

Leshan 乐善

Blow Molding Machine

K
ECONOMIC



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K SERIES

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



GENERAL FEATURES

- 1、 Could work with PE,PP,EVA etc.
- 2、 There are three working mode for K series: manual, semi-automatic or automatic .
- 3、 world-known brand components for pneumatic, hydraulic and electrical parts, components are reliable and long-last.
- 4、 precise die head, hot melt plastic flows smoothly inside the channel, no dead angle lead to dark spot.
- 5、 Optimized hydraulic system, carriage movement is smooth and fast, low power consumption, simplified parameter setting.
- 6、 Invertor to control motor, the speed of screw is changeable.



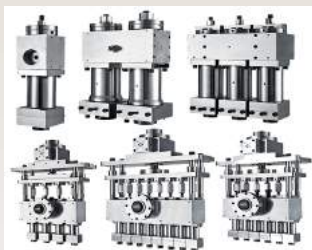
Leshan 乐善

Key
highlights

+
Die Head

Multiple choice for die head

We provide single head, double head, triple head, four head, six head and eight head

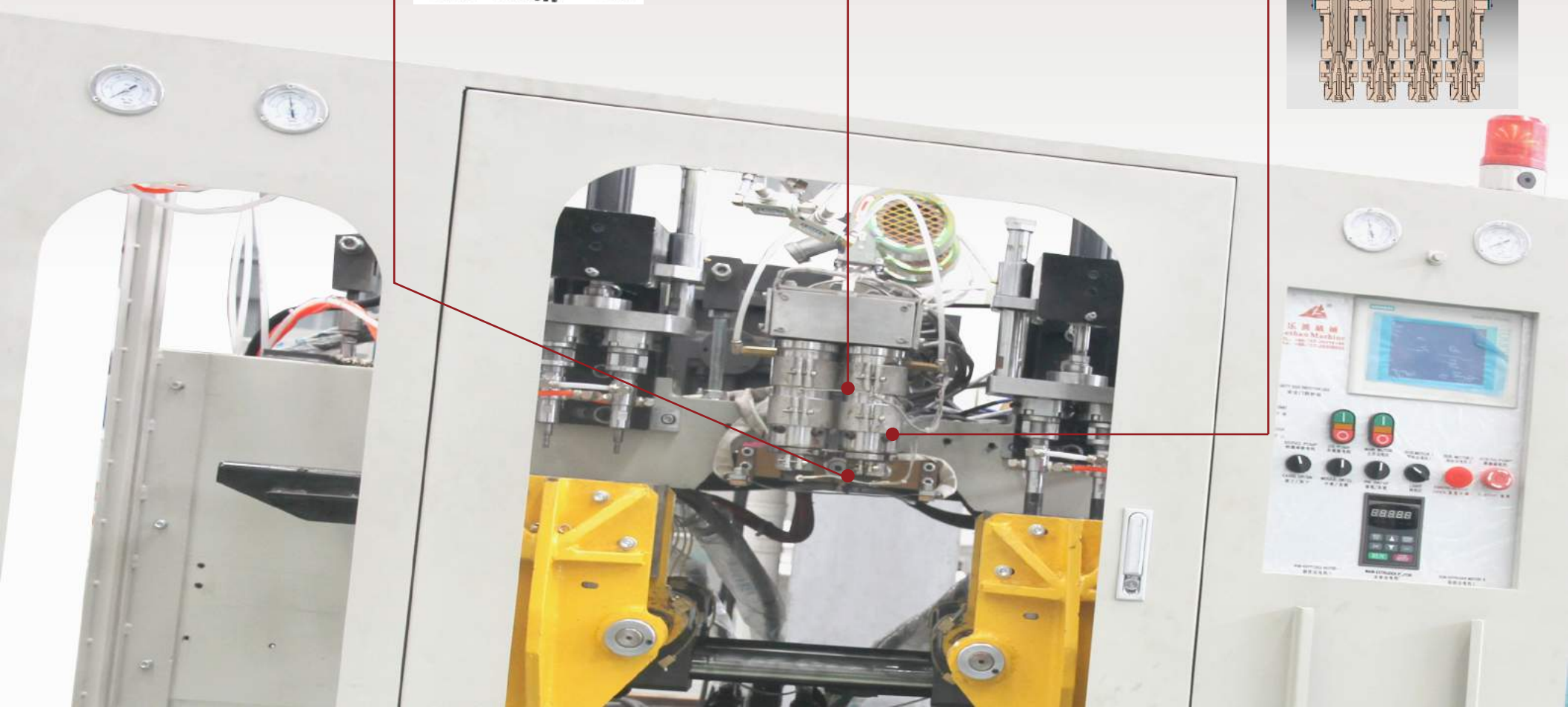
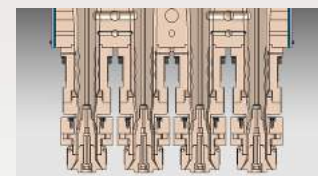
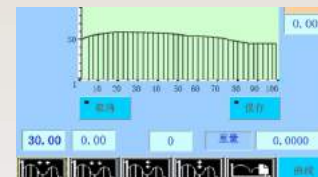


Multiple manifold

Can be equipped with spider-type distributor or torpedo-type distributor.



Professional software analysis the flow channel software to analysis the flow channel inside the die head, guaranteeing it is smooth and delicate.



Key highlights + Blow Pin



Rotating blowing pin

45 degreeed rotating blowing pin, suitable for blowing slanted mouth bottle



Air interval function

Air valve in blowing system, air interval open function will bring out the heat inside the bottle to increase the production.

Movable blowing pin

Blowing pin can move to left or right, suitable to blow the bottles whose mouth is not centered



key
highlight
+
Carriage

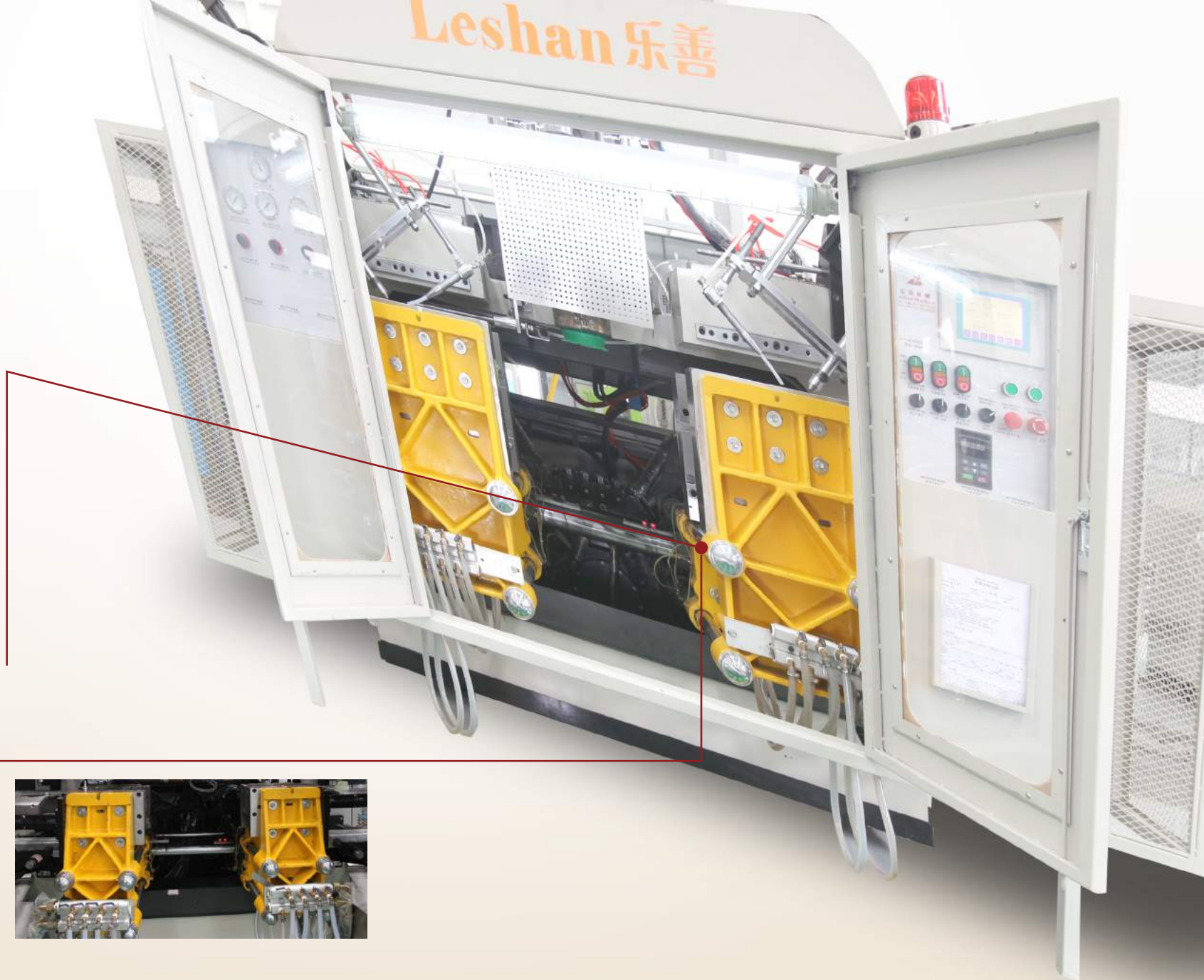
Plate- pulling type
With 4 column tie bar

Ultra-hard guide column,
fully open template design,
can accommodate
ultra-long or wide molds.



Carriage with double
protection

Firstly, the rail is equipped
with the stroke sensor.
secondly, there is a cushion
block at the end of the rail
to prevent the carriage cyl-
inder in case that the stroke
sensor is broken.

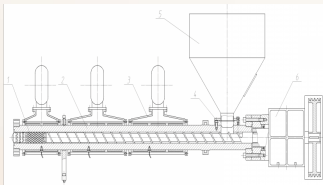


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key highlight + Extruder

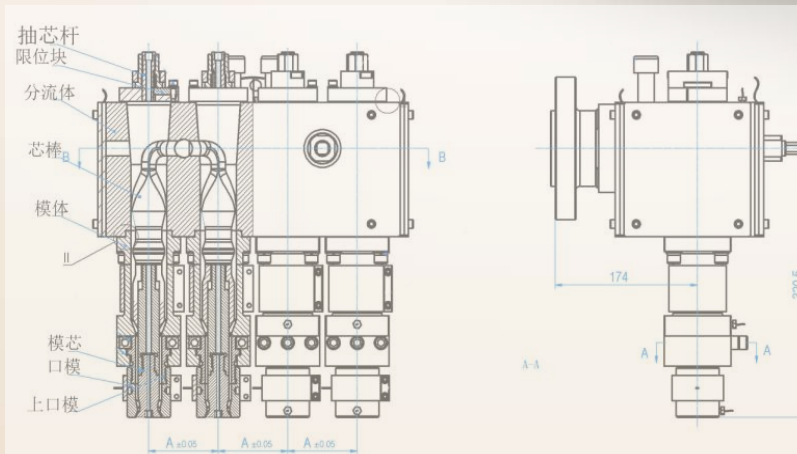
Heating segment

- 1、Screw
- 2、Barrel
- 3、Temperature control
- 4、Hopper seat
- 5、Hopper
- 6、Power Device



Die head.

It is easy to adjust the flow of each runner. The position of each seam can be arranged according to the set requirements. The temperature control is carried out according to the material characteristics .



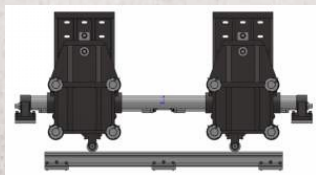
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key
highlight

+ Clamping system

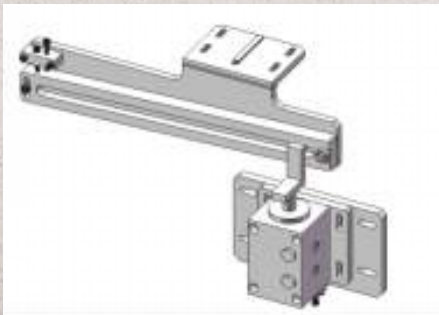
Longer service life

Reasonable structural design, the use of high-quality raw materials.



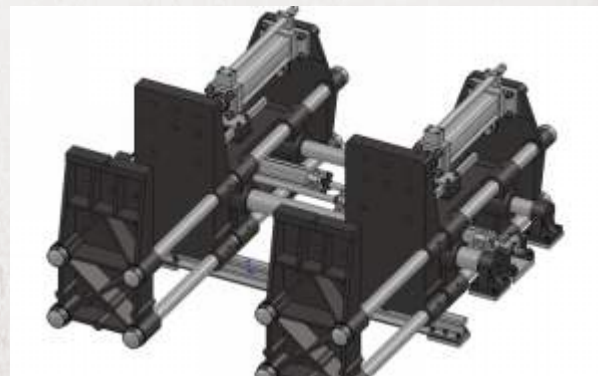
High locking accuracy

Clamping parts includes a new type of reduction valve, uniform acceleration, avoid shaking.



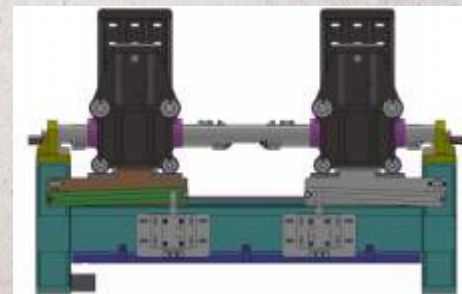
Non-leakage design

New craft work, non-leakage design, more clean production conditions.



Uniform speed for Mold clamping

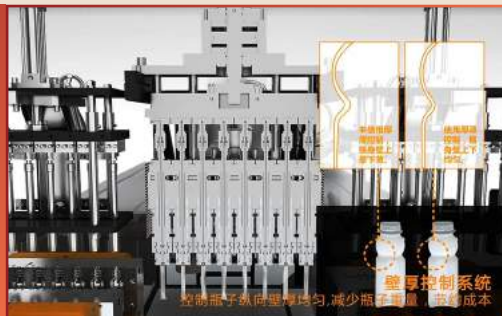
Basic on advanced technology craft work, the clamping system has uniform speed and stable movement.





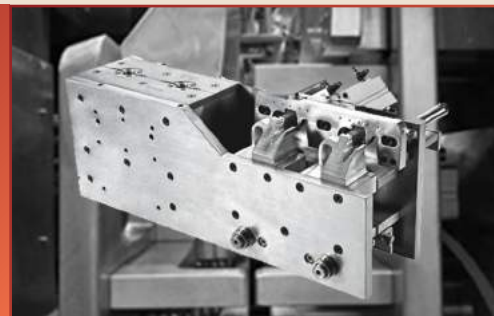
Thickness control⁺

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

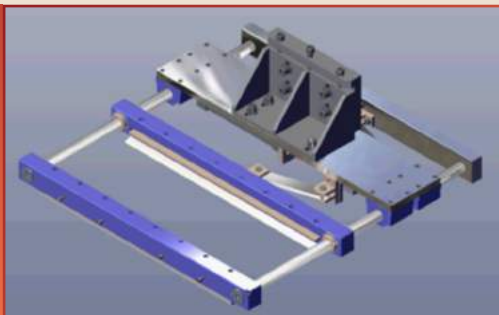


Optional function



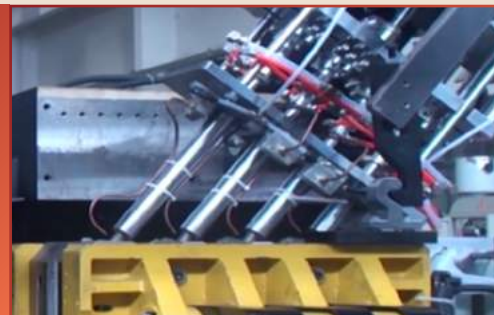
Pre-sealed⁺ cutter

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



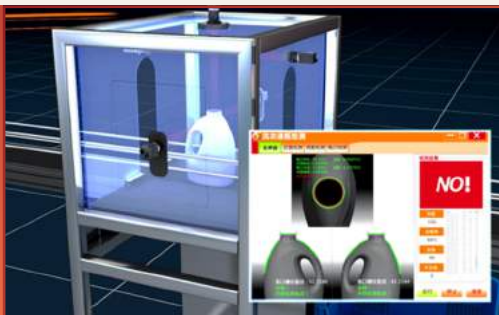
In-mold⁺ labeling

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

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.

Our clients



The above brand is LESHAN company's cooperation customer, have relative contract to check.
Due to confidentiality agreements, more customer information is not released.



Item	Unit	K Series			
Model		SCJ-45K2x1.2D	SCJ-55K2x1.2D	SCJ-55K2x2.2D	SCJ-55K2x4.2D
Specification					
Category		Single Layer			
Max Volume	L	2	2	1	0.5
Material		PE,PP,PS,PC,PVC	PE,PP,PS,PC,PVC	PE,PP,PS	PE,PP,PS
Die Head No.		1	1	2	4
Center Distance	mm	/	/	85,120,160	65,70,75
Net Weight	kg	4000	3400	3400	3500
Machine Dimension	m.LxWxH	3.13X1.93X2.1			
Clamping Unit					
Min Clamping Distance Of Mould	mm	130			
Clamping Stroke	mm	200			
Extruder Unit					
Extruder Diameter	mm	45	55		
Extruder Motor Power	kW	7.5	11		
Max Extrusion Capacity	kg/h	20	32		
Power Unit					
Total Power	kW	22.5	29.7	30.2	30.2

Item	Unit	K Series		
Model		SCJ-65K2x1.5D	SCJ-65K2x2.5D	SCJ-65K2x4.5D
Specification				
Category		Single Layer		
Max Volume	L	5	1.5	1
Material		PE,PP,PS,PC,PVC	PE,PP,PS	PE,PP,PS
Die Head No.		1	1	4
Center Distance	mm	/	120,160,170,200	65,70,75,85,100
Net Weight	kg	4600		
Machine Dimension	m.LxWxH	3.4X2.1X2.2		
Clamping Unit				
Min Clamping Distance Of Mould	mm	200		
Clamping Stroke	mm	250		
Extruder Unit				
Extruder Diameter	mm	65	65	65
Extruder Motor Power	kW	15	15	15
Max Extrusion Capacity	kg/h	60	60	60
Power Unit				
Total Power	kW	38.5	38.5	39

Item	Unit	K Series						
Model		SCJ-65-45K2x1.5D		SCJ-65-25Kx1.5D		SCJ-65-45-25K2x1.5D		
Specification								
Category		Double Layer		Single Layer With View Stripe		Double Layer With View Strip		
Max Volume	L	5		5		5		
Material		PE,PP		PE,PP		PE,PP,PS		
Die Head No.		1		1		1		
Center Distance	mm	/		/		/		
Net Weight	kg	4400		4400		4600		
Machine Dimension	m.LxWxH	3.4X2.1X2.2						
Clamping Unit								
Min Clamping Distance Of Mould	mm	200						
Clamping Stroke	mm	250						
Extruder Unit								
Extruder Diameter	mm	65	45	65	25	65	45	25
Extruder Motor Power	kW	15	5.5	15	2.2	15	5.5	2.2
Max Extrusion Capacity	kg/h	60	14	60	2	60	14	2
Power Unit								
Total Power	kW	49		42.2		53.8		

Item	Unit	K Series		
Model		SCJ-75K2x1.10D	SCJ-75K2x2.10D	SCJ-75K2x4.10D
Specification				
Category		Single Layer		
Max Volume	L	10	2.5	1
Material		PE,PP,PS,PC,PVC	PE,PP,PS	PE,PP,PS
Die Head No.		1	2	4
Center Distance	mm	/	170,200	85,100
Net Weight	kg	6300		
Machine Dimension	m.LxWxH	3.93X2.2X2.5		
Clamping Unit				
Min Clamping Distance Of Mould	mm	230		
Clamping Stroke	mm	350		
Extruder Unit				
Extruder Diameter	mm	75		
Extruder Motor Power	kW	22/(30)		
Max Extrusion Capacity	kg/h	95/(105)		
Power Unit				
Total Power	kW	54.5(62.5)	54.5(62.5)	54.5(62.5)

Item	Unit	K Series					
Model		SCJ-75-55K2x1.10D		SCJ-75-55K2x2.10D		SCJ-75-55K2X4.10D	
Specification							
Category		Double Layer					
Max Volume	L	10		2.5		1	
Material		PE,PP		PE,PP		PE,PP	
Die Head No.		1		2		4	
Center Distance	mm	/		160,200		85,100	
Net Weight	kg	7000					
Machine Dimension	m.LxWxH	3.93X2.2X2.5					
Clamping Unit							
Min Clamping Distance Of Mould	mm	230					
Clamping Stroke	mm	350					
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
Power Unit							
Total Power	kW	73.2		73.7/(82.7)		71.7/(80.7)	

Item	Unit	K Series					
Model		SCJ-75-55K2x1.5D-A		SCJ-75-55K2x2.5D-A		SCJ-75-25K2x1.5D-A	
Specification							
Category		Double Layer				Single Layer With View Stripe	
Max Volume	L	5		2		5	
Material		PE,PP		PE,PP		PE	
Die Head No.		1		2		1	
Center Distance	mm	/		160, 200		/	
Net Weight	kg	6500		6500		7000	
Machine Dimension	m.LxWxH	3.5X2.25X2.4					
Clamping Unit							
Min Clamping Distance Of Mould	mm	200					
Clamping Stroke	mm	200					
Extruder Unit							
Extruder Diameter	mm	75	55	75	55	75	25
Extruder Motor Power	kW	22/(30)	11	22/(30)	11	22/(30)	2.2
Max Extrusion Capacity	kg/h	90/(105)	30	90/(100)	30	90/(105)	2
Power Unit							
Total Power	kW	73.2/(82.2)		73.7/(82.7)		73.7/(82.7)	

Leshan 乐善

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.



Turn key project



+ 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.



Turn key project



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

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

1. Log in LESHAN company's official WeChat, click "After-sales area", click into "Assembly of after-sales service"

2. Log in system, using the account to check in.

3. Enter the system interface: the system to provide the model name, product type, date, message four big functions to choose

4. Choose machine type: choose your machine model

5. Select product types: convenient query

6. Choose manufacture date: LESHAN equipment behind, there is a famous brand, with production date, find the fill in the can

7. Mark a message: fill in the problem of fault messages

8. After the completion of the submitted information: click on the submit, and then wait for leshan after-sales personnel door-to-door service.

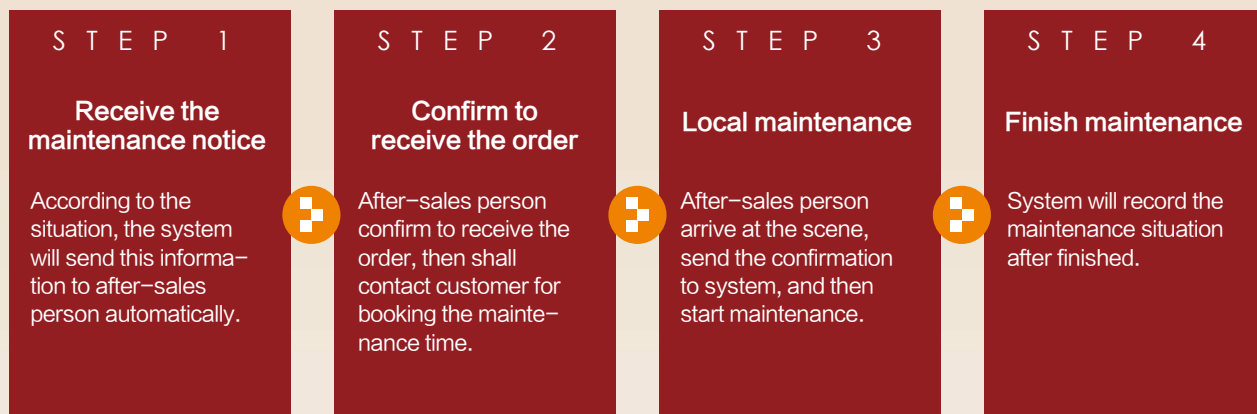
Installation & commissioning

Default declaring

Delicate service

Professional technicians

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.Installation,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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Linear Guide Rail



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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

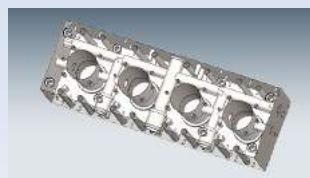
Set the thickness of the bottle
from Touch Screen

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.



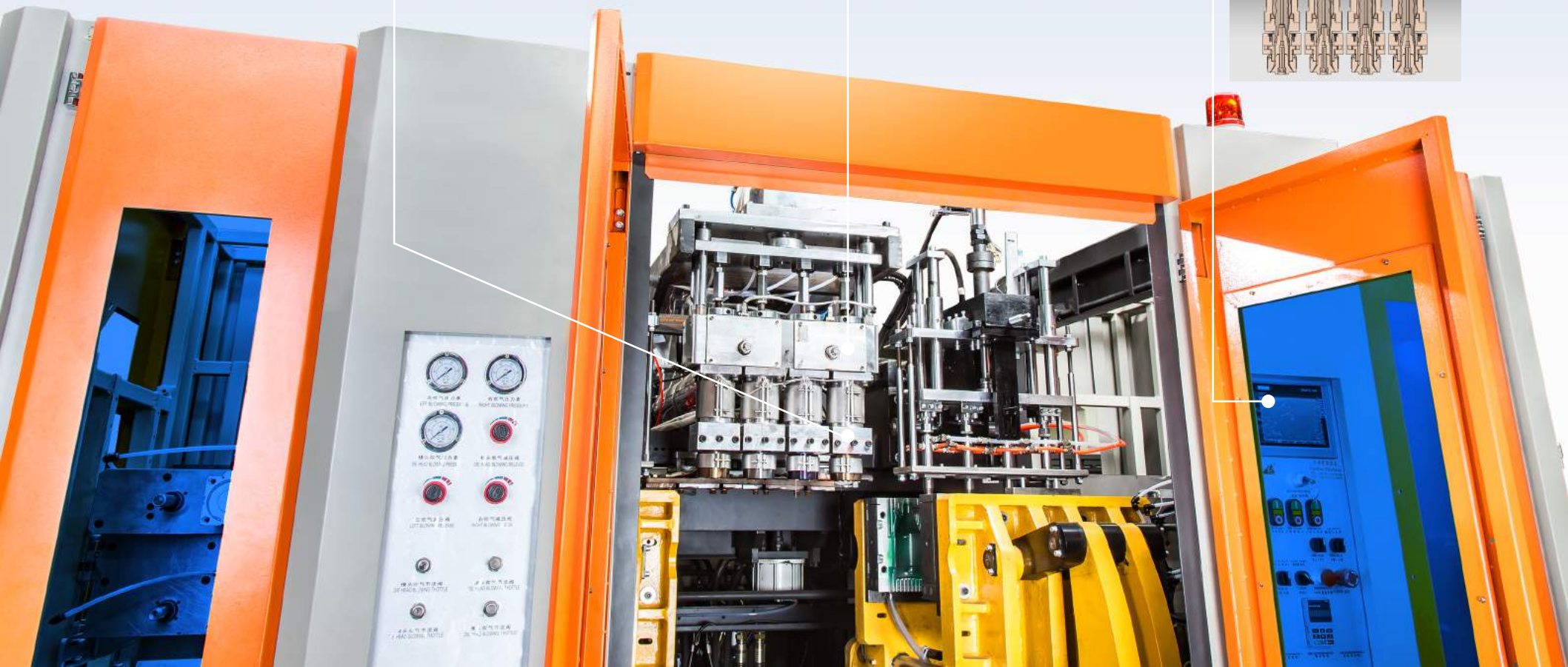
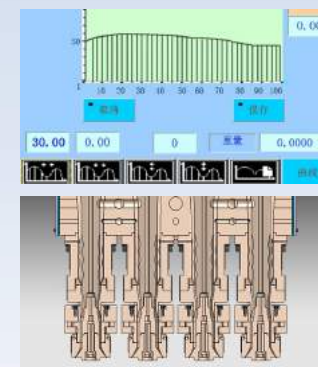
Debugging the length for multi-
ple-parison in balance.

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.

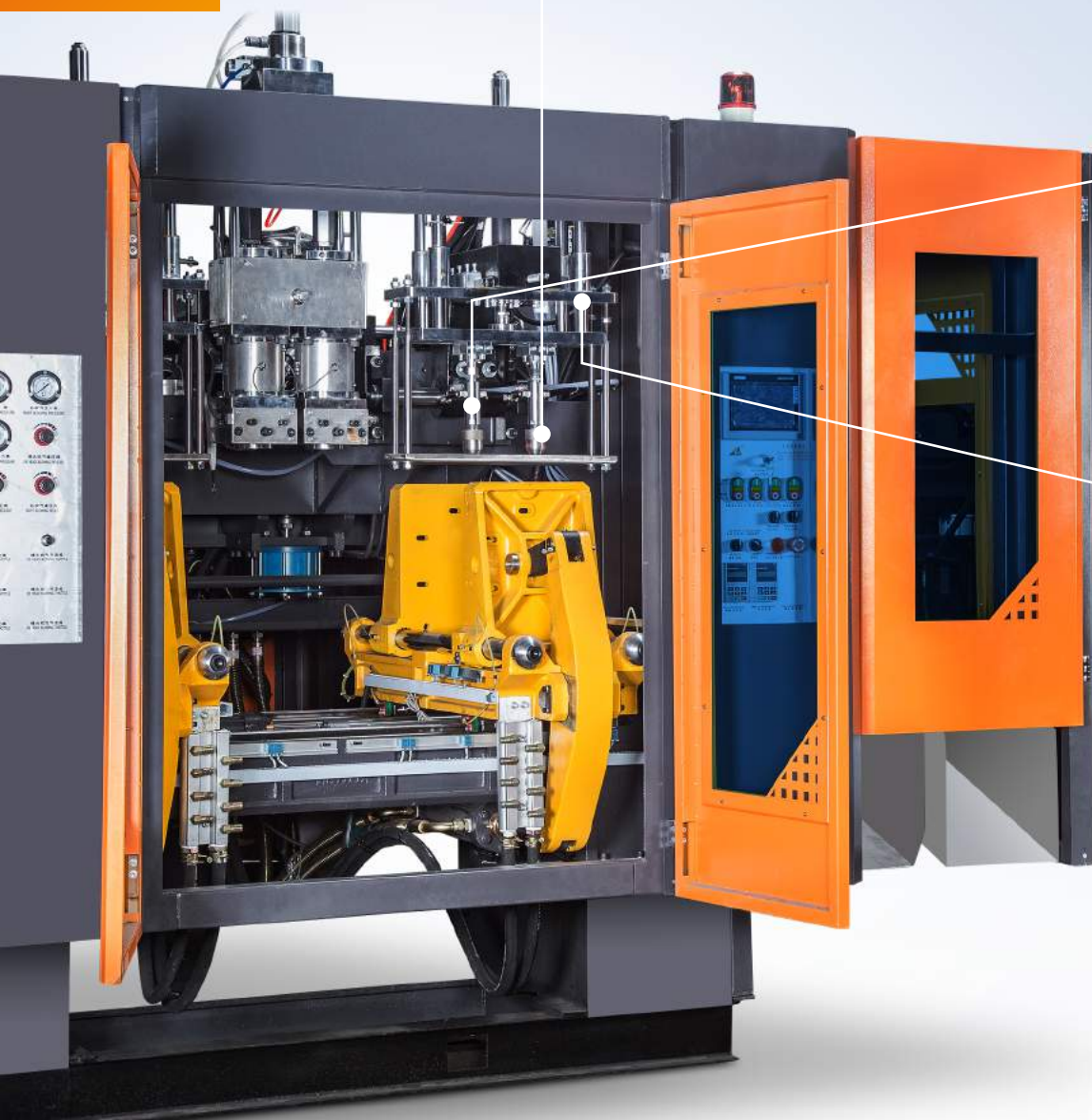
Adjusting screw for die tooling,
guarantee the parison even and no
bending



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.

Leshan 乐善

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			
Clamping Force	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					
Clamping Force	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		
Clamping Force	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		
Clamping Force	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)

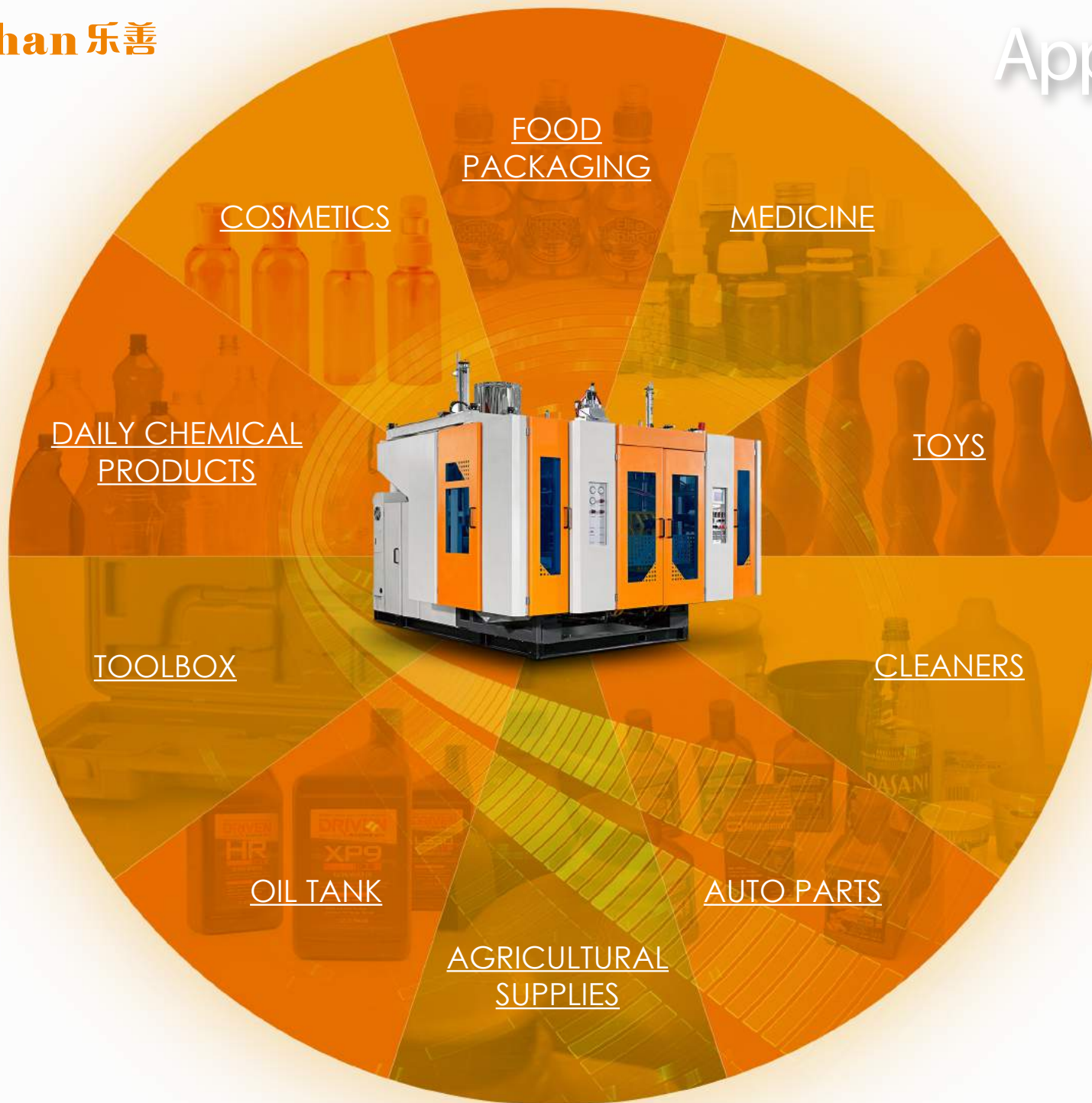
Item	Unit	U Series (Linear Guide Rail)					
Model		SCJ-75-55U2x1.10F		SCJ-75-55U2x2.10F		SCJ-65-45U2x4.5F	
Specification							
Category		Double Layer					
Max Volume	L	10		5		2	
Die Head No.		1		2		4	
Center Distance	mm	/		≤280		≤120	
Net Weight	kg	9500					
Machine Dimension	m.LxWxH	4.34X3.15(2.2)X2.6					
Clamping Unit							
Min Clamping Distance Of Mould	mm	230					
Clamping Stroke	mm	350					
Clamping Force	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		
Clamping Force	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		
Clamping Force	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		

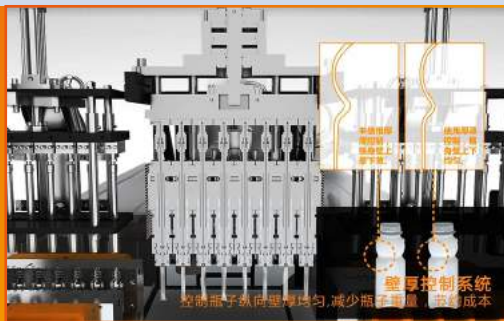
Item	Unit	U Series (Linear Guide Rail)		
Model		SCJ-65K2X6.2D	SCJ-65U2X6.2G	SCJ-75K+S2X6.5D-A
Specification				
Category		Linear Guide Rail	Single Layer	Single Layer
Max Volume	L	0.25	0.22	0.3
Die Head No.		6	6	6
Center Distance	mm	70	70	80
Net Weight	kg	5000	7600	6500
Machine Dimension	m.LxWxH	3.465X3.304X2.16	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
Clamping Force	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
Clamping Force	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



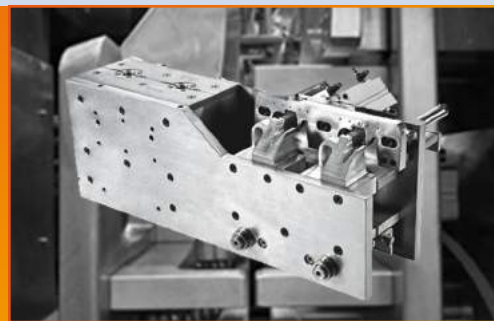
Thickness⁺ control

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 .



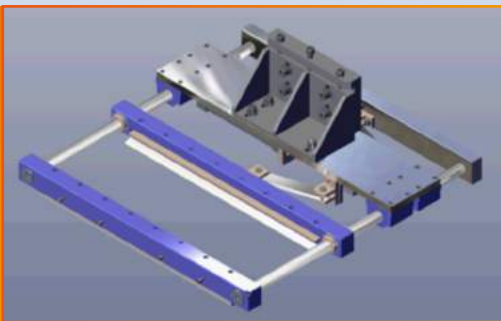
Hoist⁺

suitable for lifting molds



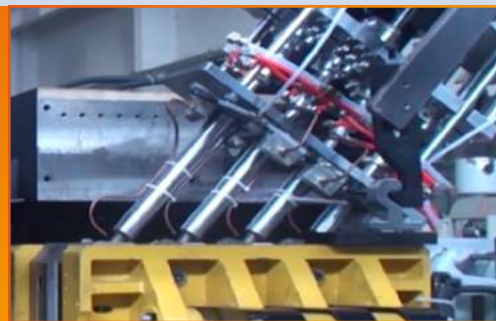
Pre-sealed⁺ cutter

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



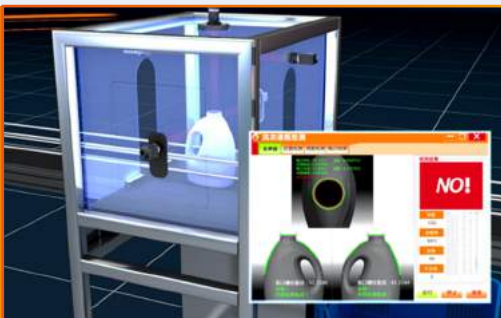
In-mold⁺ labeling

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



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Annual sales is up to 600 set of blow molding machine.



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

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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.



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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

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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

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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

1. Log in LESHAN company' s official WeChat, click "Af-ter-sales area" , click into "Assembly of after-sales service"

2. Log in system, using the account to check in.

3. Enter the system interface: the system to provide the model name, product type, date, message four big functions to choose

4. Choose machine type: choose your machine model

5. Select product types: convenient query

6. Choose manufac-ture date: LESHAN equipment behind, there is a famous brand, with production date, find the fill in the can

7. Mark a message: fill in the problem of fault messages

8. After the completion of the submitted information: click on the submit, and then wait for leshan after-sales personnel door-to-door service.

Installation & commissioning

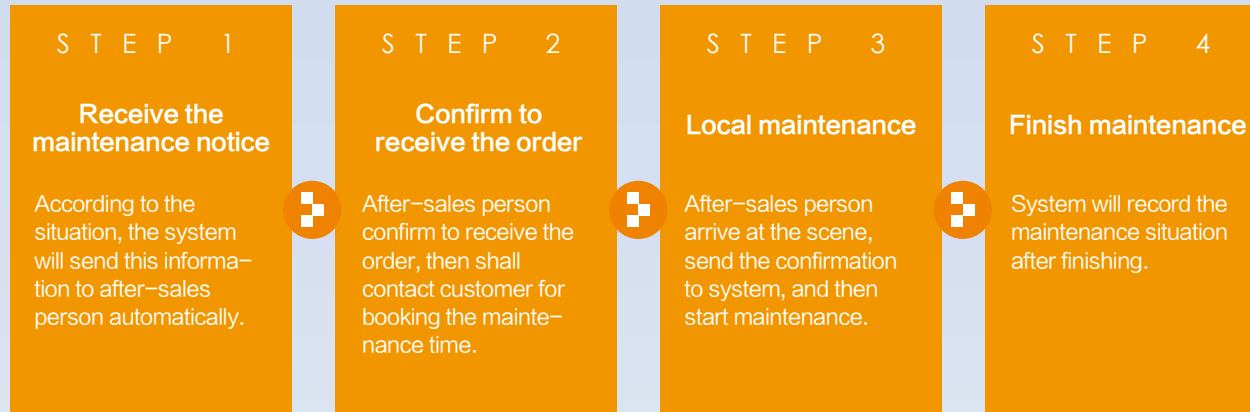
Default declaring

Delicate service

Professional technicians



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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Leshan 乐善

Blow Molding Machine

B_{ig}

Accumulator & Single station series



www.china-leshan.com

Tel: +86-757-2837 6168

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

B SERIES

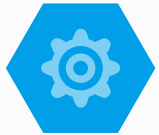
Accumulator & Single station series



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



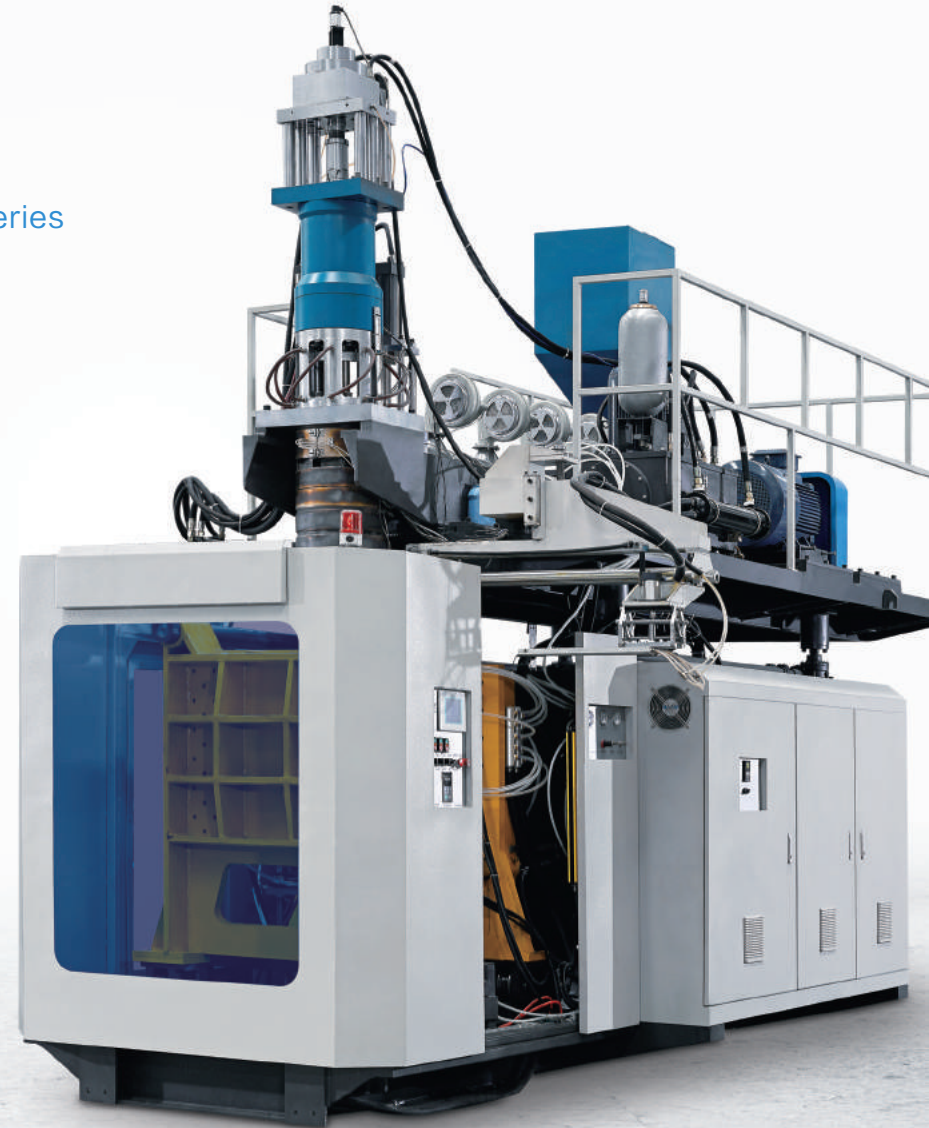
The whole machine frame is welded with steel parts, durable and non deforming.



Various functions, simple operation



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



B SERIES

Accumulator & Single station series



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



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



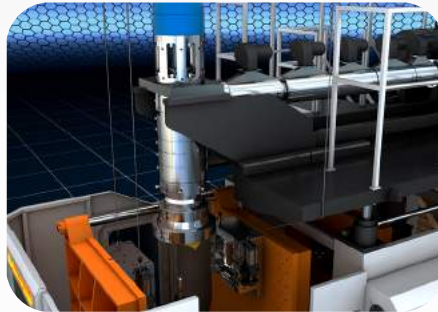
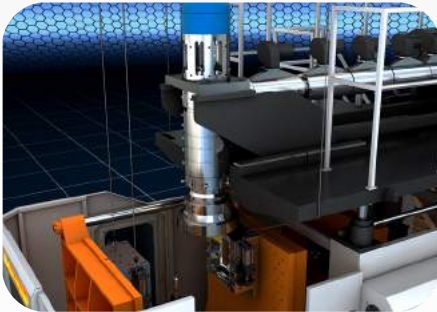
Use well-known pneumatic, hydraulic, electrical control components, long service life and stable performance.



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

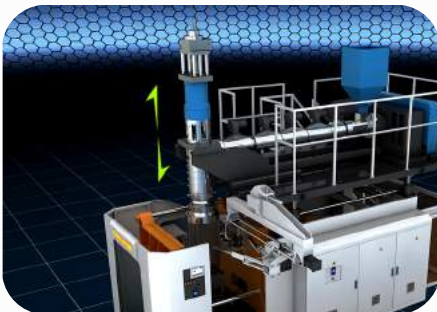
Equipped with slide system

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



Equipped with automatic lifting platform system

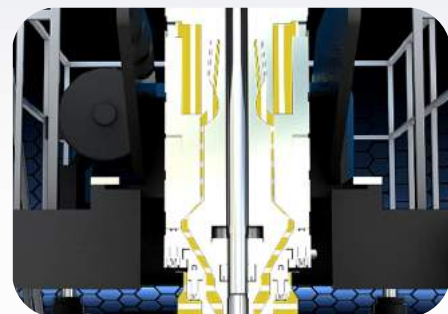
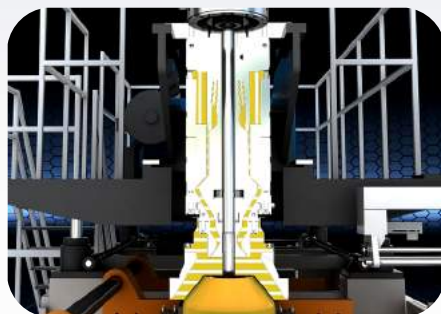
Complied with transmission principle of Gear Motor and Lift Acceleration Machine, the whole platform can elevate with die head and extrusion system, so it can adapt to different mold height and different blow molding process requirements.





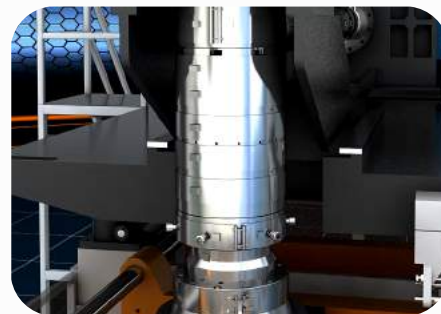
Double envelope, uniform parison

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



The die head made of hard and wear-resistant material

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



1.Up blowing or down bowing

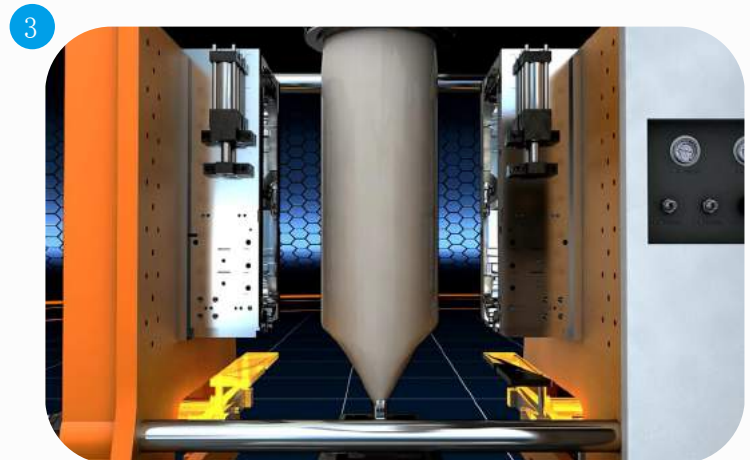
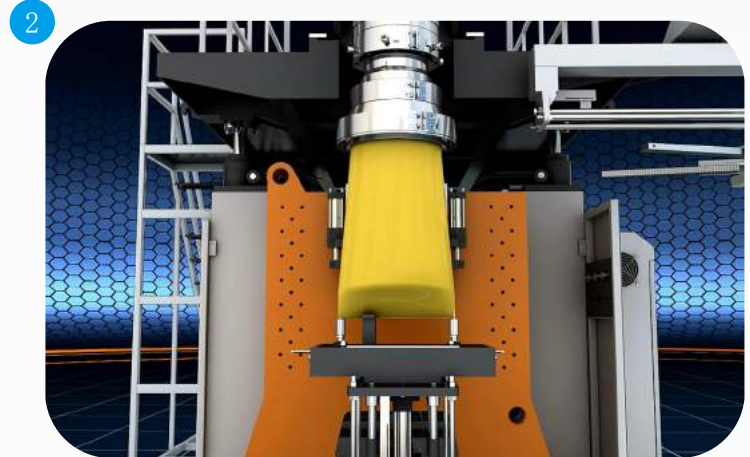
Blowing pin can signed to be up blowing ,down blowing ,
inject-blowing from side, blowing with a thread

2.Parison widening function

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

3.Parison pre-clip function

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



4.Pre- seal cutter device

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

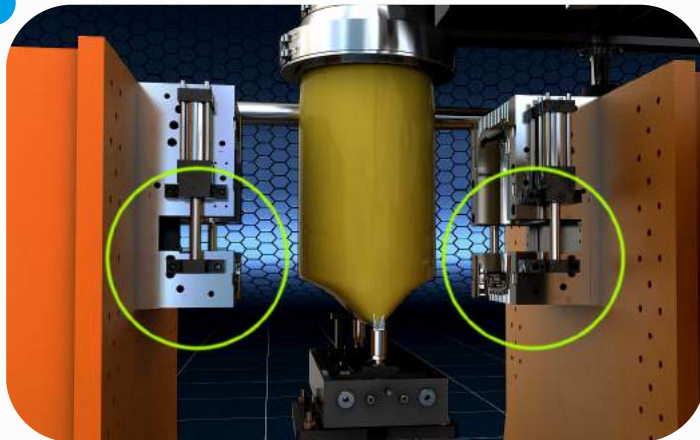
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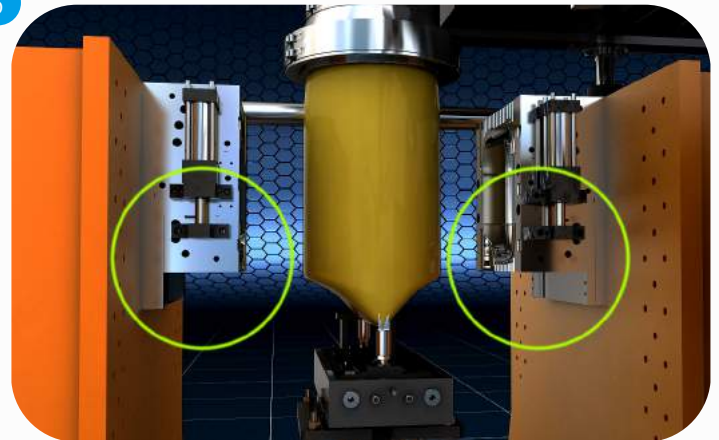
5.Mould stretch functions

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

5



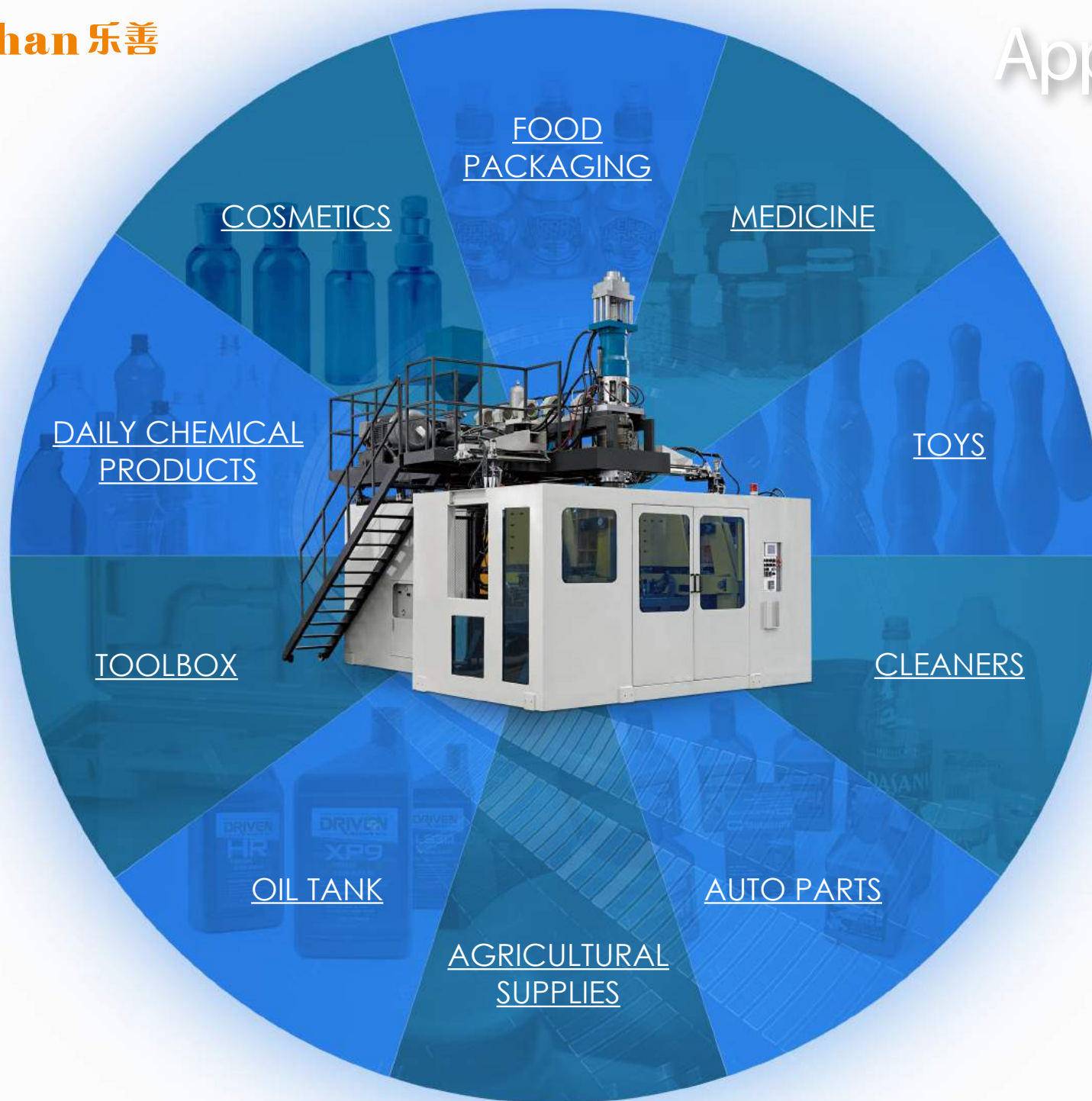
5



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

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

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



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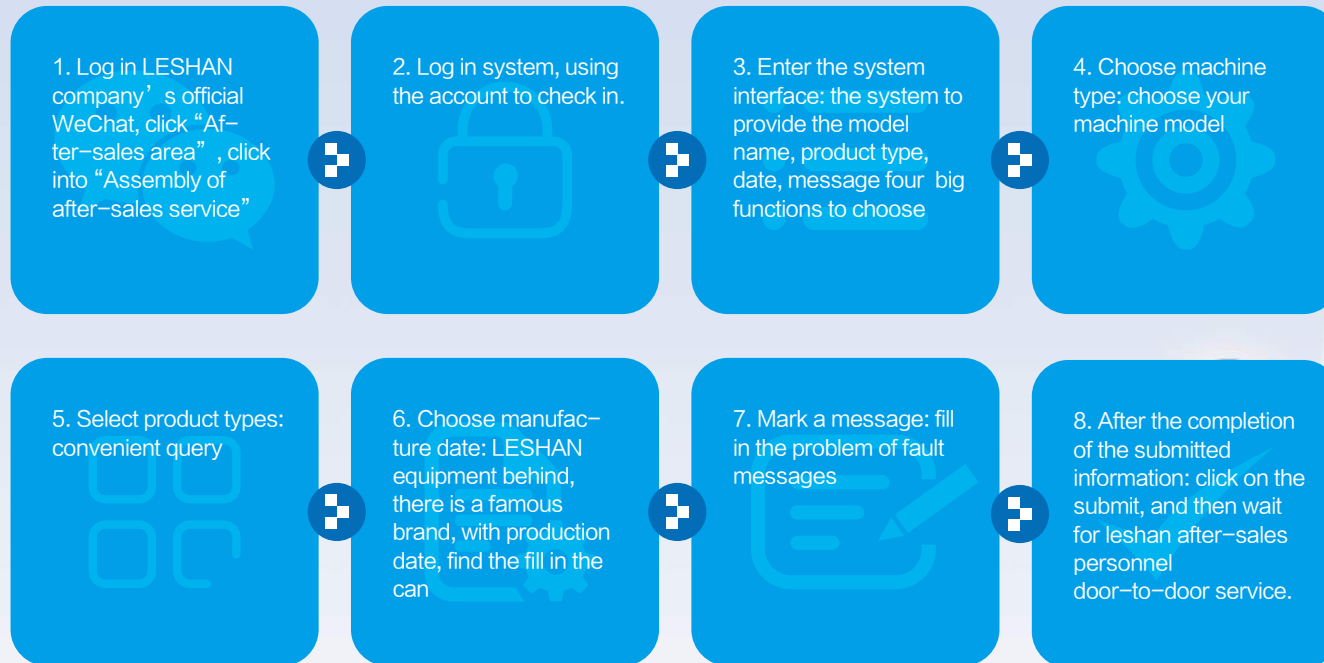
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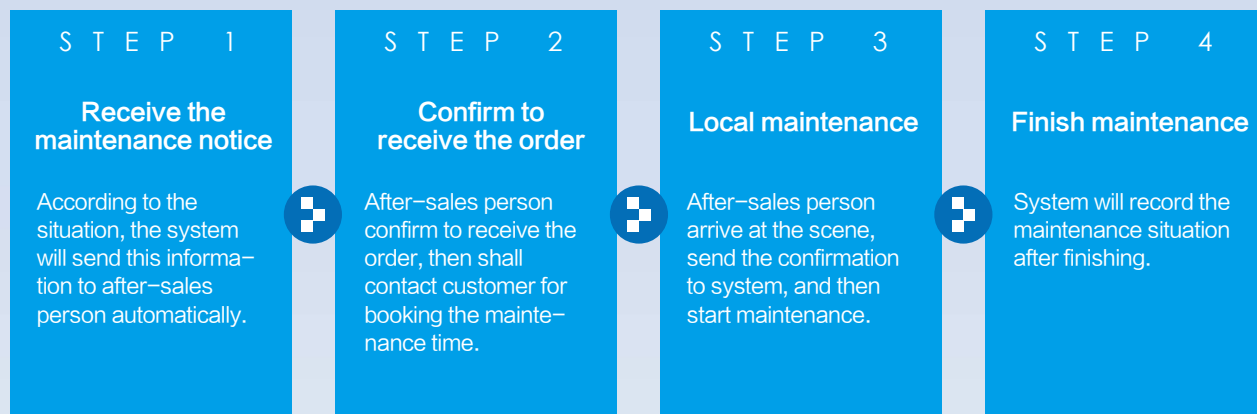
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Blow Molding Machine

E lectric

Blow molding machine



www.china-leshan.com

Tel: +86-757-2837 6168

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

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E SERIES

Electric Blow Molding Machine

Energy saving up to 51%

Patent technology, pure electric drive carriage and clamping, saving electricity energy for 250-300

Quiet

It runs as quiet as a Tesla car, providing your factory a calm working environment.

Save labor costs

If with Three axis servo manipulator, can reduce 2 workers for each machine, can effectively reduce the personnel salary and management cost

Carriage accurate fast

Carriage driven by servo motor, instant accelerate, brake accurately, speed adjustable.

Meet high hygiene standards

Pure electric drive is more suitable for food, medicine, beverages extremely strict with health products.



Die head with servo motor drive

Multiple cavity shall match electricity parson, parison control mode provides the cup-pulling type or core-pulling type for choice



With electricity blow pin

Pure electricity drive blow pin, action quick, and move smooth. adjusted all movement by setting parameters from the touch screen, free from mechanical adjusting, it is more safe and more reliable





With electricity clamping

Electric clamping structure is using amplified dynamic mechanical structure design, amplify the input power up to 20 times to achieve using small power motor while getting big clamping force.



With electrical carriage

Replace mechanical structure of hydraulic cylinder and sensor with servo motor and ball screw rod, providing accurate action, quick movement and fast responding.



Leshan 乐善



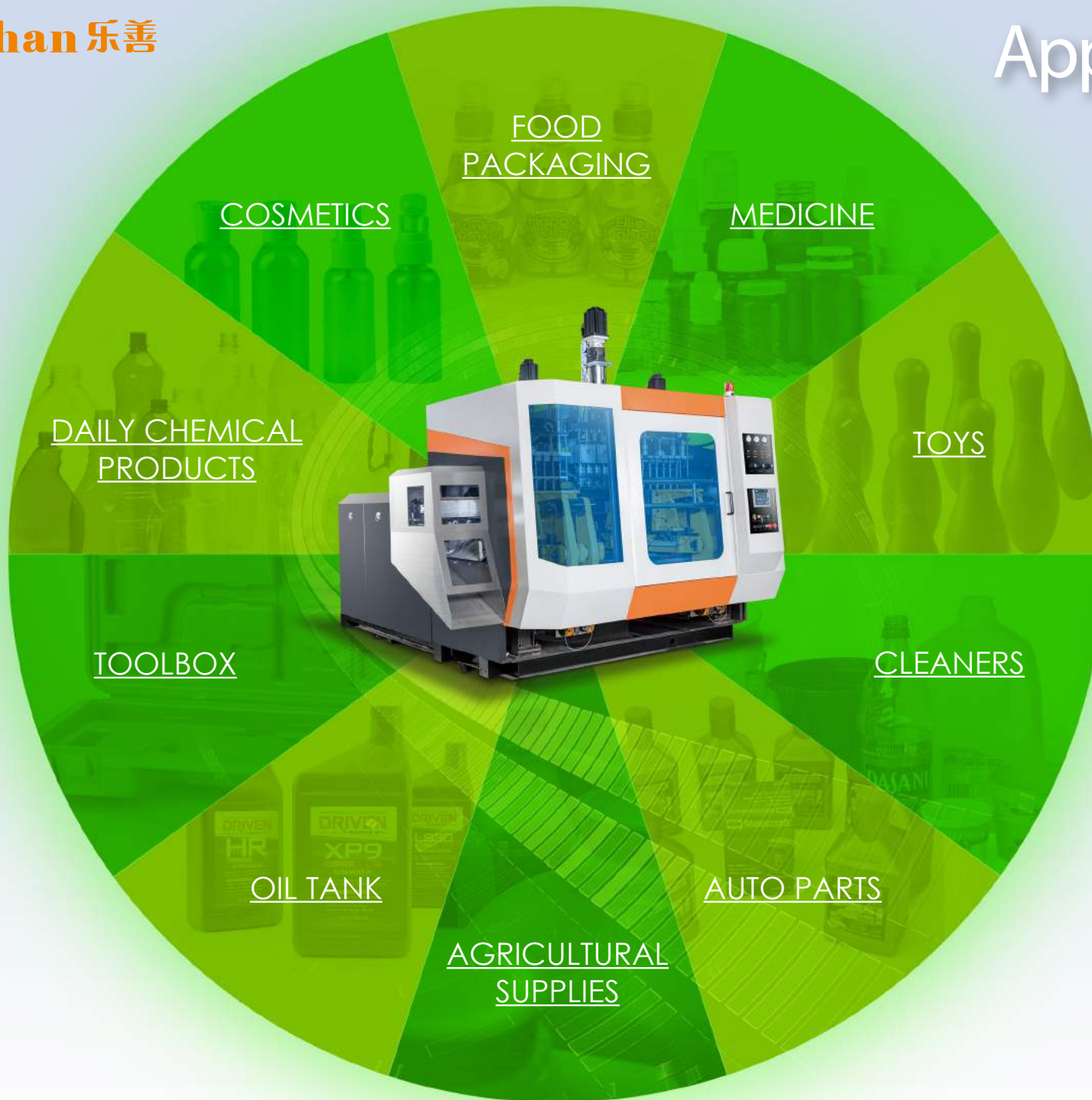
With electrical lifting platform
Suitable for different height bottle, needn't labor to operate.



With electrical platform rising
Platform rising more stable.

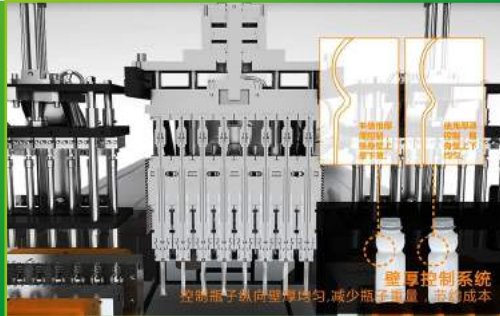
Item	Unit	Hybrid EBM machine							
Model		SCJ-65-65EH+S2X1.10D		SCJ-75-55-25EH+T+S2X1.10D			SCJ-85-55-30EH+T+S2X2.15D		
Specification									
Category		Triple Layer		Double Layer With View Stripe					
Max Volume	L	10		10			5		
Die Head No.		1		1			2		
Center Distance	mm	/		/			280		
Net Weight	kg	12000							
Machine Dimension	m.LxWxH	5.3x3.4x3.7		5.3x3.7x3.7			5.2x4.2x3.7		
Clamping Unit									
Min Clamping Distance Of Mould	mm	230		230			250		
Clamping Stroke	mm	575		350			400		
Clamping Force	kN	125		125			196		
Extruder Unit									
Extruder Diameter	mm	65		75	55	25	85	55	30
Extruder Motor Power	kW	24		22	7.5	2.2	37	7.5	2.2
Max Extrusion Capacity	kg/h	50		90	25	4	150	25	4
Total Power	kW	78.2		85.9			109		

Item	Unit	Pure Electrical EBM machine		
Model		SCJ-75E+S2X6.5G(70)	SCJ-85E+S2X8.5G(80)	SCJ-90E+S2X4.15G
Specification				
Category		Single Layer		
Max Volume	L	0.5	0.5	2
Die Head No.		6	8	4
Center Distance	mm	90	80	160
Net Weight	kg	12000		
Machine Dimension	m.LxWxH	4.6x3.7x3.2	4.6x3.7x3.2	5.9x4.2x3.6
Clamping Unit				
Min Clamping Distance Of Mould	mm	250	250	230-270 ADJUSTABLE
Clamping Stroke	mm	200	200	300
Clamping Force	kN	125	125	196
Extruder Unit				
Extruder Diameter	mm	75	85	90
Extruder Motor Power	kW	30	30	45
Max Extrusion Capacity	kg/h	120	130	180
Total Power	kW	75.9	76.9	106.1



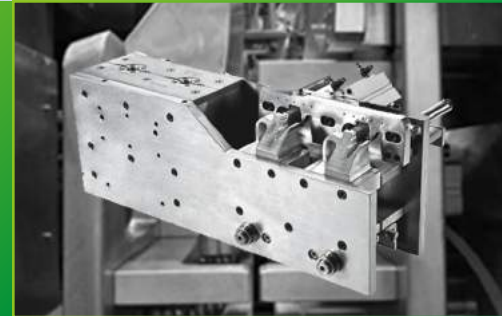
Thickness⁺ control

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



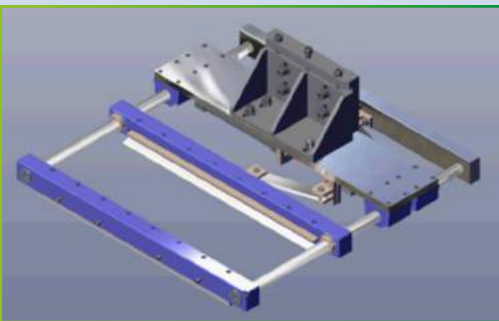
Spin trimmer⁺

Able to equipped with inside spin trimmer or out side spin trimmer.



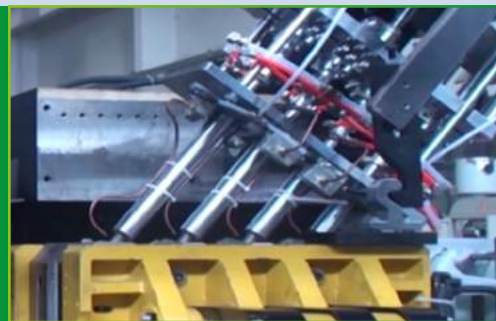
Pre-sealed cutter

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



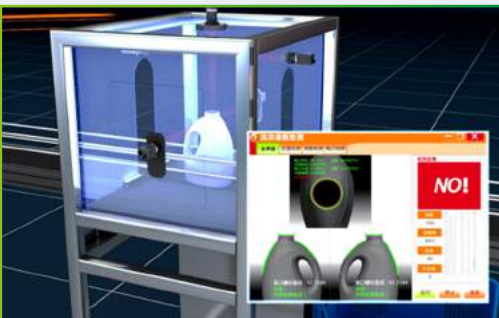
In-mold⁺ labeling

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 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.



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



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

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

+
Member

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



+ Service

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



+ CONSTRUCTION

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



WORKING PROCESSING

1

Setting the output requirement of the bottle

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

The safe coefficient is related to the following factors:

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

2

Select blow molding machine

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



WORKING PROCESSING

3

Equipped with auxiliary machinery, pipeline calculation

The process is divided into the following five parts

Cooling-water machine

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

Crusher

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

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

Feeding system

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

Air compressor, air accumulator

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

Water pipe & gas pip

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



WORKING PROCESSING

4

Design of workshop layout (core engineering)

All members in our project center are all elites of the industry. they all have abundant experience in mechanical workshop management and blow molding technology. They are familiar with the principle on mechanical layout and the best route of logistics operation. in the course of the design, we consider the operation of the machine. The maintenance space, fire control passageway, ventilation and lighting and staff access in and all- around way. In the whole of China, LESHAN is the only one company who is able to plan the EBM production line so comprehensively.

5

An actuarial production lines operating costs

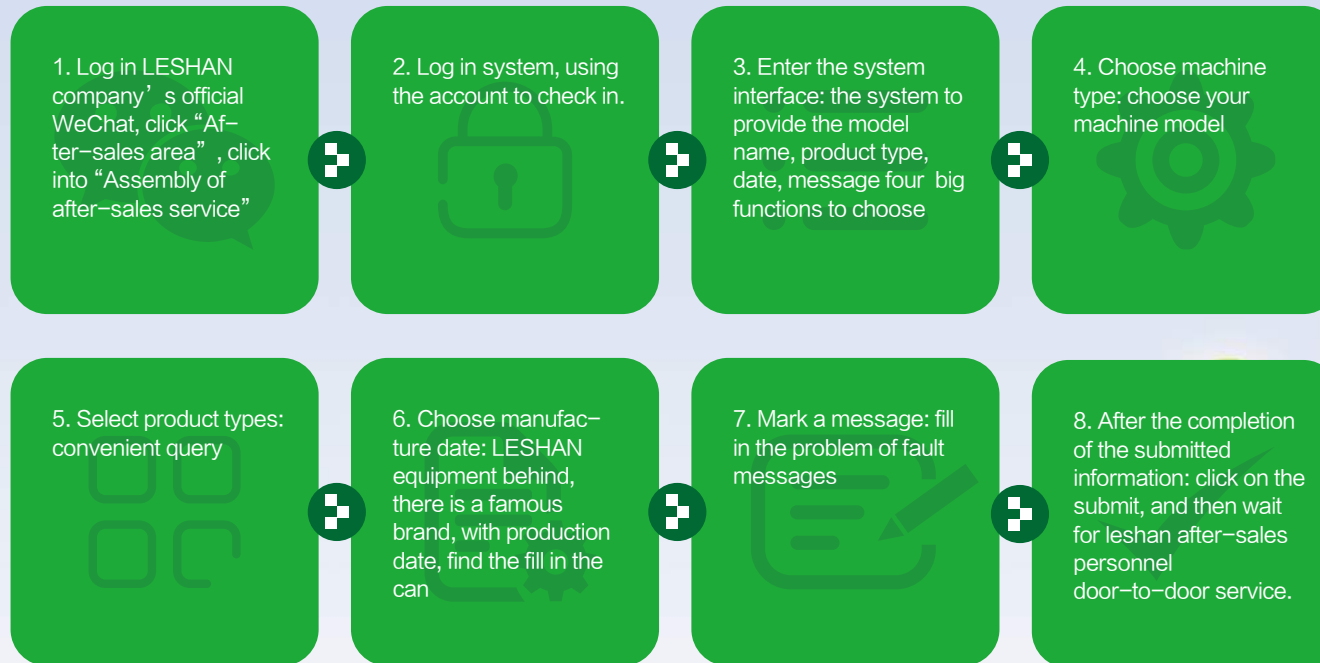
Our project center can accurately list the amount of investment for production lines and the production cost for in following one year for our customers



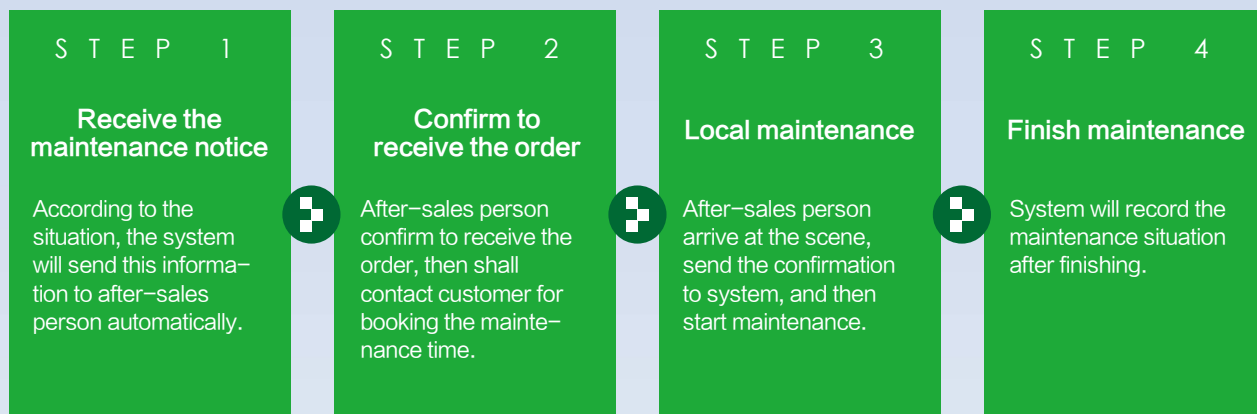
1. Wechat Assembly system

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

Assembly Processing



After-sales maintenance process



2.Spare part damage warning system

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

3.Install,commissioning and training

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



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