 4 lines closed circuit water connection lines (Stationary side. With flow indicator and stop valve, and stop valve and filter for cooling water)	○	○	△
15. 2 lines closed circuit water connection lines (Stationary side. With flow indicator and stop valve, and stop valve and filter for cooling water)	○	○	△
16. Spare power supply outlet selection	○	○	△
17. Electric power supply receptacles	○	○	×
18. Electric power supply receptacles	×	×	○
19. Electric power supply receptacles	×	×	○
20. Key-lock switch for molding setup	○	○	△
21. Name plate : Blue	○	○	○
22. Mat switch for Under the Mold clamping unit	○	○	○
23. Motion 07	○	○	○
24. Motion GB	○	◎	◎
25. Emergency stop link (traverse robot & die cart)	×	×	◎
26. DC24V power supply for external signal (power only)	×	×	○

Module configuration



Clamp unit	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Ejector (Rod diameter 25)	×	○	×
2. Pneumatic ejector (Stationary side - 2 lines, Control circuit + Pneumatic circuit)	○	○	△
3. Pneumatic ejector (Stationary side - 2 lines, Control circuit only)	○	○	○
4. Pneumatic ejector (Movable side - 2 lines, Control circuit + Pneumatic circuit)	×	×	△
5. Cavity ventilator (Stationary side - 1 line)	○	○	△
6. Cavity ventilator (Stationary side - 2 line)	×	×	○
7. Hydraulic core tractor control circuit (Stationary side, 2 line)	○	○	△
8. Hydraulic core tractor control circuit (Stationary side, 4 line)	×	×	△
9. Pneumatic core pull control circuit (Stationary side, 1 line)	○	○	△
10. Pneumatic core pull control circuit (Stationary side, 2 line)	×	×	○
11. SPI take-out robot connection circuit *1	○	○	○
12. SPI AN-146 / Euromap67 take-out robot connection circuit *1	×	×	△
13. High precision heat insulating plate t=5mm (rectangular, separates)	○	○	○
14. Auto grease lubrication unit (liner guide on plasticizing unit)	○	○	×
15. Valve gate drive circuit (Control circuit and pneumatic circuit 1 line)	×	×	◎
16. Valve gate drive circuit (Control circuit and pneumatic circuit 2 line)	×	×	◎
17. Full metallic toggle cover	○	○	○
18. Hydraulic driving unit	×	×	◎
19. Preserve piping for Mold reversal device (1Line, less than 120℃)	× (30 only) ○ (75/130 only)	×	×
20. Preserve piping for Mold reversal device (2Lines, less than 120℃)	×	○	○
21. Preserve piping for Mold reversal device (4Lines, less than 120℃)	×	○	○
22. Preserve piping for Mold reversal device (6Lines, less than 120℃)	×	×	○
23. Preserve piping for Mold reversal device (8Lines, less than 120℃)	×	×	○
24. Preserve piping for Mold reversal device (2Lines, less than 80℃)	×	×	△
25. Preserve piping for Mold reversal device (4Lines, less than 80℃)	×	×	○
26. Preserve piping for Mold reversal device (6Lines, less than 80℃)	×	×	○
27. Preserve piping for Mold reversal device (8Lines, less than 80℃)	×	×	○
28. Preserve piping for Mold reversal device (2Lines, less than 160℃)	×	×	○
29. Preserve piping for Mold reversal device (4Lines, less than 160℃)	×	×	○
30. Preserve piping for Mold reversal device (6Lines, less than 160℃)	×	×	△
31. Preserve piping for Mold reversal device (8Lines, less than 160℃)	×	×	○
32. Tie-bar coating	○	○	△
33. Locating ring (Press fit) (Inner diameter ø100)	×	×	○
34. Mold space extension 100mm	×	×	△
35. Ejector unit with brake (Mold opening and closing stroke is shortened)	○ (75/130 only)	○	(Standard)
36. Slide core return signal (2 lines) *1	×	×	○
37. Hydraulic driving unit (2 lines)	×	×	○
38. Hydraulic driving unit (4 lines)	×	×	○
39. Mold clamp control unit *1	×	×	○
40. Magnet clamp control unit *1	×	×	○

Spare parts and accessories	DU-CI	HS-CI (230/280)	HS-CI (400)
1. Spare parts A (Mechanical parts : Brake lining, Lub. Parts)	◎	◎	◎
2. Spare parts A (Thermocouple)	◎	○	○
3. Spare parts for export (Encorder, Limit switch, Relay and Magnetic switch)	○	○	○
4. Leveling pads (for one machine)	○	○	△
5. Locating ring (Transition fit) Inner diameter ø100/outer diameter ø120	×	×	△
6. Mechanical parts and hook for hosting machine	○	○	△
7. Tool A	○	○	○
8. Ejector rods	×	×	○
9. Grease gun	○	○	○
10. Grease cartridge for Auto lub. (700cc)	○	○	○
11. Grease cartridge for Manual lub. (400cc)	○	○	○
12. Special tool for removing Screw head set	×	×	○ (C900only)

*1 All input and output signals are no-voltage contact signals. (Power is not supplied with output signals.)

●The export of this product for use for or in development and/or production of massive destruction arms and weapons (nuclear weapons, biological weapons, missiles) or the export of this product to any person, party or corporation engaged or involved in the development and/or production of above described goods is subject to the authorization of the Japanese government pursuant to Foreign Exchange and Foreign Trade Control Law.

●Specifications are subject to change without notice for performance improvement.

Machine utility list

●This table presents an example case of utilities. Values will change according to the place of use and operating conditions.

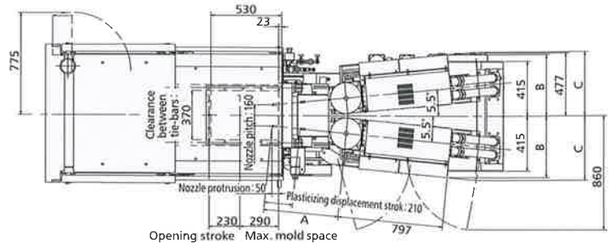
	Model	SE30DU-CI F	SE30DU-CI R	SE75DU-CI F	SE75DU-CI R	SE130DU-CI F	SE130DU-CI R	SE230HS-CI F	SE230HS-CI R	SE280HS-CI F	SE280HS-CI R	SE400HS-CI F	SE400HS-CI R	Notes
Specification	Plasticizing capacity	C30	C30	C65	C65	C250	C250	C250	C250	C360	C510	C560	C560	
	Screw size	ϕ18	ϕ20	ϕ20	ϕ22	ϕ32	ϕ36	ϕ32	ϕ36	ϕ36	ϕ45	ϕ40	ϕ50	
Cooling water	Water cooling cylinder required water level	0.6ℓ/min	0.7ℓ/min	0.8ℓ/min	0.9ℓ/min	1.8ℓ/min	2.0ℓ/min	1.8ℓ/min	2.0ℓ/min	2.0ℓ/min	2.6ℓ/min	2.4ℓ/min	2.9ℓ/min	*Molding machine only
	Connecting pipe size (both for intake/outlet)	1/2B		1/2B		1/2B		1/2B		1/2B		1/2B		*Shared mold
	Mold cooling water manifold	1/4B		1/4B		1/4B		1/4B		1/4B		1/4B		
Electrical list	Power supply specification	200V 3ϕ 3W+E												
	Heater capacity	2.7kW	3.1kW	3.5kW	3.9kW	7.6kW	8.5kW	7.6kW	8.5kW	8.5kW	11.1kW	10.3kW	12.6kW	
	Main breaker capacity	125.0A		150.0A		200.0A		225.0A		225.0A		250.0A		
	Primary power supply terminal screw size	M8		M8		M8		M8		M8		M8		
	Primary power supply wiring size	38.0mm²		50.0mm²		80.0mm²		100.0mm²		100.0mm²		100.0mm²		
	Earth wire screw size	M8		M8		M8		M8		M8		M8		
	Earth wire size	22.0mm²		30.0mm²		50.0mm²		50.0mm²		50.0mm²		100.0mm²		
	Required power capacity	43.3kVA		52.0kVA		69.3kVA		77.9kVA		77.9kVA		86.6kVA		*Molding machine only

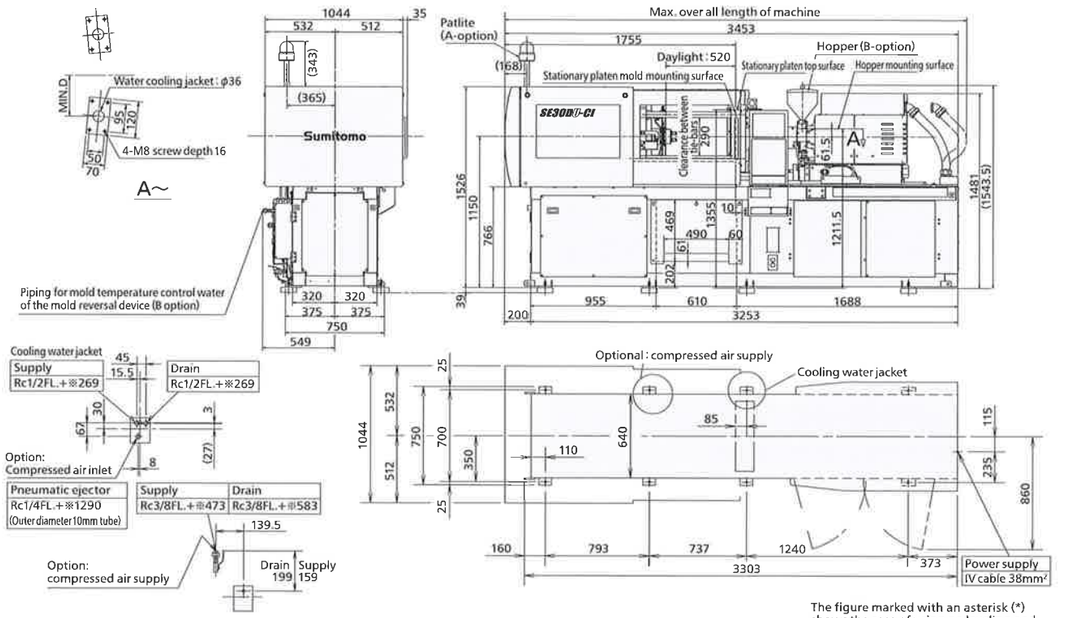
SE30DU-CI

Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.

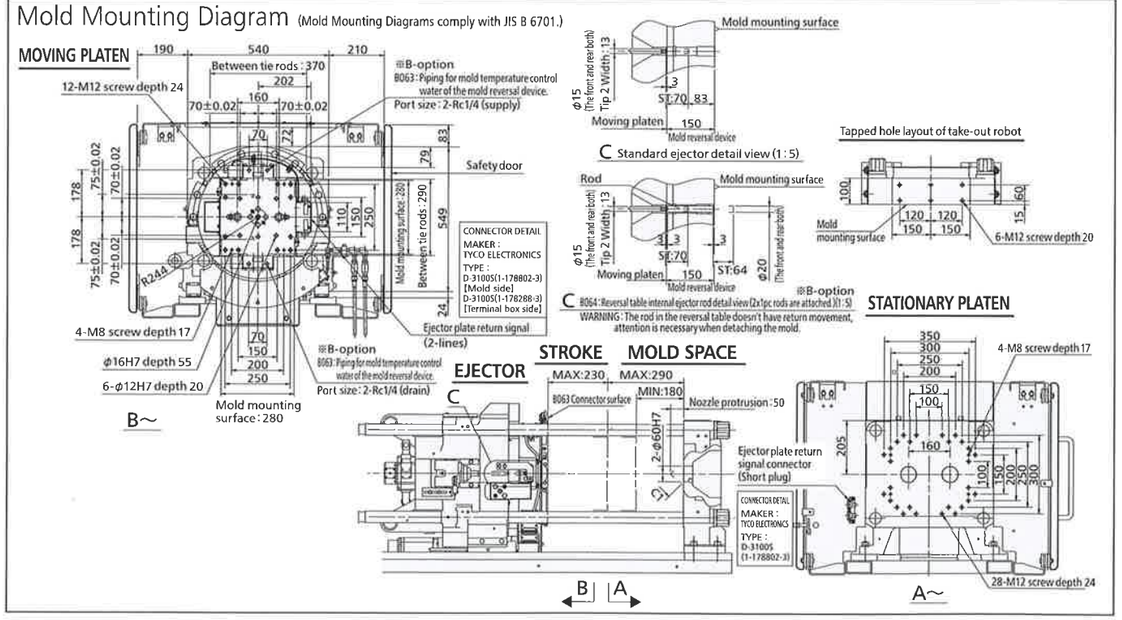
Injection unit	Screw diameter		A	B	C	D	Max. over all length of machine
C30	MN	16, 18	511	460	481	129	3479
		20	561	465	486	134	3517





The figure marked with an asterisk (*) shows the case of using no leveling pad.

Mold Mounting Diagram (Mold Mounting Diagrams comply with JIS B 6701.)



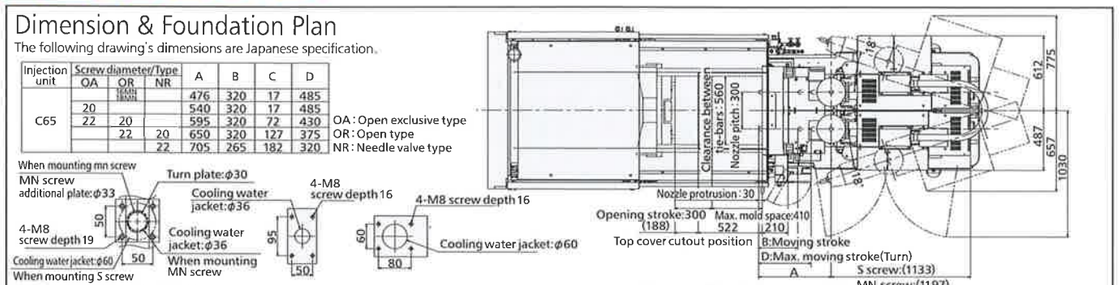
SE75DU-CI

Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.

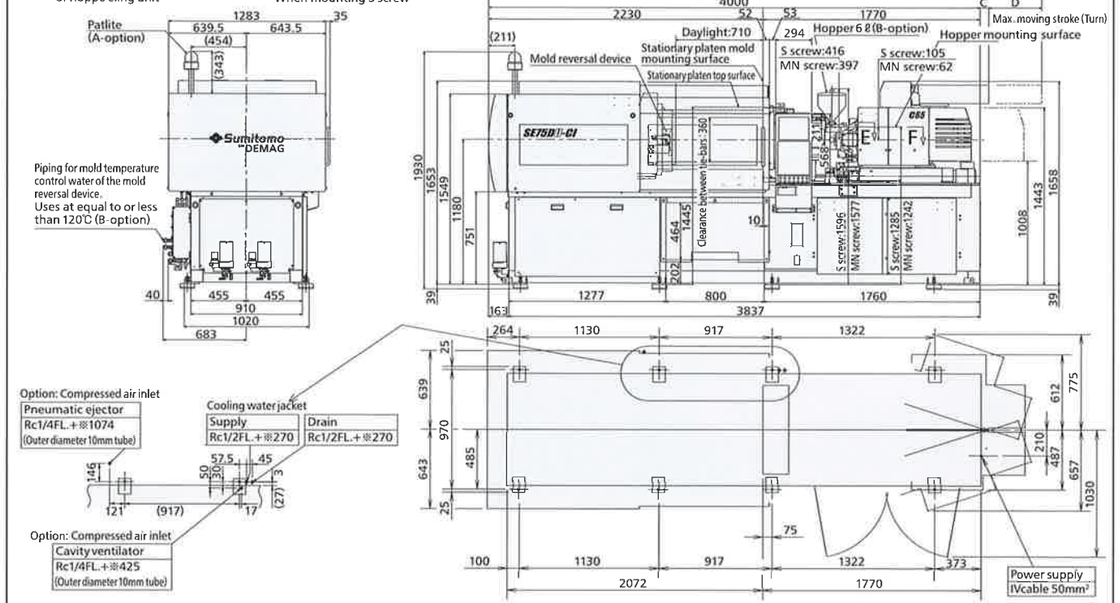
Injection unit	Screw diameter/Type OA	OR	NR	A	B	C	D
C65				476	320	17	485
	20			540	320	17	485
	22	20		595	320	72	430
		22	20	650	320	127	375
			22	705	265	182	320

OA: Open exclusive type
OR: Open type
NR: Needle valve type



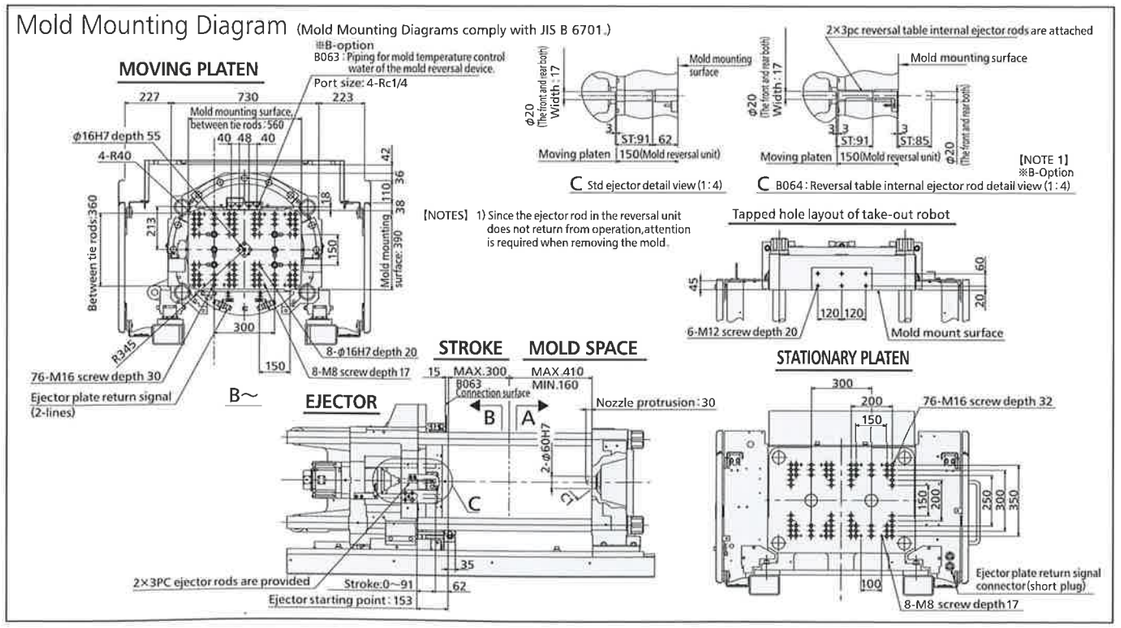
E~ When selecting hopper 6ℓ or hoppe eling unit

F~ When mounting MN screw When mounting S screw



The figure marked with an asterisk (*) shows the case of using no leveling pad.

Mold Mounting Diagram (Mold Mounting Diagrams comply with JIS B 6701.)



SE130DU-CI

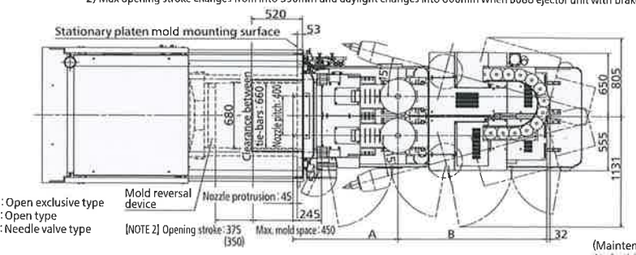
Dimension & Foundation Plan

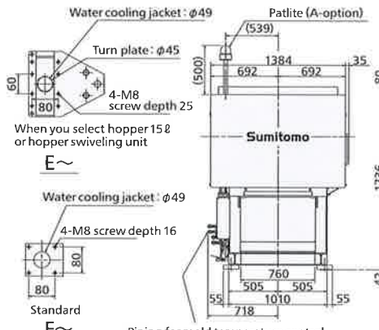
The following drawing's dimensions are Japanese specification.

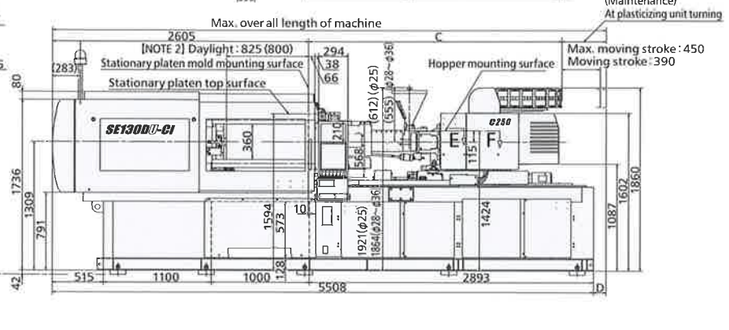
Injection unit		Screw diameter/Type OA	OR	NR	A	B	C	D	Max. over all length of machine
C250	M	25			654	1618	2309	-194	5508
			25		704		2309	-144	5508
				25	794		2399	-54	5508
		28			744		2259	-194	5508
			28		794		2309	-144	5508
		32			834		2349	-104	5508
			32	28	884	1528	2399	-54	5508
		36			924		2439	-14	5508
			36	32	974		2489	36	5544
				36	1064		2579	126	5634

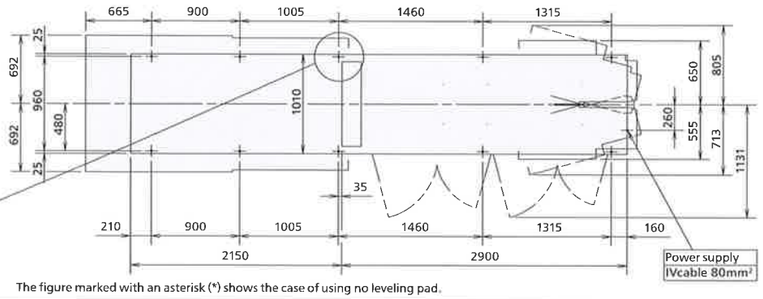
【NOTES】 1) Mechanical overall length dimension is applied, when selects the same F&R injection unit and screw.
When selects different F&R injection unit and screw, refer to the bigger dimension.
2) Max opening stroke changes from into 350mm and daylight changes into 800mm when B088 ejector unit with brake is selected.

OA : Open exclusive type
OR : Open type
NR : Needle valve type



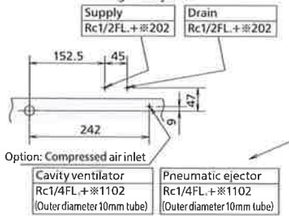






Cooling water jacket

Supply	Drain
Rc1/2FL.+※202	Rc1/2FL.+※202

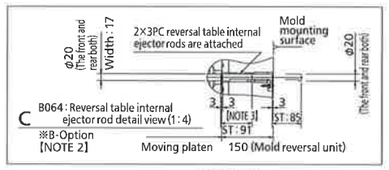


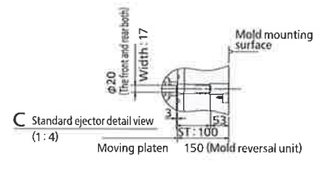
Cavity ventilator	Pneumatic ejector
Rc1/4FL.+※1102 (Outer diameter 10mm tube)	Rc1/4FL.+※1102 (Outer diameter 10mm tube)

The figure marked with an asterisk (*) shows the case of using no leveling pad.

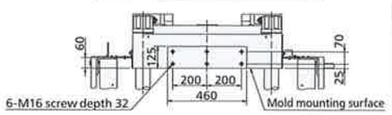
Mold Mounting Diagram (Mold Mounting Diagrams comply with JIS B 6701.)

【NOTES】 3) When removing a mold, because reversal table internal ejector rod doesn't return operation.
4) The ejector stroke is shorter when the rotary plate with embedded ejector rods are selected.



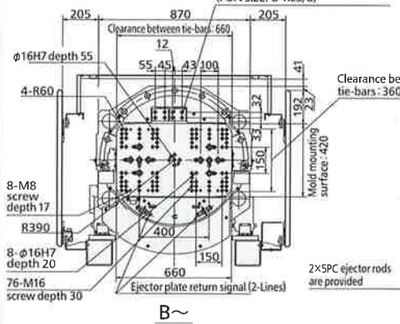


Tapped hole layout of take-out robot

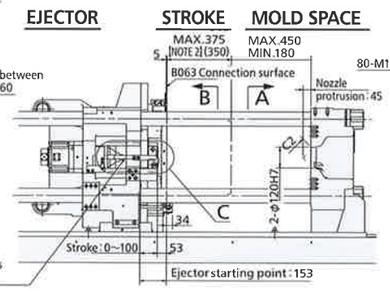


MOVING PLATEN

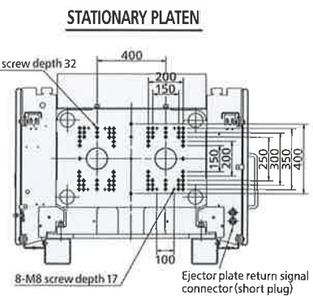
※B-Option
B063 : Piping for mold temperature control water of the mold reversal device (Port size: 8-Rc3/8)



EJECTOR / STROKE / MOLD SPACE



STATIONARY PLATEN



SE230HS-CI

Plasticizing unit		Screw / type OA	OR	NR	E	F	G	M	Max. over all length of machine
C250	M	28			390	450	2527	-69	6403
			28				2537	-59	
		32					2617	21	6424
			32	28			2627	31	6434
		36					2707	111	6514
			36	32			2717	121	6524
				36			2807	211	6614

Plasticizing unit		Screw / type OA	OR	NR	E	F	G	M	Max. over all length of machine
C360	M	32			440	655	2772	381	6784
			32			645	2782		
				32		555	2872		
		36				655	2772		
			36			645	2782		
		40				565	2862		
			40	36		555	2872		
				40		500	2962	416	6819

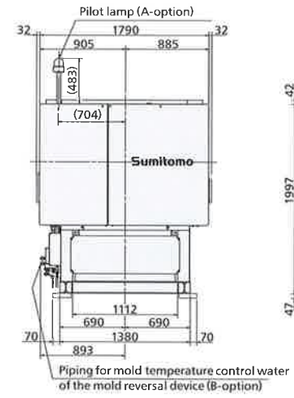
Plasticizing unit		Screw / type OA	OR	NR	E	F	G	M	Max. over all length of machine
C510	M	40			440	500	2927	381	6784
			40				2937	391	6794
		45					3017	471	6874
			45	40			3027	481	6884
		50					3107	561	6964
			50	45			3117	571	6974
				50			3207	661	7064

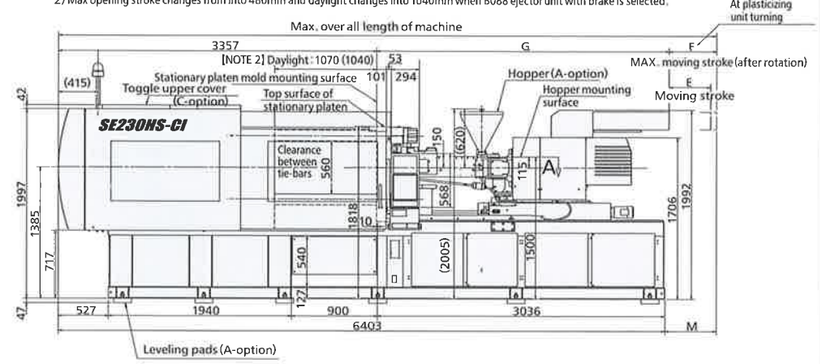
OA : Open exclusive type
OR : Open type
NR : Needle valve type changeable type

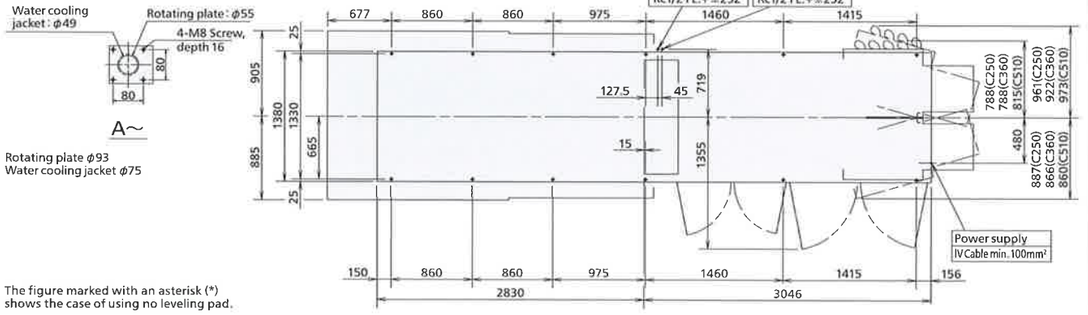
Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.

【NOTES】 1) Mechanical overall length dimension is applied, when selects the same F&R injection unit and screw.
When selects different F&R injection unit and screw, refer to the bigger dimension.
2) Max opening stroke changes from into 480mm and daylight changes into 1040mm when B088 ejector unit with brake is selected.



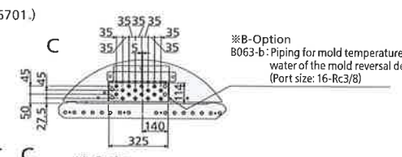


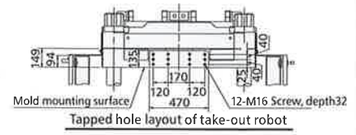


The figure marked with an asterisk (*) shows the case of using no leveling pad.

Mold Mounting Diagram

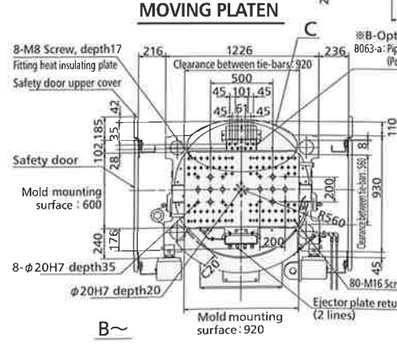
(Mold Mounting Diagrams comply with JIS B 6701.)



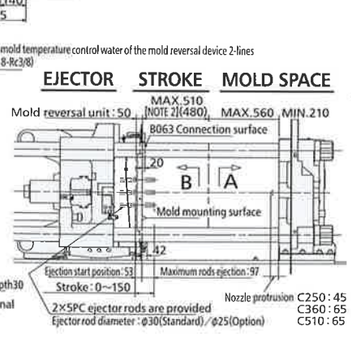


Tapped hole layout of take-out robot

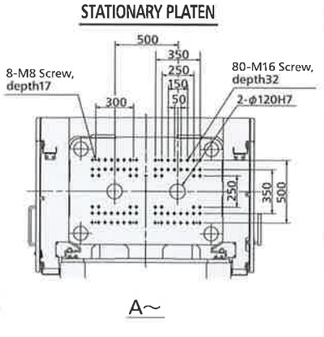
MOVING PLATEN



EJECTOR / STROKE / MOLD SPACE



STATIONARY PLATEN



SE280HS-CI

Plasticizing unit	Screw / type			E	F	G	M	Max. over all length of machine
	OA	OR	NR					
C250 M	28			390	450	2527	-69	6403
		28				2537	-59	
	32					2617	21	6424
		32	28			2627	31	6434
	36					2707	111	6514
		36	32			2717	121	6524
			36			2807	211	6614

Plasticizing unit	Screw / type			E	F	G	M	Max. over all length of machine
	OA	OR	NR					
C360 M	32			440		655	2772	6784
		32				645	2782	
			32			555	2872	
	36					655	2772	
		36				645	2782	
	40					565	2862	
		40	36			555	2872	
			40			500	2962	6819

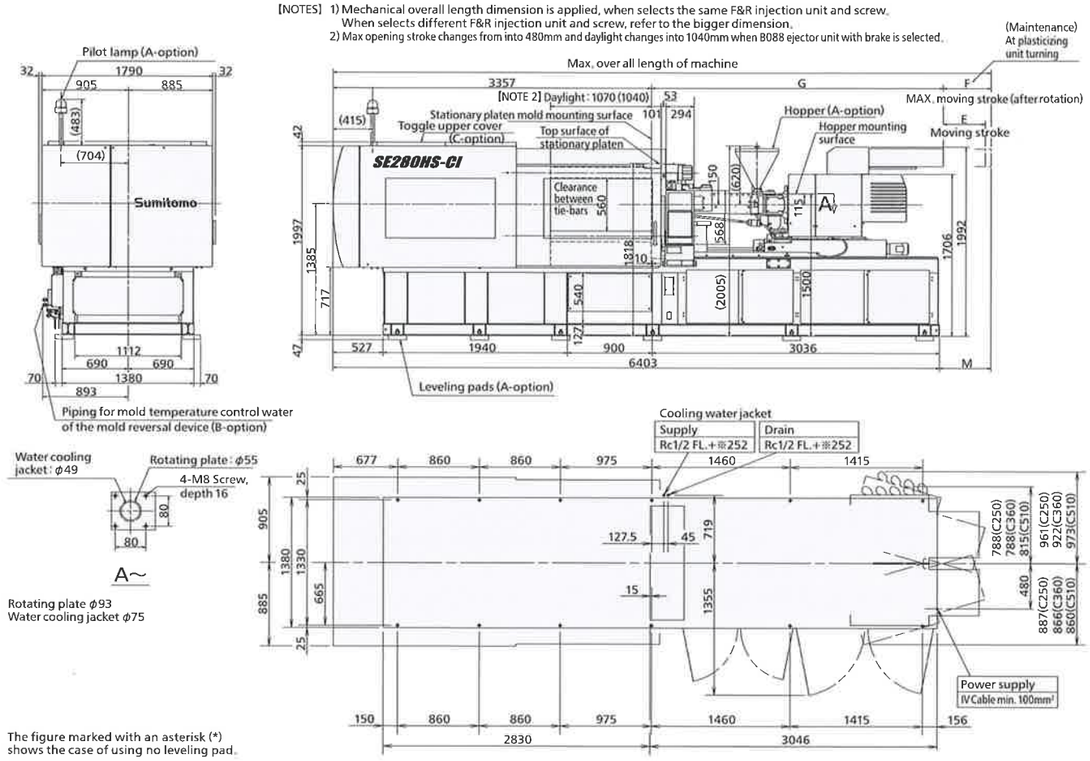
Plasticizing unit	Screw / type			E	F	G	M	Max. over all length of machine
	OA	OR	NR					
C510 M	40			440	500	2927	381	6784
		40				2937	391	6794
	45					3017	471	6874
		45	40			3027	481	6884
	50					3107	561	6964
		50	45			3117	571	6974
			50			3207	661	7064

OA : Open exclusive type
OR : Open type
NR : Needle valve changeable type

Dimension & Foundation Plan

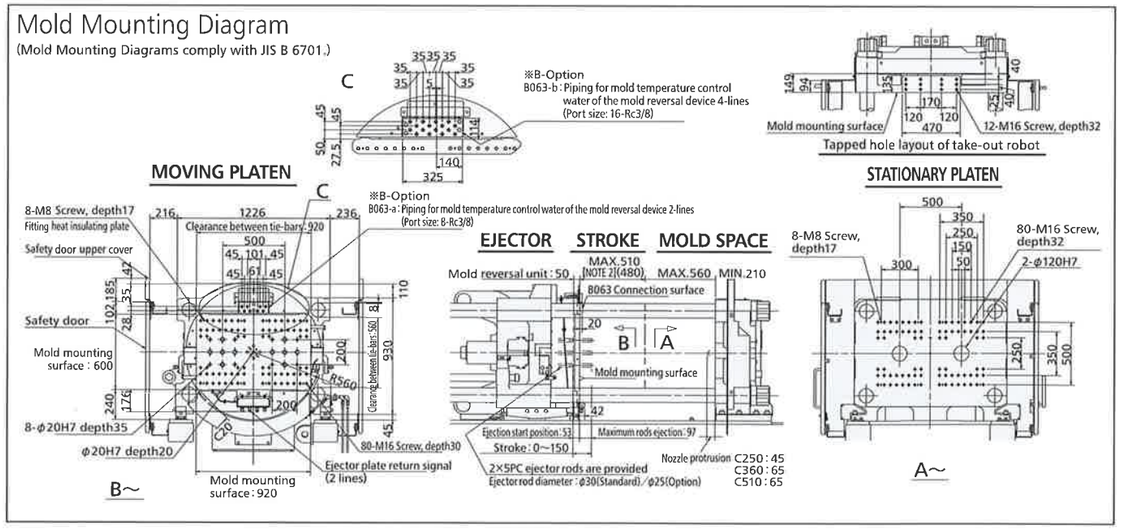
The following drawing's dimensions are Japanese specification.

【NOTES】 1) Mechanical overall length dimension is applied, when selects the same F&R injection unit and screw.
When selects different F&R injection unit and screw, refer to the bigger dimension.
2) Max opening stroke changes from into 480mm and daylight changes into 1040mm when B088 ejector unit with brake is selected.



Mold Mounting Diagram

(Mold Mounting Diagrams comply with JIS B 6701.)



Double-shot

SE400HS-CI

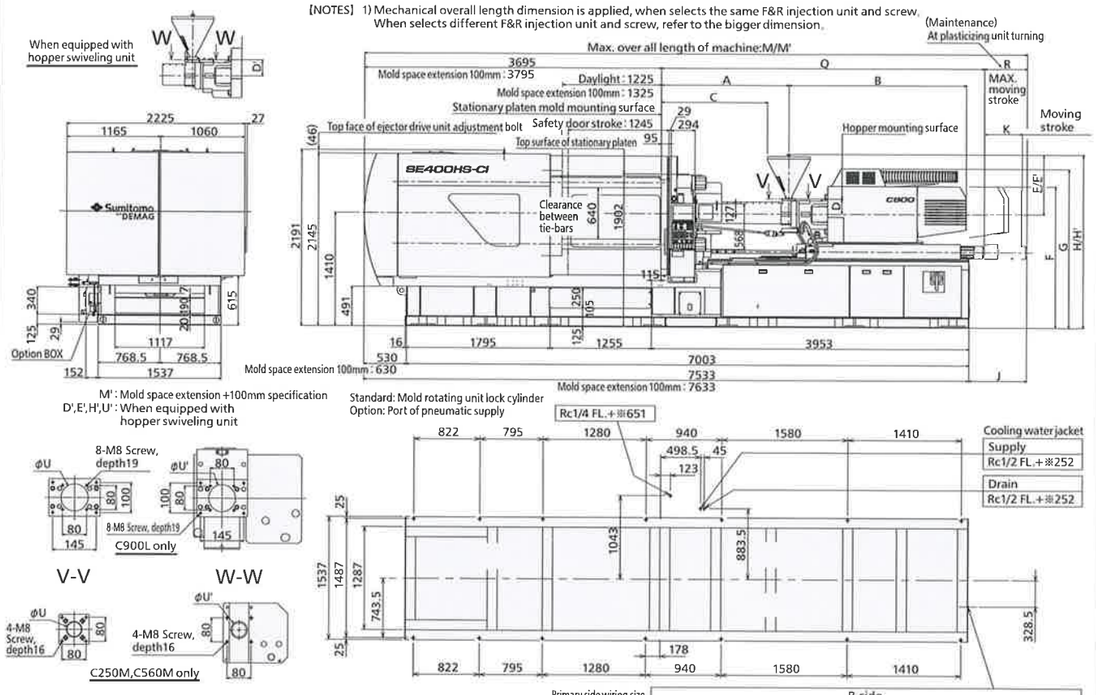
Injection unit	Screw diameter OR	Screw diameter NR	A	B	C	D	D'	E	E'	F	G	H	H'	J	K	M	M'	Q	R	T	U	U'
C250M	28		729	1459	462	155	140	711	696	1701	1978	2121	2106	-698	470	7533	7633	2320	530	20°	52	56
		28	839		572													2430				
	32		819		552													2410				
		32	929		662													2520				
	36		909		642													2500				
		36	1019		752													2610				
C560M	40		999	1723	732	155	140	711	696	1746	1977	2121	2106	-237	470	7533	7633	2782	530	20°	52	56
		40	1109		842													2892				
	45		1089		822													2872				
		45	1199		932													2982				
	50		1179		912													2962				
		50	1289		1022													3072				
C900L	45		1137	2212	870	189	202	745	777	1758	1977	2155	2187	717	470	7800	7900	3575	530	14°	56	93
	50	45	1267		1000											7930	8030	3705				
	56	50	1422		1160											8090	8190	3865				
		56	1587		1320											8250	8350	4025				

OR : Open type
NR : Needle valve changeable type

Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.

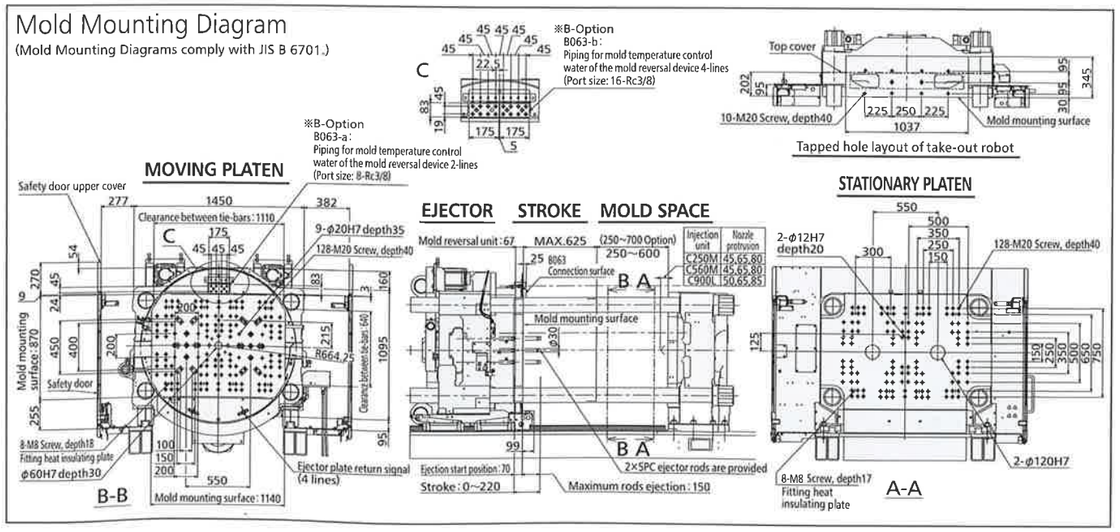
【NOTES】 1) Mechanical overall length dimension is applied, when selects the same F&R injection unit and screw.
When selects different F&R injection unit and screw, refer to the bigger dimension.



Primary side wiring size / Ground wire size		R side		
		C250	C560	C900
F side	C250	min. 100mm²	min. 100mm²	min. 100mm²
	C560	min. 100mm²	min. 100mm²	min. 175mm² or 50mm² ×2
	C900	min. 100mm²	min. 175mm² or 50mm² ×2	min. 175mm² or 50mm² ×2

Mold Mounting Diagram

(Mold Mounting Diagrams comply with JIS B 6701.)



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