



Thermoforming Machine (2-step)

Machine structure

一、 Specification

1. Machine dimensions : L 5400mm * W 2000mm * H 3700mm
2. Machine weight : 17,920kg
3. Maximum installed power of machine : 260.8kW @ 380V
4. Machine method : Forming → First hot-pressing → Blow release
5. Template dimensions : 1,300mm*1,400mm
6. Maximum height of the product : 100mm (≥ 10 degrees)
7. Vacuum pump : $48\text{m}^3/\text{min.}$, -60Kpa
8. Compressed air : $0.6\sim 1.8\text{m}^3/\text{min}$, 0.6Mpa
9. Supply pulp: 20~65kg/hr., it depends on the products.

二、 Structure

1. Frame : Carbon steels SS41 welding, post-treatment annealing
2. Molding : Upper mold (aluminum alloy A380)
3. Molding : Lower mold (stainless steel SUS304)
4. Thermoforming : Upper mold & Lower mold (ductile iron FCD45, post-

treatment annealing)

三、 Hydraulic oil pressure system

1. Forming servo hydraulic cylinders: Hydraulic cylinders (max. force 10T, max. stroke 600mm) + Servo motor drive (power : 4.5kW)
2. Hot-pressing servo hydraulic cylinder: Hydraulic cylinders (max. force 36.5T, max. stroke 450mm) + Servo motor drive (power : 8.5kW)

Electrical control

1. Mitsubishi servo motor
2. PLC : Mitsubishi FX5U series
3. HMI : HMI touch screen+GUI+15" screen
4. Heating mode : Electric heating (SSR power controller /380V) ;
Single groups of maximum power 15 kW (total of 16 groups), Maximum heating power : 240kW