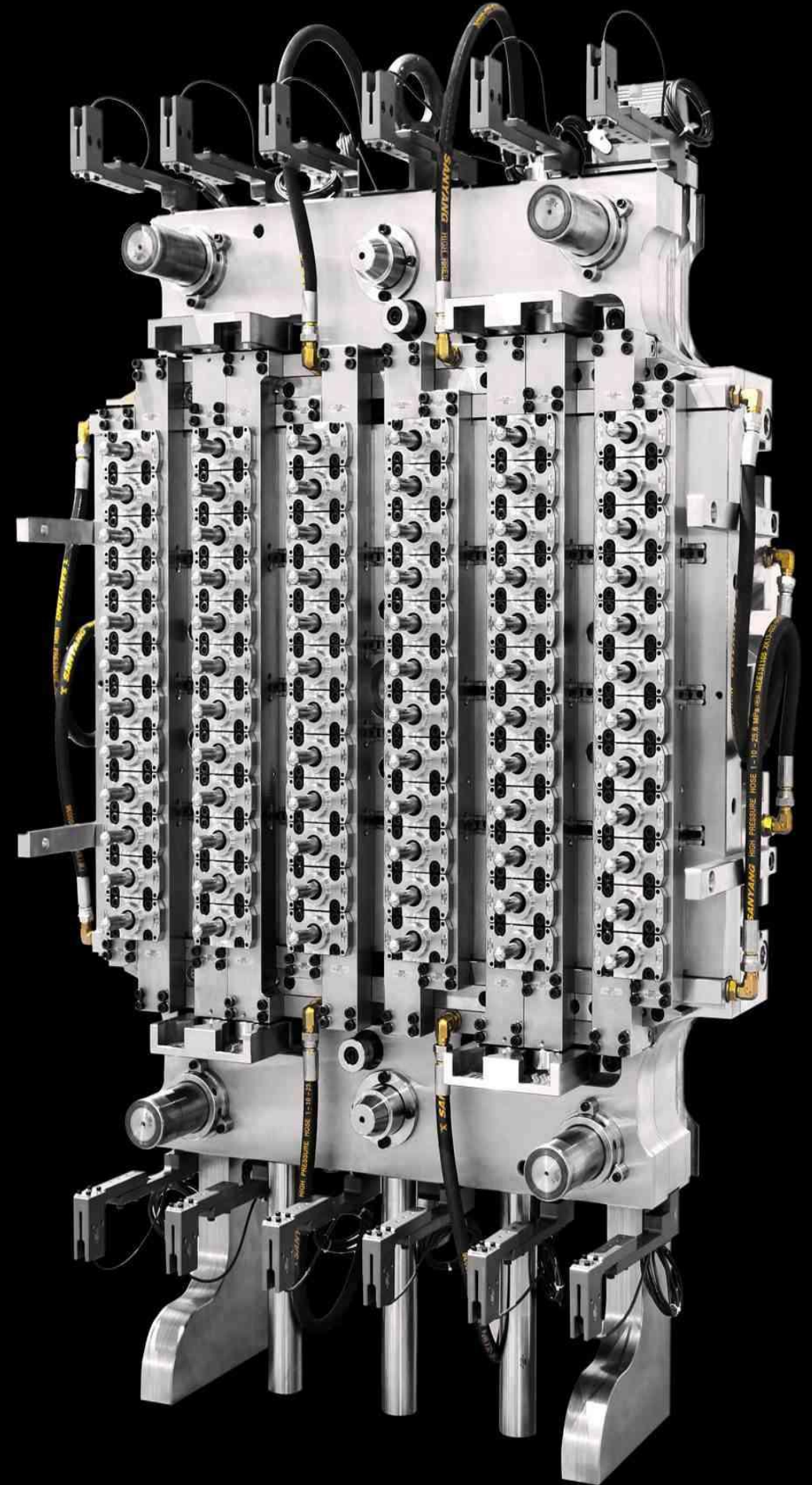


LIANYU PET Preform Mold

Specification: 24-144 cavity

Mold plate material: 3Cr13 stainless steel



Our advantage:

1. Positioned by dual tapers inside neck ring
2. Labyrinth cooling channel surround cavity
3. Assisted compressed air ejection
4. Imported steel material for some cavity parts
5. Special heat treatment

Our key customers :

1. Taiwan Hongquan company
2. Nongfu Spring company

PET spare parts



Cavity Parts Material

cavity base: S136 (China)

cavity: M333 (Austria Bohler Company)

neck ring :FS136 (China)

core: FS136 (China)

core sleeve: FS 136(China)

gate insert : M310 (Austria Bohler Company)

PET Preform



bottle neck: 26mm, 2925, 3025, PCO1881, ISBT1881, 38mm, etc.

Case 1

product : 19g-3025 preform

mold specifiction : 72 cav cold mold matching Husky hot mold

injection molding machine: HUSKY-GL300
cycle time

opening time	clamping time	injection time	pressure holding time	cooling time	Ejection time	robot arm	total
1s	1.5s	3.5s	1.2s	4.5s	0.2s	1s	11s

injection condition

cooling water pressure	cooling water temperature	water flow	Plasticizing amount
0.6-0.8Mpa	10-12度	40-45M3/h	180-200g/s

Case 2

product : 22g 1881 preform

mold information: 72cav cold mold matching Husky hot mold

injection molding machine: HUSKY-GL300

cycle time

opening time	clamping time	injection time	pressure holding time	cooling time	ejection time	robot	total
1s	1.5s	3.8s	1.5s	4.8s	0.2s	1s	12s

injection condition

cooling water pressure	cooling water temperature	water flow	Plasticizing amount
0.6-0.8Mpa	10-12 degree	40-45M3/h	180-200g/s

Case 3

product : 55g oil PET preform

mold specifiction : 48 cavity preform mold

injection molding machine: YIZUMI PET-72A

cycle time

opening time	clamping time	injection time	pressure holding time	cooling time	ejection time	robot	total
1.5s	1.8s	7.5s	3s	11s	0.3s	1s	28s

injection condition

cooling water pressure	cooling water temperature	water flow	Plasticizing amount
0.6-0.8Mpa	10-12 degree	40-45 M3/hour	180-200g/sec