

Global Network



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Double-shot

All-electric Double-shot Injection Molding Machine



Double-shot

All-electric Double-shot Injection Molding Machine



Lineup

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



Our products have acquired ISO9001 certification.

www.shi.co.jp/plastics/

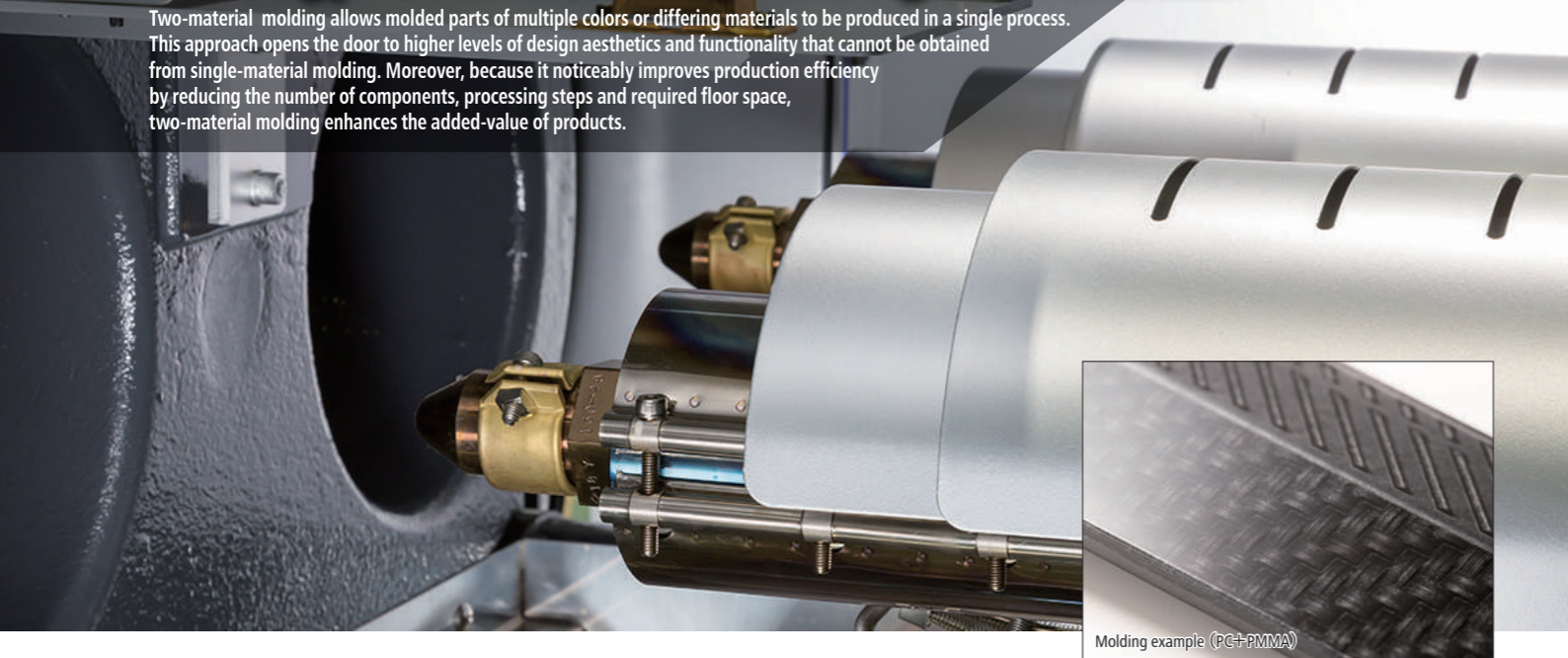


Sumitomo Heavy Industries, Ltd.

Pursuing greater possibilities of parts with the Double-shot

Enhancing product added-value by combining different materials

Two-material molding allows molded 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	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.
	Rotation speed	
Stable precision molding	Rotation precision	Tried-and-trusted components are on board. It is designed and built to answer the growing needs for thin-wall filling.
	Double Center Press Platens	
	SKII control	
Filling for thin-wall parts	Direct drive	Freedom of mold design and mountable weight is greatly increased, making possible to produce longer parts.
	High-speed injection	
	Flash mode/control	
Mold support	Wide platen	Freedom of mold design and mountable weight is greatly increased, making possible to produce longer parts.
	Proprietary temperature control piping	
Ease of setup/maintenance	Independently turning plasticizing units	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.
	Temperature control piping for rotary unit	
	N9 controller	

YouTube



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

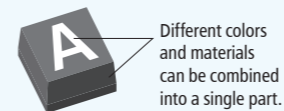
World's largest class of all-electric double-shot molding machines

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

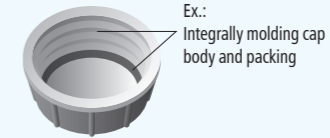
Combining different colors or grades of the same material or different materials entirely opens the door to new applications in molding that were not possible before.



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

Functionality

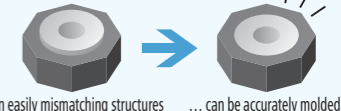
Molded parts can be given properties of resins with conflicting elements like improved sealing or resistance.



Ex.: Integrally molding cap body and packing

Dimensional accuracy

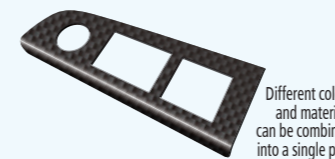
Since parts can be designed without consideration for downstream processing, dimensional variation caused by shrinkage is reduced. Moreover, improved dimensional stability can be expected in production of thinner-wall parts.



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

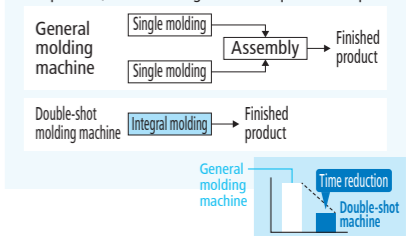
Strength and resistance to heat, weather and wear will be improved because the appropriate resin can be placed in the appropriate location.



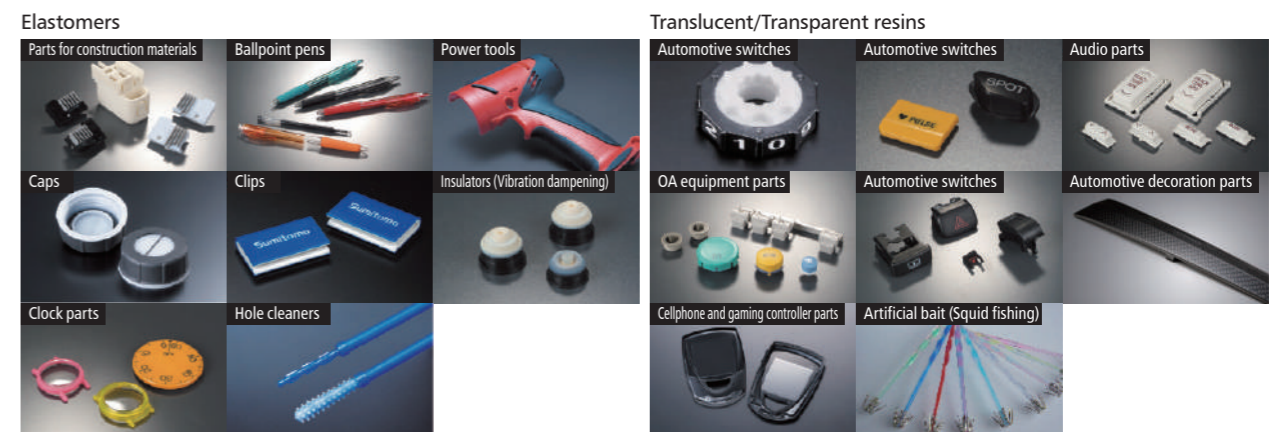
Ex.: Tray Shock-absorbing material is used on the outside to enhance durability.

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



Advantages of parallel type double-shot machine

Compared to vertically, horizontally and diagonally arranged layouts, there are many advantages to positioning injection units in 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

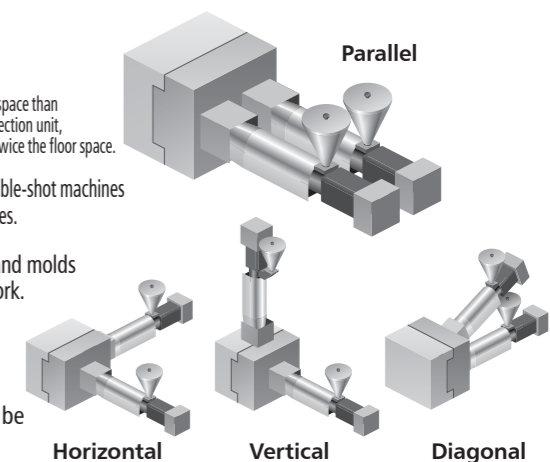
Use of integrated mold make it easy to align nozzles and molds so that injection units do not hamper maintenance work.

Shorter cycle times

More effective features to shorten cycle time is incorporated into machines.

Cleanroom compatible

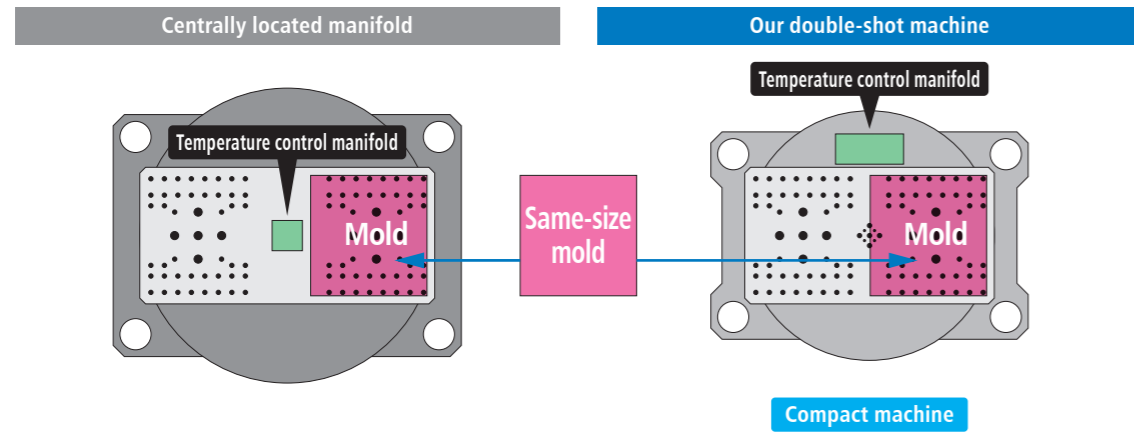
Safety door is hermetically sealed and gases can be easily recovered from the purging cover.



Production efficiency spawned from the 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.



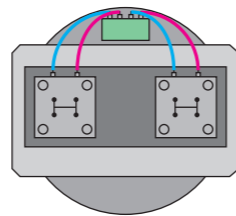
Temperature control piping on movable side for mold rotation

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.

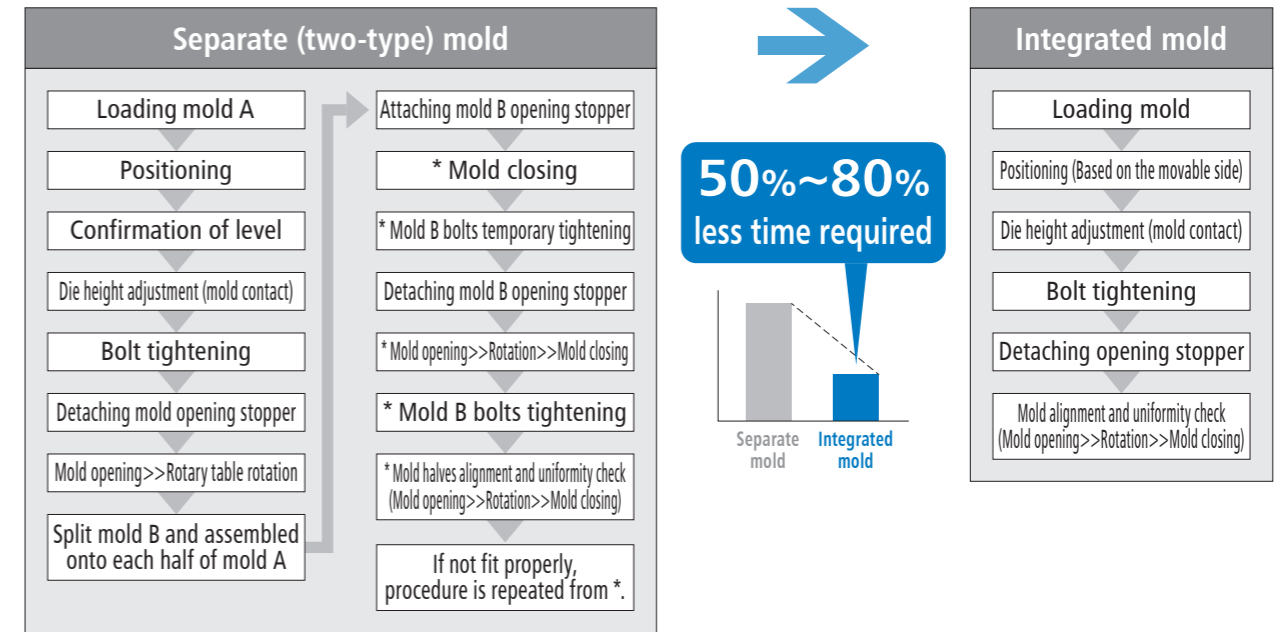
SE30DU-CI	1 line
SE75DU-CI	2 lines *4 lines
SE130DU-CI	2 lines *4 lines
SE230HS-CI	2&4 lines *8 lines
SE280HS-CI	2&4 lines *8 lines
SE400HS-CI	2&4 lines *8 lines

* Available upon request

Shorter setup time with integrated mold

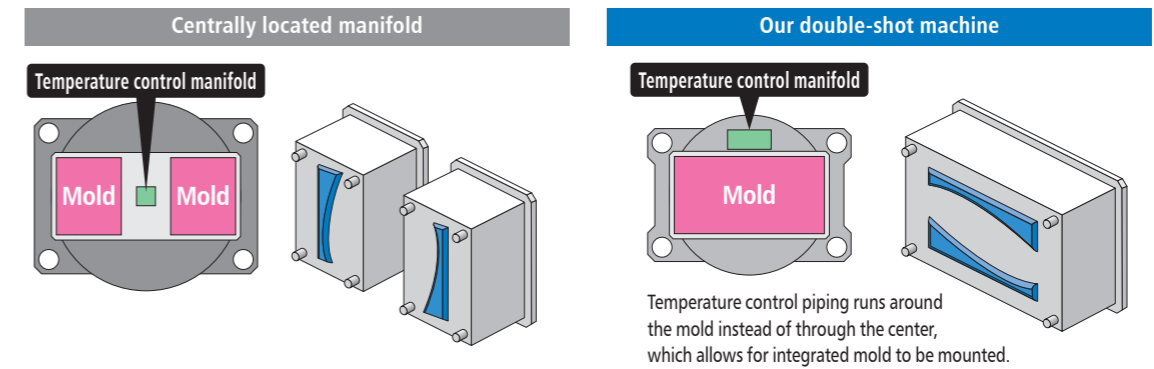
Thanks to an original design, our double-shot machine can easily mount large integrated mold. Compared to separate molds, integrated molds require considerably less time to set up, which translates into more efficient production operations.

Example comparison of mold mounting



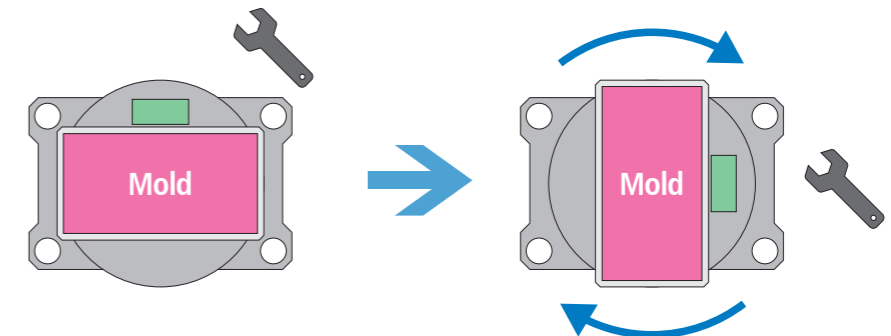
Long parts available thanks to wider range of mountable molds

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.



90° rotation stop feature that greatly improves workability

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.

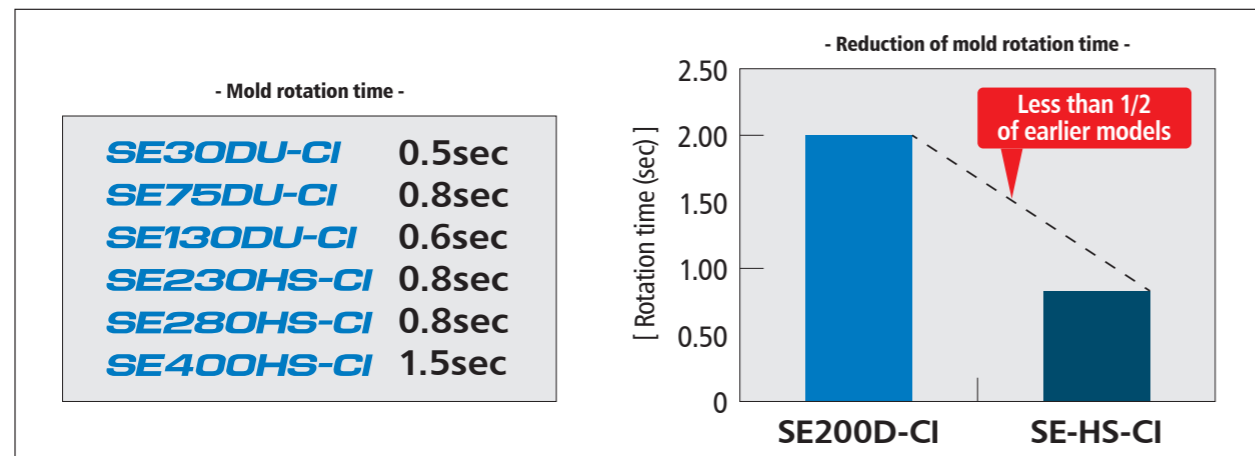


SE400HS-CI

Features designed for cycle time reduction

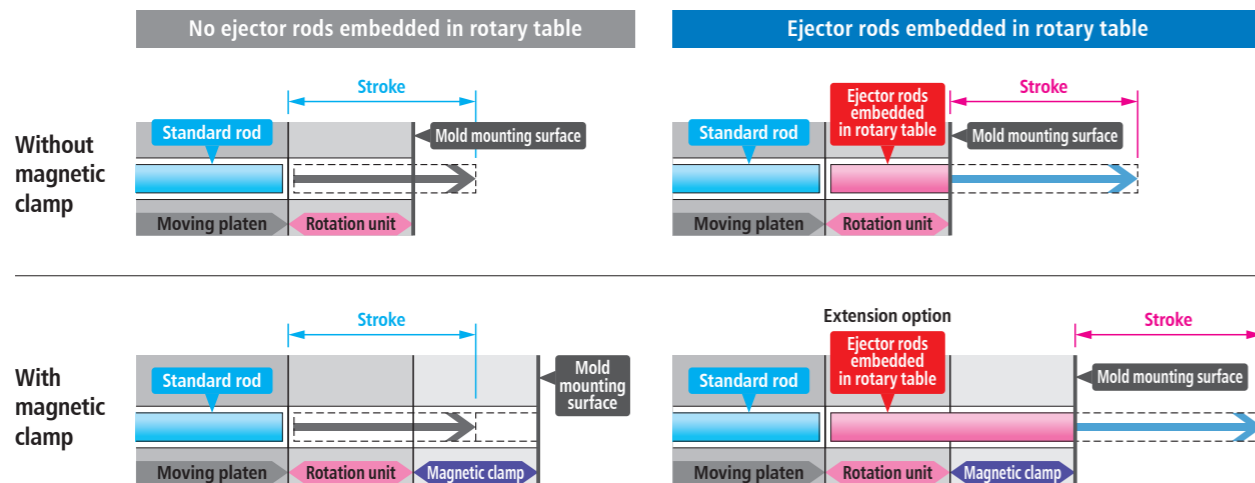
Greatly shortened mold rotation time

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.



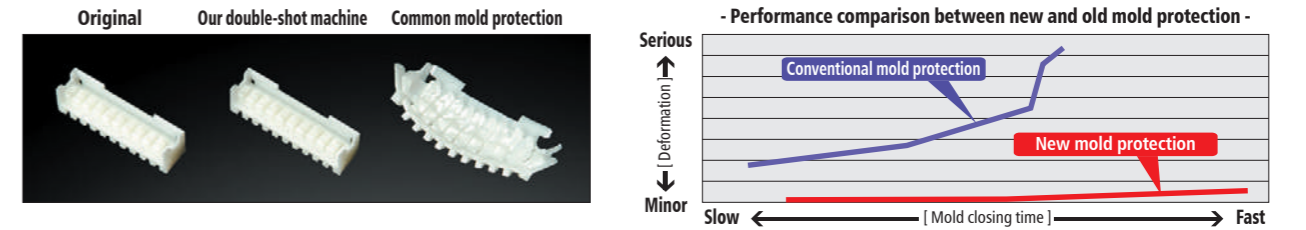
Ejector rods embedded in the rotary table

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.



Example of mold protection settings

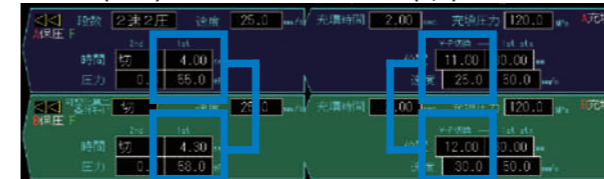
Settings for mold opening and closing:

- 型開閉位置: 300.00 mm
- 型開時間: 2.39 sec
- サイクル時間: 29.3 sec
- エジェクタ位置: 0.0 mm
- 型閉時間: 2.34 sec
- 総エジェクタ時間: 1.29 sec
- 反転位置: 180.0 deg
- 反転時間: 1.63 sec
- 型締力: 830 kN

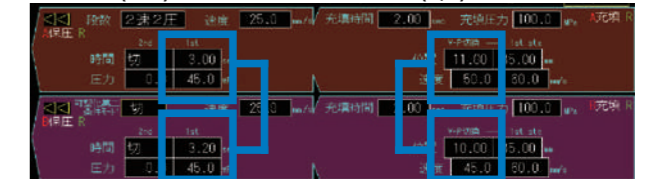
Additional settings for mold opening and closing:

- 型開限: 2nd 35.0, 1st 10.0 mm
- 速度: 30.0, 20.0, 10.0 %
- 位置: 35.0, 20.0, 1.30 mm
- 速度: 30.0, 20.0, 10.0 %
- 位置: 20.0 mm
- 圧力: 20 %

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



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



Rotating mode setting

Rotating mode settings interface showing various parameters for mold rotation.

Rotation timing priority

Rotation timing priority settings interface, including trigger selectability between rotating action or ejector action.

Applicable to various filling patterns

Interface showing mold filling patterns and associated parameters.

Logging display easy to monitor molds separately

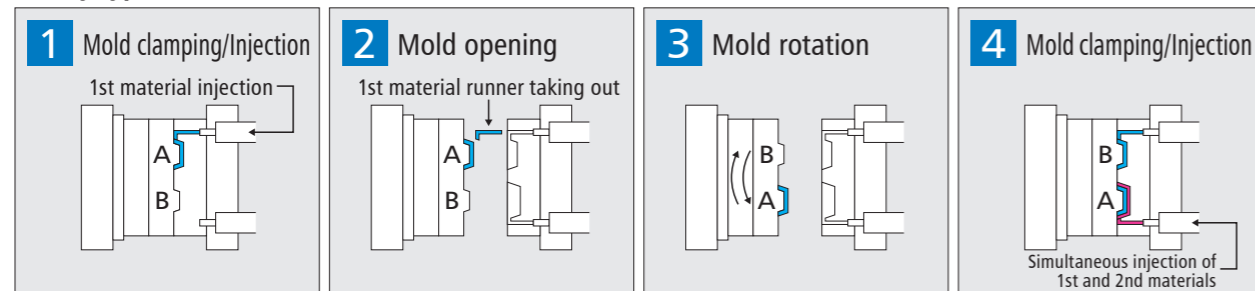
Logging display interface for monitoring mold performance separately.

Capability for a wide range of molding processes and special resins

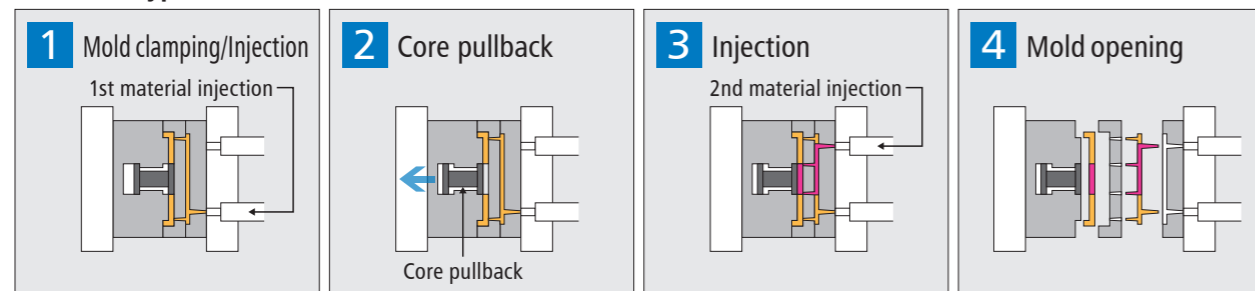
Diverse molding processes support molding complex shaped parts

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

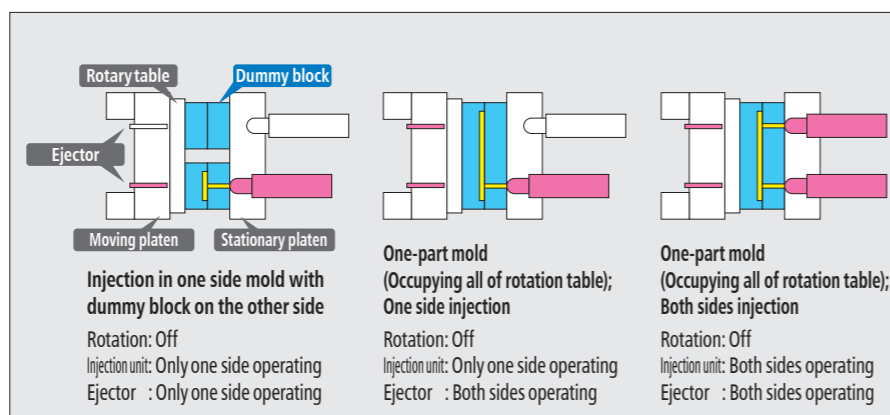


Core back type Optional



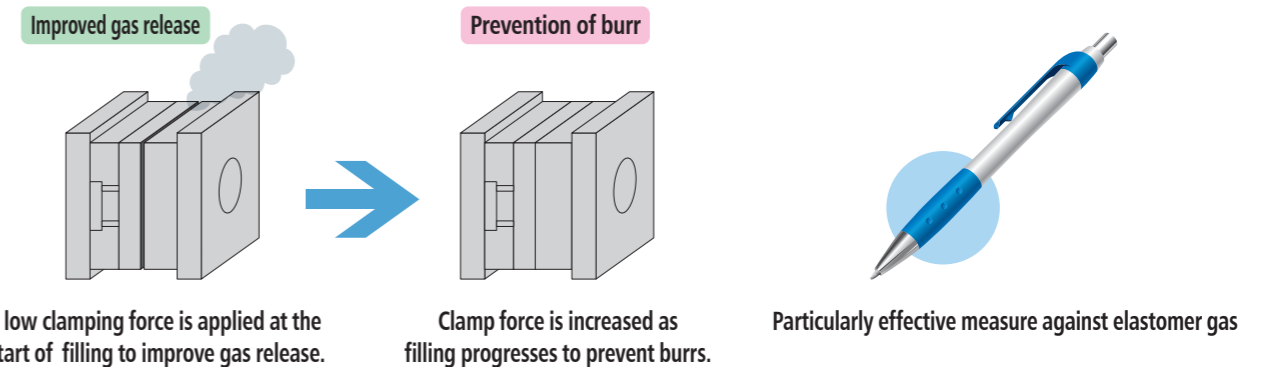
Single-color molding

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



Multi-toggle

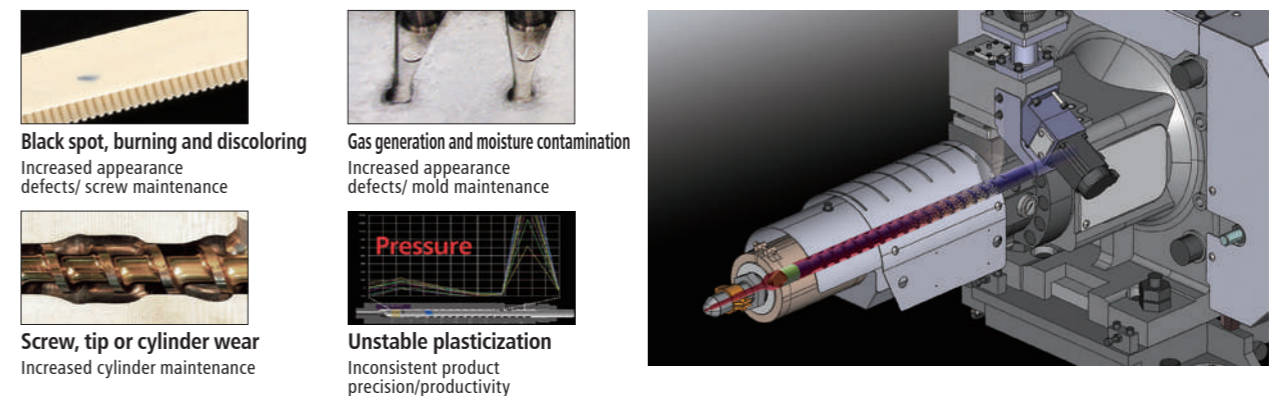
Multi-toggle is a mechanism that applies a low clamp force at the start of filling and then increases pressure as filling progresses. It improves gas release, prevents burrs from forming and lessens the frequency of mold cleaning. These benefits are especially appreciated in two-material molding where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



SL Screw Optional

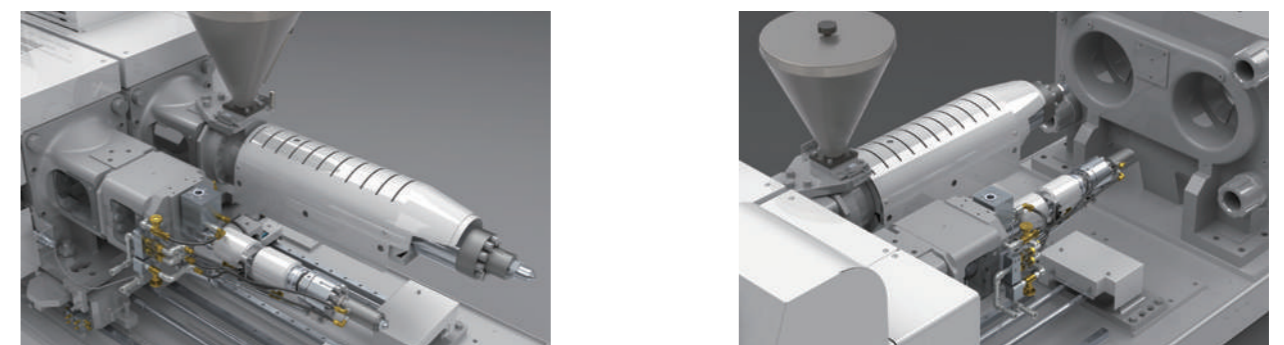
A new plasticizing system with a screw as the core, which was designed after visually analyzing the resin melting behavior against temperature and pressure with previous screws. It prevents melt resin stagnation and subsequent carbonization, and releases gas and moisture to realize stable plasticization.

Defects improved or solved by SL Screw



LSR molding supported Optional

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
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■ Clamp unit

Clamp system		Double toggle (5 points)	Double toggle (5 points)	Double toggle (5 points)
Clamp force max.	kN	290	730	1270
Clearance between tie bars (WxH)	mm	370 x 290	560 x 360	660 x 360
Dimensions of rotary table (WxH)	mm	280 x 280	560 x 390	660 x 420
Daylight	mm	520	710	825 (800) ^{*5}
(When mold thickness extension 100 mm is selected)	mm	—	—	—
Mold opening stroke	mm	230	300	375 (350) ^{*5}
Platen speed max.	mm/s	1200	1300	1200
Mold thickness (Min. - Max.)	mm	180~290	160~410	180~450
(When mold thickness extension 100 mm is selected)	mm	—	—	—
Locating ring diameter	mm	2-φ60	2-φ60	2-φ120
(Locating ring with inner diameter φ100 selected)	mm	—	—	—
Ejector system		Motor driven type (1 point) x 2	Motor driven type (3 points) x 2	Motor driven type (5 points) x 2
Ejector force	kN	7.8 x 2	20 x 2	21 x 2
(When ejector force power up is selected)	kN	—	—	—
Ejector speed max.	mm/s	333	333	333
Ejector stroke	mm	70	91	100 (91) ^{*6}
Ejector rod protrusion amount	mm	-83 (61) ^{*6}	-62 (82) ^{*6}	-53 (82) ^{*6}
Max. mold weight (Fixed side)	kg	50	175 x 2	300 x 2
Max. mold weight (Movable side)	kg	100	200 x 2	250 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
Injection pressure max. ^{*1,*2}	MPa	266	210	170	266	210	235	194	281	284	217	171
Holding pressure max. ^{*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 mass (GPPS)	g	11	13	17	11	13	26	32	54	83	108	137
Plasticizing rate ^{*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		
Injection speed max.	mm/s	500			500				300			
Screw rotating speed max.	min ⁻¹	430			400				400			
Number of temperature control zone		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 contact force	kN	2.9			5.8				A 11 / B 14 ^{*7}			
Protrusion	mm	30 / 50			30 / 45 / 65 / 80				45 / 65 / 85			
Hopper capacity (When the standard hopper selected)	L	(2.5 x 2)			(6.0 x 2)				(15 x 2)			

■ Machine dimensions and mass

Machine dimensions (LxWxH) ^{*4}	mm	3453 x 1079 x 1526	4017 x 1318 x 1658	5508 x 1419 x 1860
(When mold thickness extension 100 mm is selected)	mm	—	—	—
Machine mass	t	3.0	5.0	7.6

*1 The max. injection pressure and max. hold pressure are calculated values and represent machine output, not resin pressure.

*2 The max. injection pressure and max. hold pressure are not sustained pressure levels.

*3 The plasticizing rate is shown for a machine equipped with SD Screw.

*4 The total length of the machine is to the front end of the injection unit when mounting the screw of the smallest diameter.

*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 plasticizing device is selected, it is necessary to select both sides.

(This restriction does not apply to the SE400HS-CI.)

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

● The dimensions are Japanese specification.

◇ This series originally comply to safety standards of Japan, the US, in addition, also China GB22530 and KC mark.

SE230HS-CI	SE280HS-CI	SE400HS-CI
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Double toggle (5 points)	Double toggle (5 points)	Double toggle (5 points)
2250	2740	4000
920 x 560	920 x 560	1110 x 640
920 x 600	920 x 600	1140 x 870
1070 (1040) ^{*5}	1070 (1040) ^{*5}	1225
—	—	(1325)
510 (480) ^{*5}	510 (480) ^{*5}	625
1200	1200	1200
210~560	210~560	250~600
—	—	(250~700)
2-φ120	2-φ120	2-φ120
—	—	(2-φ100)
Motor driven type (5 points) x 2	Motor driven type (5 points) x 2	Motor driven type (9 points) x 2
45 x 2	45 x 2	60 x 2
—	—	100 x 2
333	333	267
150	150	220
97	97	150
750 x 2	750 x 2	1650 x 2
500 x 2	500 x 2	1300 x 2

C250 ^{*8}			C360			C510			C250 ^{*8}			C360			C510			C250			C560			C900		
M			M			M			M			M			M			M			M			L		
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
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
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
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
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
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
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
140			160			160			140			160			160			140			160			207		
300			300			300			300			300			300			350			350			350		
400			400			400			400			400			400			400			400			400		
5			5			5			5			5			5			5			5			6		
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
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}		
45			45 / 65			45 / 65			45			45 / 65			45 / 65			45 / 65 / 80			45 / 65 / 80			50 / 65 / 85		
(30 x 2)						(30 x 2)						(C003:30 x 2) (C003a:50 x 2)														

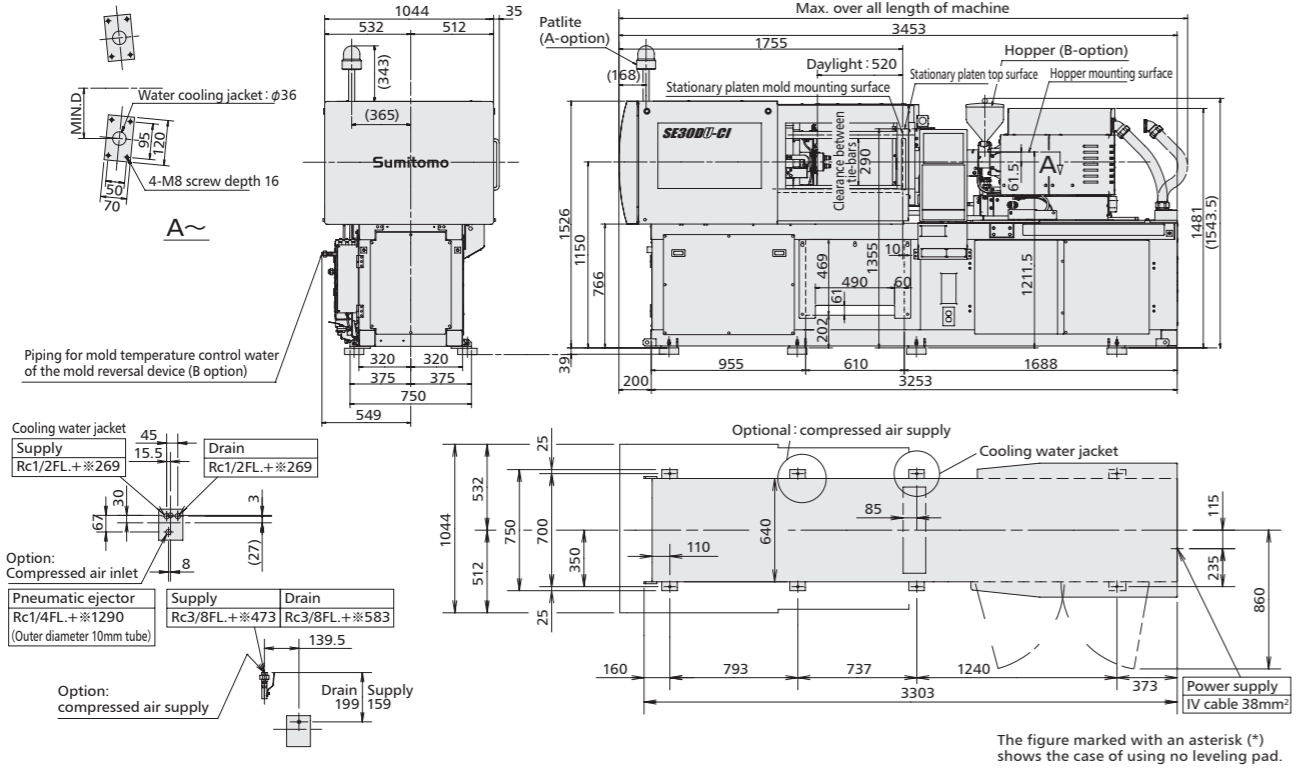
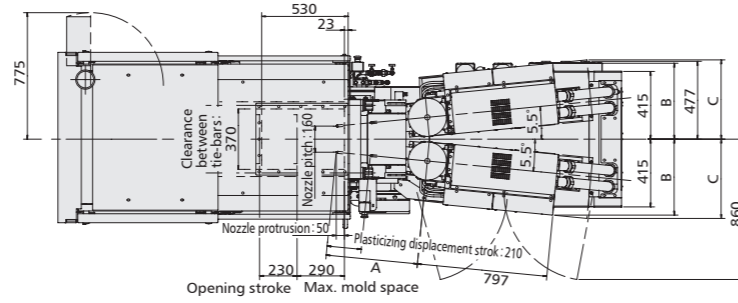
6403 x 1854 x 1997	6403 x 1854 x 1997	7533 x 2252 x 2191
—	—	(7633 x 2252 x 2191)
17.0	17.0	25.1
		26.1
		27.5

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.

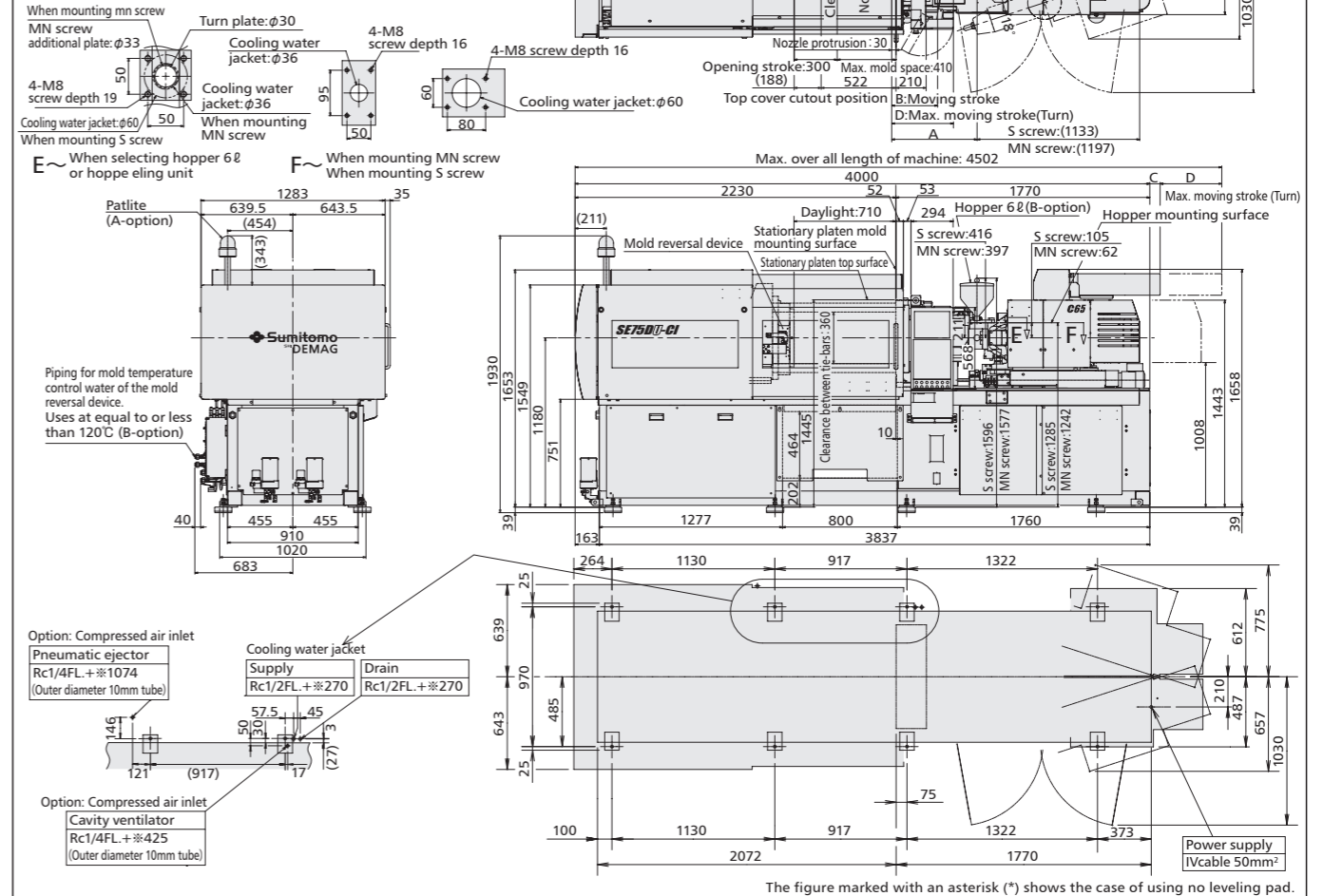
SE75DU-CI

Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.

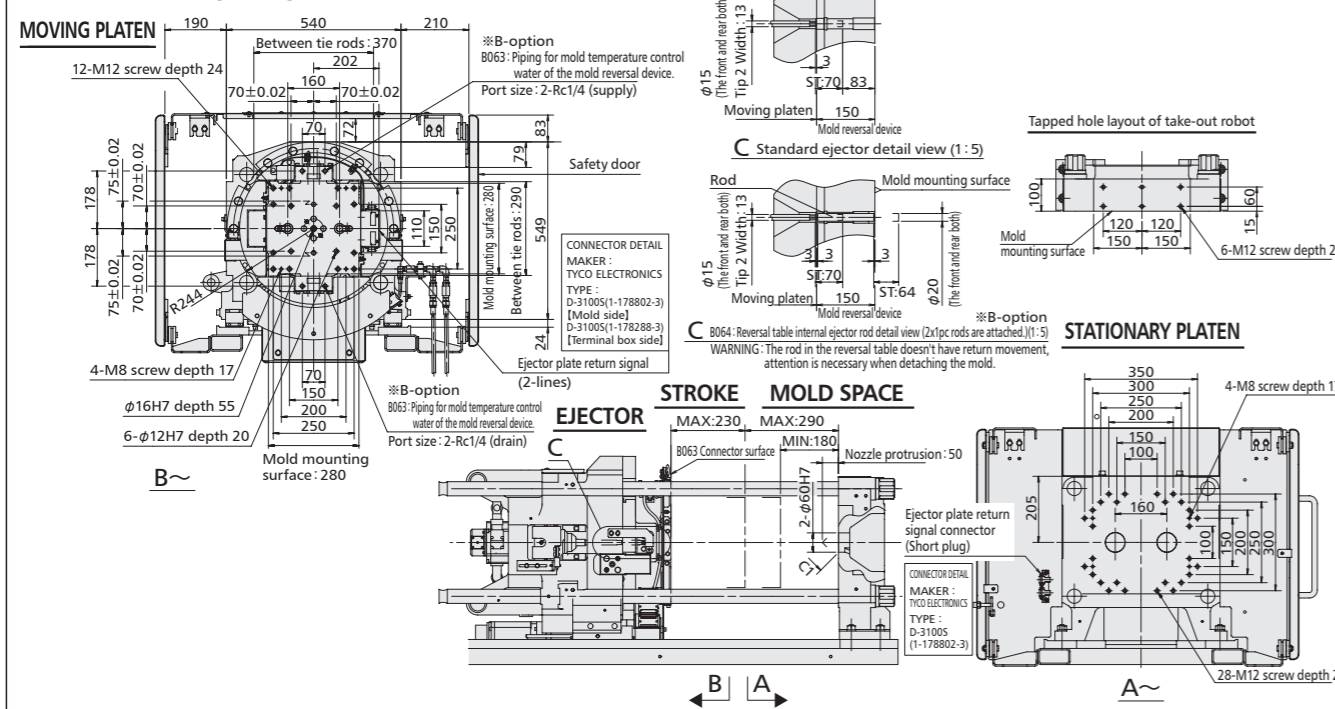
Injection unit	Screw diameter/Type			A	B	C	D
	OA	OR	NR				
C65	18	NR		476	320	17	485
	20			540	320	17	485
	22			595	320	17	430
	22			650	320	127	375
				705	265	182	320

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

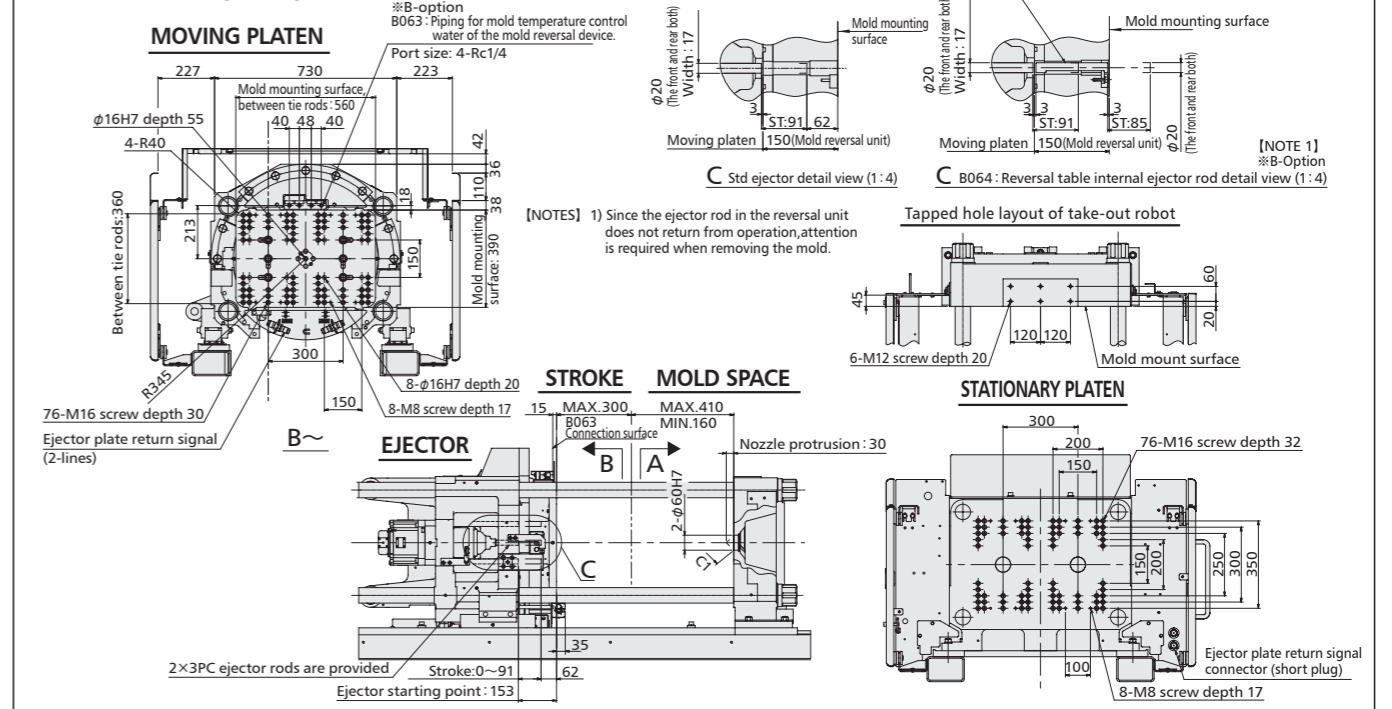


The figure marked with an asterisk (*) shows the case of using no leveling pad.

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



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



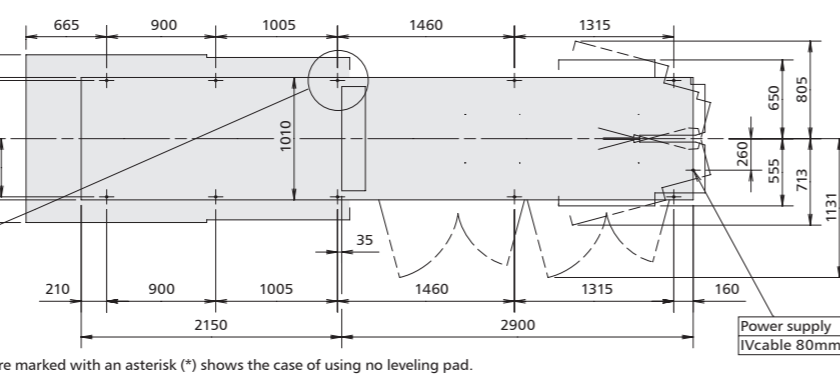
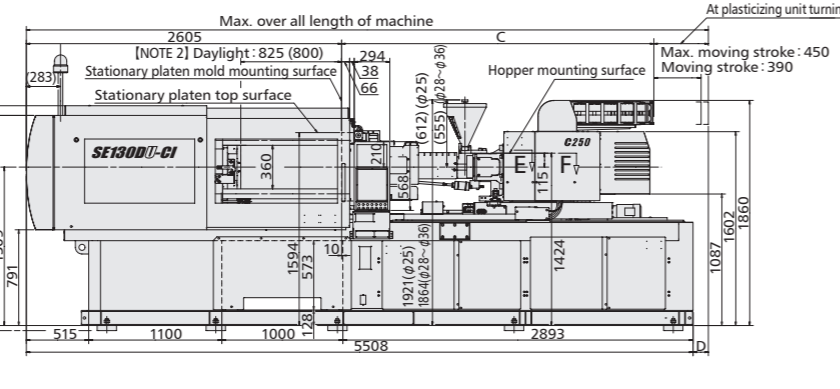
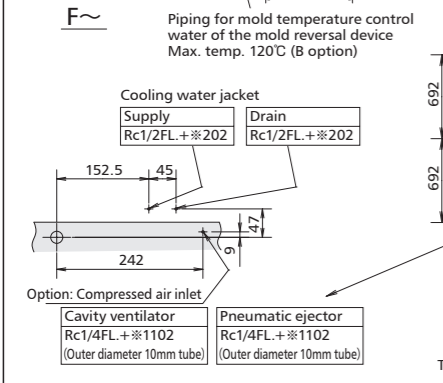
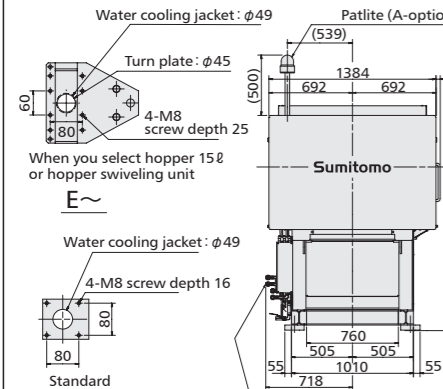
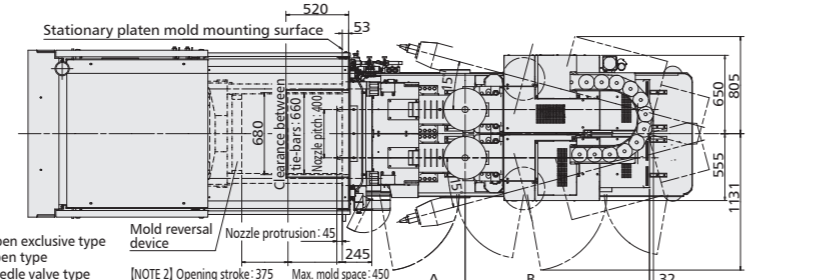
SE130DU-CI

Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.

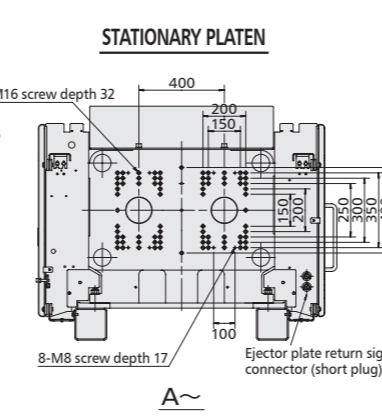
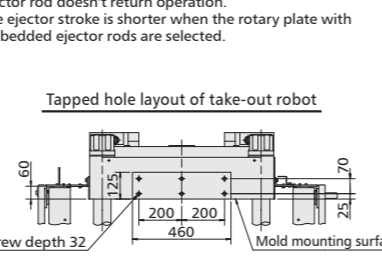
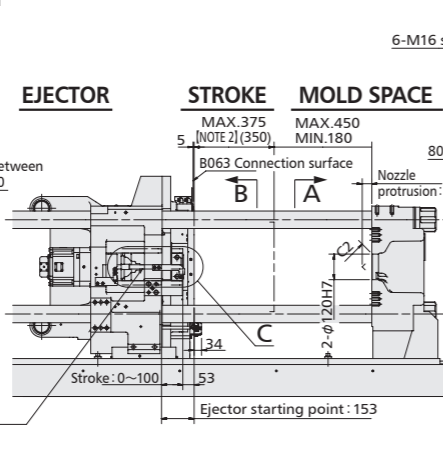
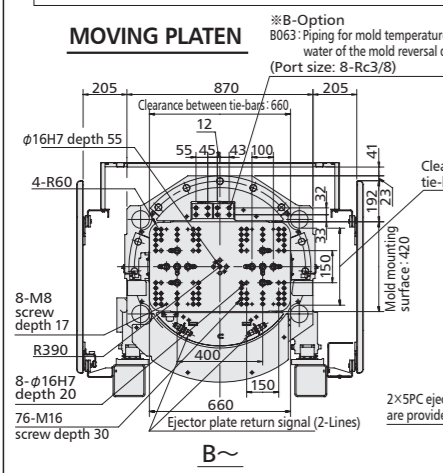
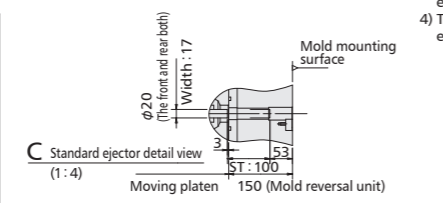
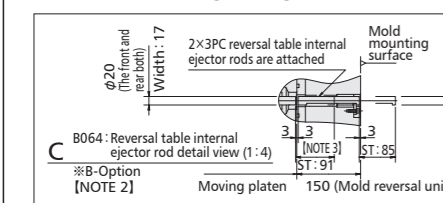
Injection unit	Screw diameter/Type	A B C D				Max. over all length of machine	
		OA	OR	NR			
C250	M	25	654	2259	-194	5508	
		25	704	2309	-144	5508	
		25	794	2399	-54	5508	
		28	744	2259	-194	5508	
		28	794	2309	-144	5508	
		32	834	2349	-104	5508	
		32 28	884	1528	2399	-54	5508
		36	924	2439	-14	5508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



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.

SE230HS-CI

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

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

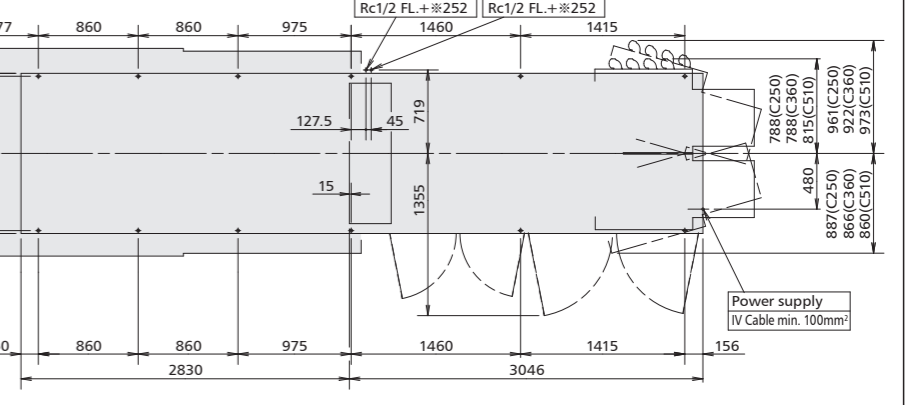
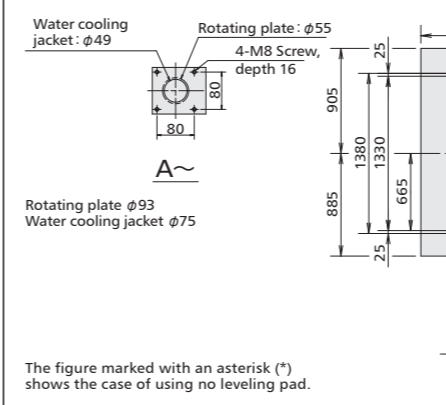
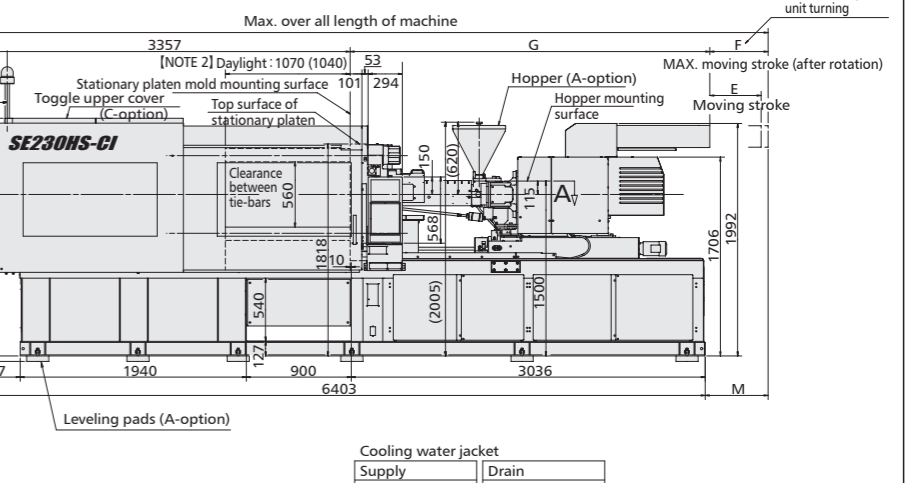
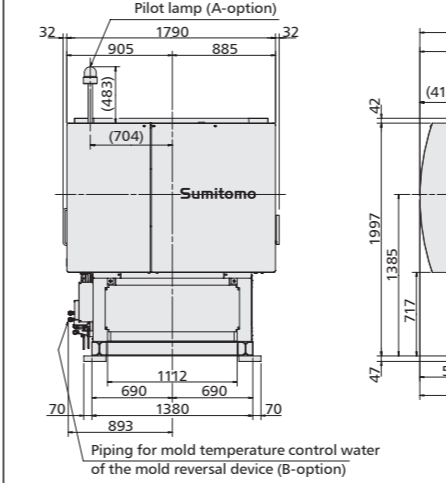
Plasticizing unit	Screw / type	E F G M				Max. over all length of machine		
		OA	OR	NR				
C510	M	40				2927	381	6784
		40				2937	391	6794
		45				3017	471	6874
		45 40	440	500		3027	481	6884
		50				3107	561	6964
		50 45				3117	571	6974
					3207	661	7064	

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

Dimension & Foundation Plan

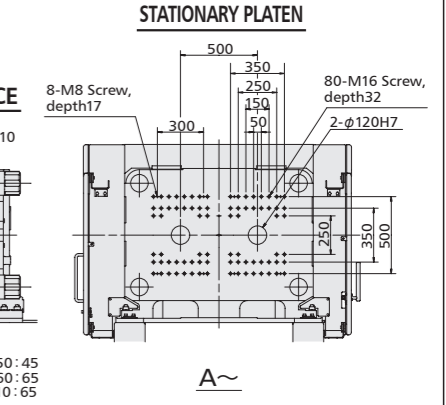
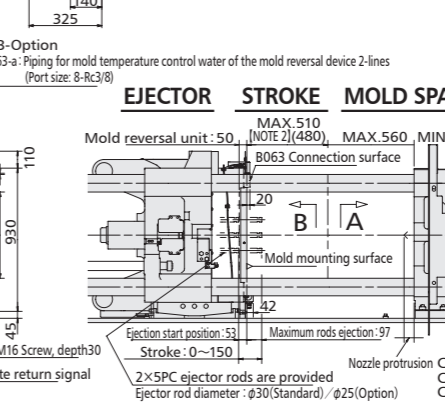
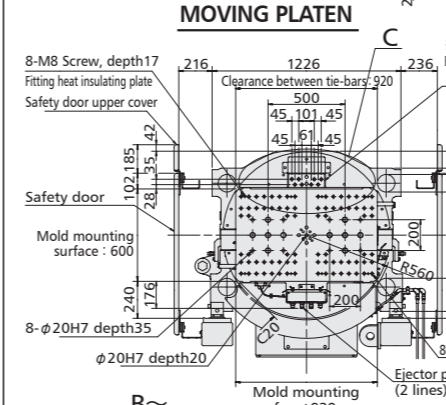
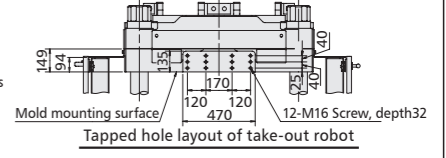
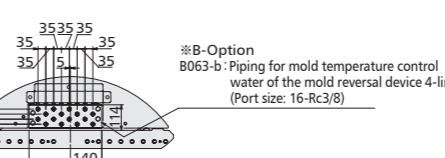
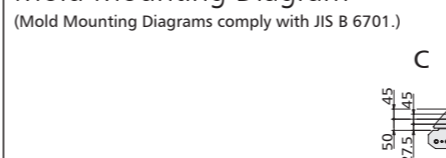
The following drawing's dimensions are Japanese specification.

[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.



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.)



SE280HS-CI

Plasticizing unit	Screw / type	E	F	G	M	Max. over all length of machine		
C250	M	28			2527	-69	6403	
		32			2537	-59		
		36			2617	21	6424	
	M	32	28	390	450	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		
C360	M	32			655	2772		
		36			645	2782		
		40			555	2872		
	M	36		440	655	2772	381	6784
		40			645	2782		
		40	36			565	2862	
		40	36		555	2872		
		40			500	2962	416	6819

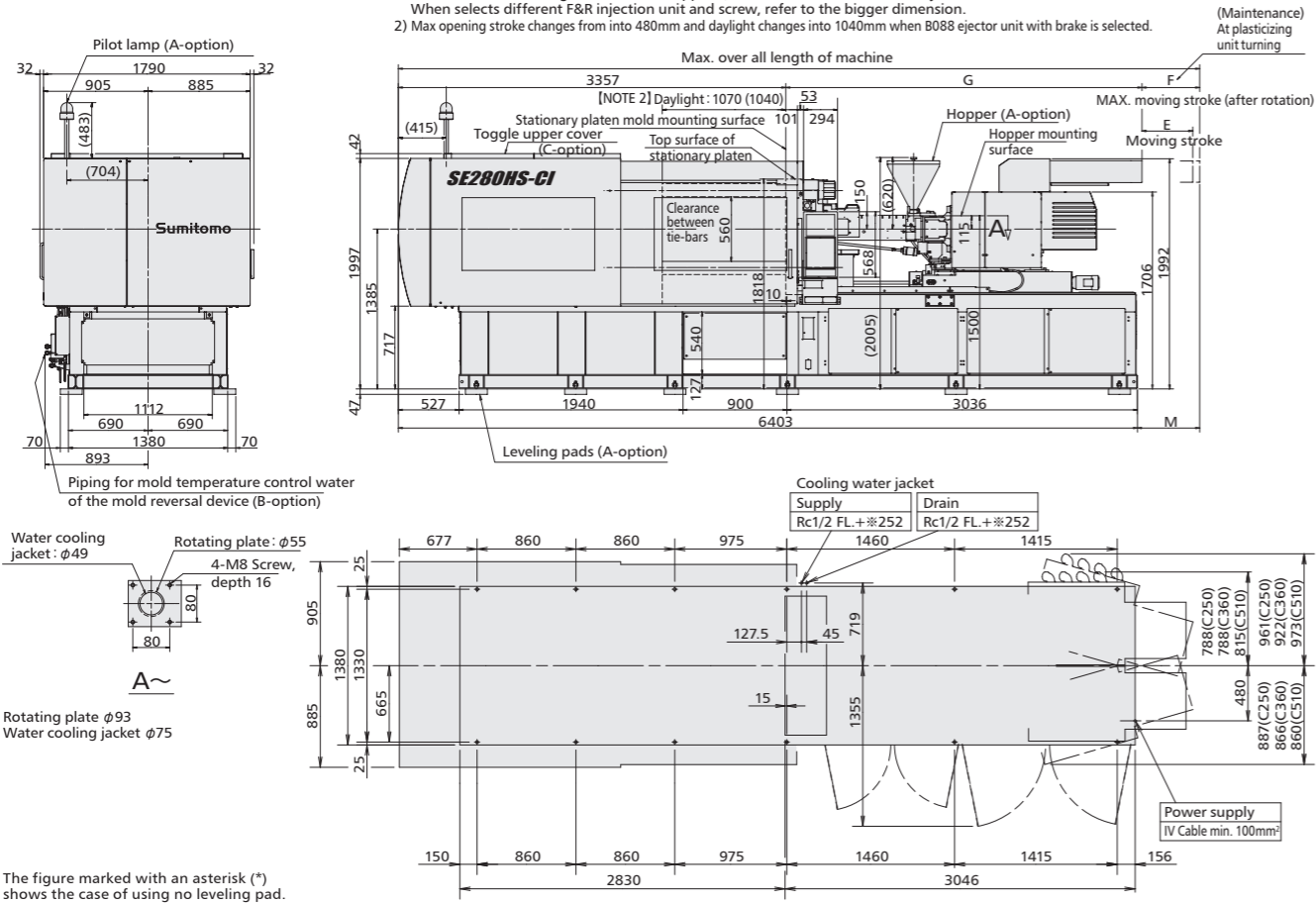
Plasticizing unit	Screw / type	E	F	G	M	Max. over all length of machine		
C510	M	40			2927	381	6784	
		45			2937	391	6794	
		50			3017	471	6874	
	M	45	40	440	500	3027	481	6884
		50				3107	561	6964
		50	45			3117	571	6974
		50			3207	661	7064	

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.



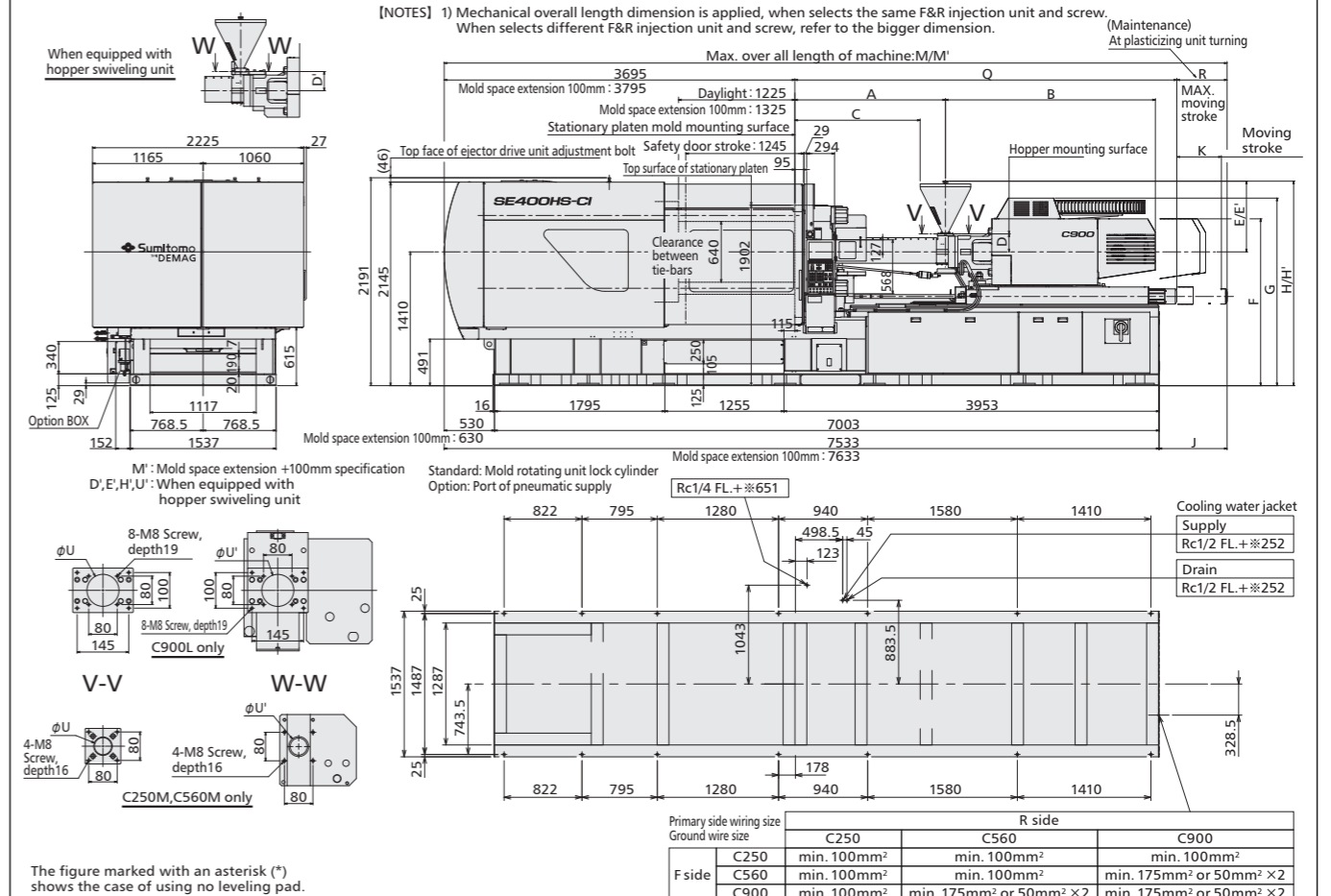
SE400HS-CI

Injection unit	Screw diameter	A	B	C	D	D'	E	E'	F	G	H	H'	J	K	M	M'	Q	R	T	U	U'	
C250M	28	729		462													2320					
	28	839		572													2410					
	32	929	1459	662	155	140	711	696	1701	1978	2121	2106	-698	470	7533	7633	530	20'	52	56		
	36	909		642													2500					
	40	1019		752													2610					
	40	999		732													2682					
C560M	45	1089	1723	822	155	140	711	696	1746	1977	2121	2106	-237	470	7533	7633	530	20'	52	56		
	45	1199		932													2872					
	50	1289		1022													2982					
	50	1267		1000													3072					
	45	1137		870													7800	7900	3575			
	50	1267		1000													8090	8190	3665	530	14'	56
56	1347	2212	1160	189	202	745	777	1758	1977	2155	2187	717	470	8250	8350	4025						
56	1587		1320																			

OR: Open type
NR: Needle valve changeable type

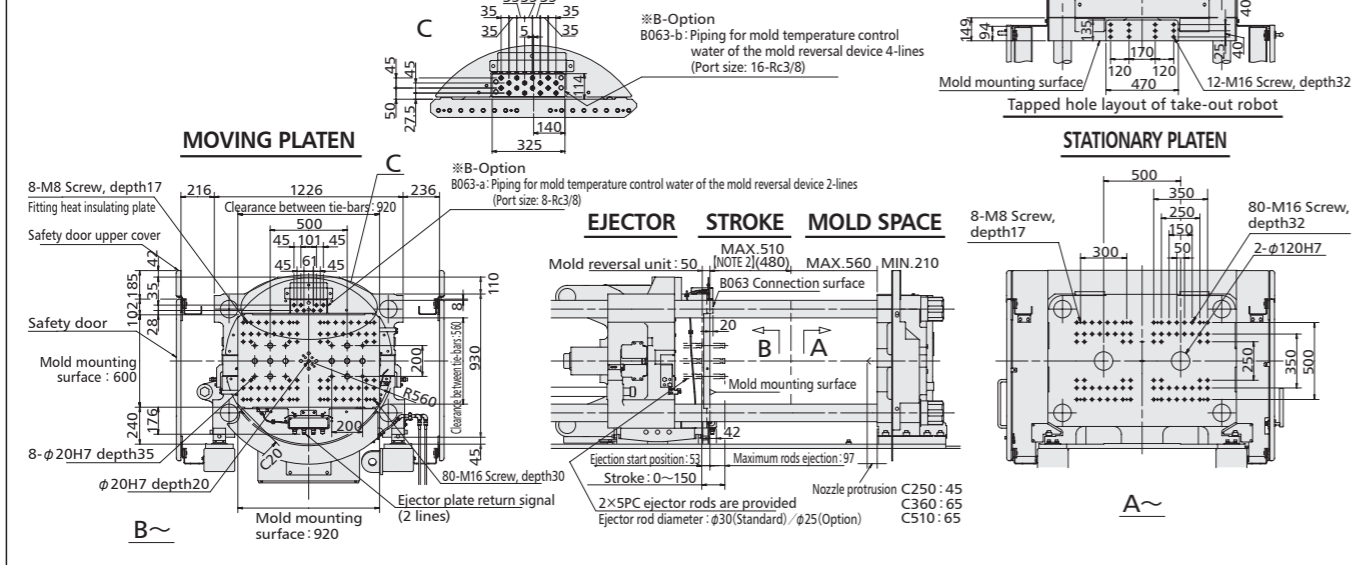
Dimension & Foundation Plan

The following drawing's dimensions are Japanese specification.



Mold Mounting Diagram

(Mold Mounting Diagrams comply with JIS B 6701.)



Mold Mounting Diagram

(Mold Mounting Diagrams comply with JIS B 6701.)

