ZHAFIR
PLASTICS MACHINERY

TECHNOLOGY TO THE POINT

SMART TECHNOLOGY

FLEXIBLE INTEGRATION

SUSTAINABLE SOLUTIONS

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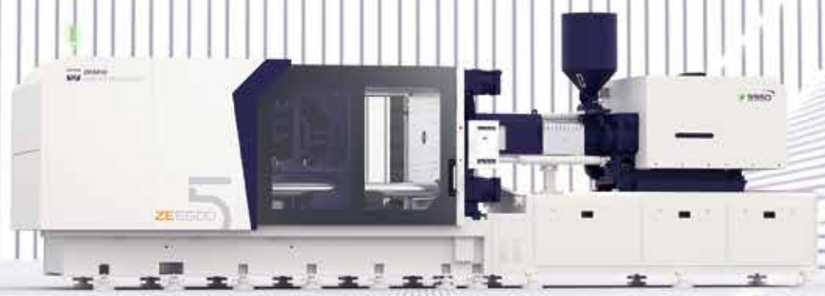
HT 20231101-IV

ZERES SERIES

TECHNICAL SPECIFICATION

5,500 – 13,800 kN



TECHNICAL DATA ZE5500 V

CLAMPING UNIT	Clamping force	kN	5500											
	Mold opening stroke	mm	900											
	Mold height min.	mm	400											
	Mold height max.	mm	880											
	Total daylight max.	mm	1780											
	Dist. Between tie-bars (H×V)	mm	970×970											
	Size of mold platen (H×V)	mm	1320×1320											
	Mold dimension min.	mm	630×630											
	Ejector stroke	mm	180											
	Ejector force	kN	154											
INJECTION UNIT			A	B	C	A	B	C	A	B	C	A	B	C
	Screw diameter	mm	55	60	65	60	65	70	65	70	80	75	80	90
	Screw L/D ratio	L/D	21.8	20	18.5	21.6	20	18.6	21.5	20	17.5	21.3	20	17.8
	Injection volume (theoretical) [1]	cm^3	617	735	862	791	929	1077	1068	1239	1618	1634	1859	2353
	Injection weight (PS) [2]	g	562	668	785	720	845	980	972	1127	1472	1487	1692	2141
	Injection pressure [3]	MPa	214	180	153	210	180	155	210	180	138	205	180	142
		bar	2140	1800	1530	2100	1800	1550	2100	1800	1380	2050	1800	1420
	Holding pressure [3]	MPa	190	160	136	187	160	138	190	162	124	185	162	128
		bar	1900	1600	1360	1870	1600	1380	1900	1620	1240	1850	1620	1280
	Screw speed	rpm	300			250			240			220		
	Plasticizing rate (GPPS) [4]	g/s	54	64	71	57	68	72	62	71	88	70	92	105
	Plasticizing rate (HDPE) [5]	g/s	-	-	-	-	-	-	93	111	132	105	141	165
	Nozzle contact force	kN	85			85			85			85		
	INJECTION UNIT		**1400**			**1700**			**2250**			**3350**		
	Injection speed	mm/s	160			160			160			160		
	Injection rate (PS)	g/s	332	395	463	395	463	537	463	537	702	617	702	889
	INJECTION UNIT		**1400h**			**1700h**			**2250h**			**-**		
	Injection speed	mm/s	250			250			250			-		
	Injection rate (PS)	g/s	518	617	724	617	724	840	723	839	1097	-	-	-
OTHERS	Connection power	kW/A	1400:52/87 1400h:65/109			1700:58/98 1700h:74/125			2250:65/109 2250h:89/150			83/138		
	Heating power	kW	29.3			33.1			36.1			42.6		
	Machine dimension	m	8.48×2.29×2.50			8.62×2.29×2.50			8.48×2.29×2.50			8.74×2.29×2.50		
	Machine weight	t	-			27.33			28.55			28.64		
	Hopper capacity (OP)	l	50			50			50			100		
	Pressure	MPa	17.5			17.5			17.5			17.5		
	Flow	l/min	204			204			204			204		
	Oil tank	l	284			284			284			284		

NOTE: [1] Shot volume is the theoretical value which equals to cross section area of screw cylinder or barrel plunger × screw stroke.

[2] Shot weight (PS) is the theoretical value of shot volume melt density of PS.It is not a measured value.

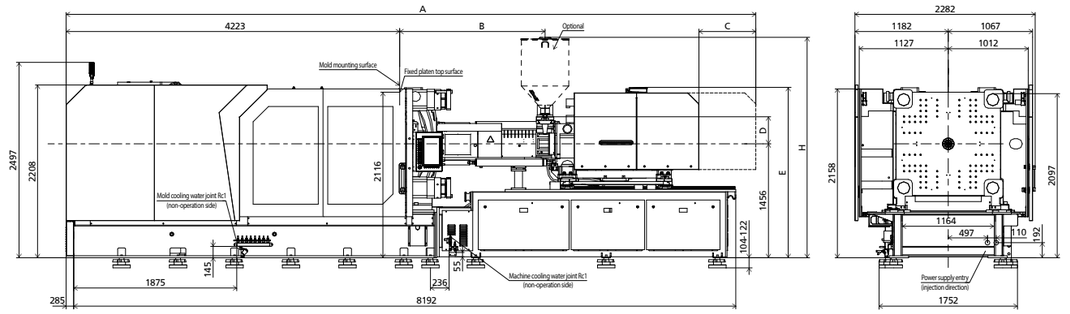
[3] Injection & holding pressure are theoretical values of machine output, not the actual resin pressure.

[4] Plasticizing capacity(GPPS):GB standard,with applicationg of GPPS plasticizing capacity of 3-zone screws.

[5] Plasticizing capacity(HDPE):Euromap 19.with application of HDPE plasticizing capacity of barrier screws.

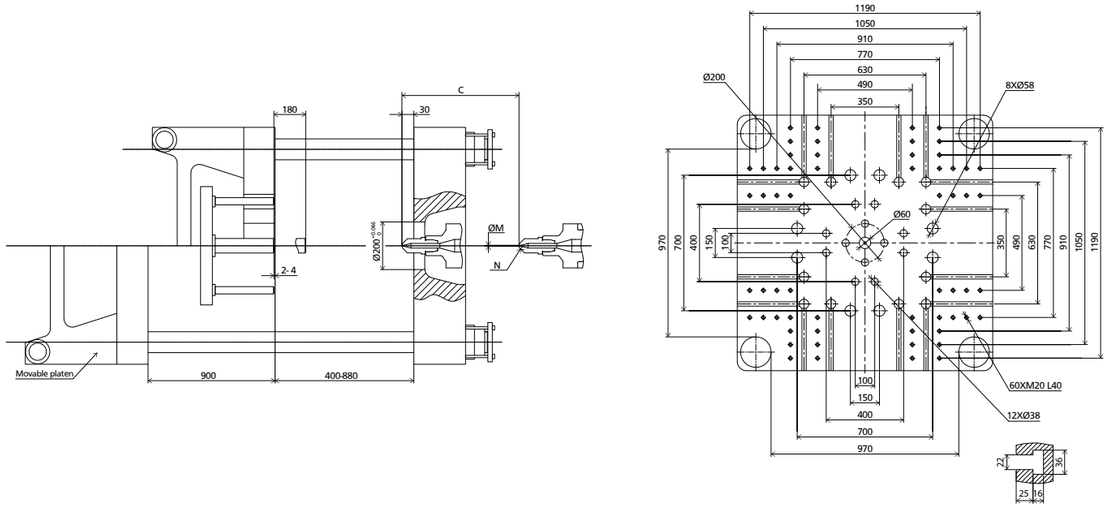
This parameter table is based on machine standard configuration;
We reserve the right to make changes as a result of further technical advances.

MACHINE DIMENSIONS

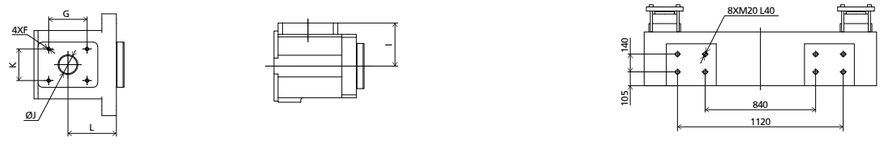


	A	B	C	D	E	F	G	H	I	J	K	L	M	N
1400h,1400	8176	1383	560	245	2167	4XM10 L20	115	2304	143	82	115	204	Ø3	SR10
1700h,1700	8619	1543	560	250	2259	4XM10 L20	115	2309	148	95	115	222.5	Ø3	SR10
2250h,2250	8353	1630	610	327	2107	4XM10 L20	115	2470	225	85	115	70	Ø4	SR15
3350	8732	1841	720	346	2107	4XM12 L25	170	2796	225	100	170	128	Ø4	SR15

PLATEN DIMENSIONS



OTHERS DIMENSIONS



HOPPER MOUNTING DIMENSION

ROBOT TOP VIEW FIXED PLATEN

TECHNICAL DATA ZE6500 V

CLAMPING UNIT	Clamping force	kN	6500											
	Mold opening stroke	mm	1000											
	Mold height min.	mm	420											
	Mold height max.	mm	1000											
	Total daylight max.	mm	2000											
	Dist. Between tie-bars (H×V)	mm	1080×1080											
	Size of mold platen (H×V)	mm	1460×1460											
	Mold dimension min.	mm	700×700											
	Ejector stroke	mm	200											
	Ejector force	kN	196											
INJECTION UNIT			A	B	C	A	B	C	A	B	C	A	B	C
	Screw diameter	mm	60	65	70	65	70	80	75	80	90	80	90	100
	Screw L/D ratio	L/D	21.6	20	18.6	21.5	20	17.5	21.3	20	17.8	24.8	22	19.8
	Injection volume (theoretical) [1]	cm^3	791	929	1077	1068	1239	1618	1634	1859	2353	2261	2862	3534
	Injection weight (PS) [2]	g	720	845	980	972	1127	1472	1487	1692	2141	2058	2605	3216
	Injection pressure [3]	MPa	210	180	155	210	180	138	205	180	142	227	180	145
		bar	2100	1800	1550	2100	1800	1380	2050	1800	1420	2270	1800	1450
	Holding pressure [3]	MPa	187	160	138	190	162	124	185	162	128	204	162	131
		bar	1870	1600	1380	1900	1620	1240	1850	1620	1280	2040	1620	1310
	Screw speed	rpm	250			240			220			190		
	Plasticizing rate (GPPS) [4]	g/s	57	68	72	62	71	88	70	92	105	85	107	131
	Plasticizing rate (HDPE) [5]	g/s	-	-	-	93	111	132	105	141	165	128	162	200
	Nozzle contact force	kN	85			85			85			85		
	INJECTION UNIT		**1700**			**2250**			**3350**			**5200**		
	Injection speed	mm/s	160			160			160			160		
	Injection rate (PS)	g/s	395	463	537	463	537	702	617	702	889	702	889	1097
	INJECTION UNIT		**1700h**			**2250h**			**-**			**-**		
	Injection speed	mm/s	250			250			-			-		
	Injection rate (PS)	g/s	617	724	840	723	839	1097	-	-	-	-	-	-
OTHERS	Connection power	kW/A	1700:58/98 1700h:74/125			2250:65/109 2250h:89/150			83/138			98/164		
	Heating power	kW	33.1			36.1			42.6			54.3		
	Machine dimension	m	9.70×2.44×2.70			9.70×2.44×2.70			9.70×2.44×2.70			9.81×2.44×2.70		
	Machine weight	t	32.98			34.20			34.30			35.33		
	Hopper capacity (OP)	l	50			50			100			100		
	Pressure	MPa	17.5			17.5			17.5			17.5		
	Flow	l/min	252			252			252			252		
	Oil tank	l	353			353			353			353		

NOTE: [1] Shot volume is the theoretical value which equals to cross section area of screw cylinder or barrel plunger × screw stroke.

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[3] Injection & holding pressure are theoretical values of machine output, not the actual resin pressure.

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[5] Plasticizing capacity(HDPE):Euromap 19.with application of HDPE plasticizing capacity of barrier screws.

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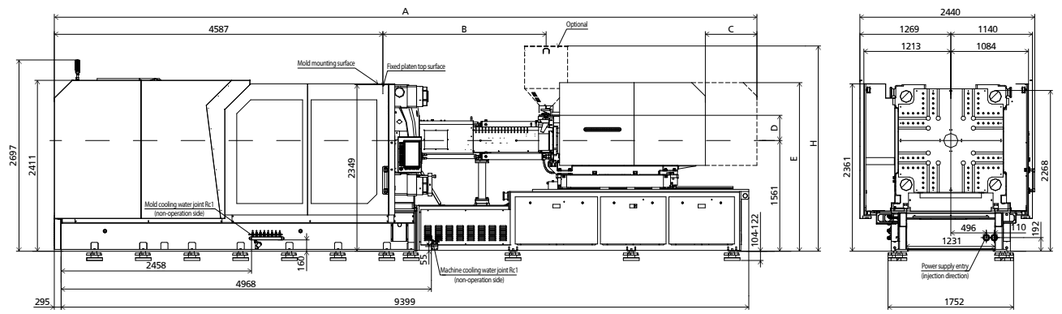
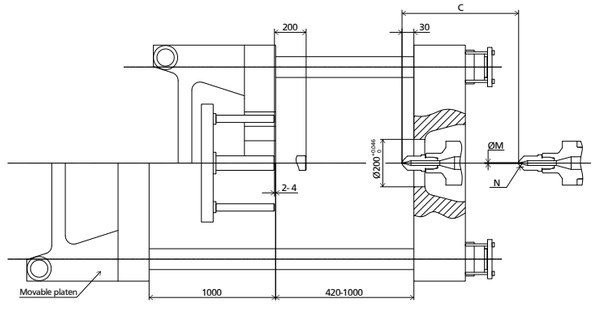
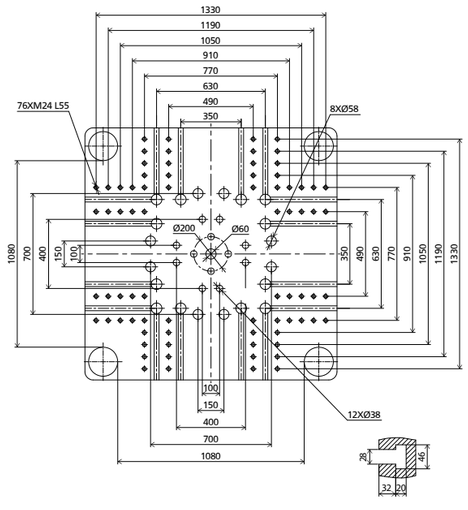
MACHINE DIMENSIONS



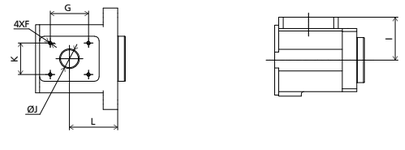
	A	B	C	D	E	F	G	H	I	J	K	L	M	N
1700h,1700	8983	1543	560	250	2364	4XM10 L20	115	2414	148	95	115	222.5	Ø3	SR10
2250h,2250	8717	1630	610	327	2212	4XM10 L20	115	2575	225	85	115	70	Ø4	SR15
3350	9096	1841	720	346	2212	4XM12 L25	170	2901	225	100	170	128	Ø4	SR15
5200	9808	2278	720	356	2378	4XM12 L20	170	2895	220	100	170	105	Ø4	SR15

PLATEN DIMENSIONS

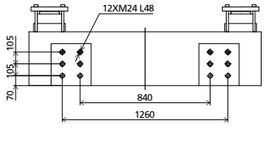




OTHERS DIMENSIONS



HOPPER MOUNTING DIMENSION



ROBOT TOP VIEW FIXED PLATEN

TECHNICAL DATA ZE8500 V

CLAMPING UNIT	Clamping force	kN	8500										
	Mold opening stroke	mm	1200										
	Mold height min.	mm	450										
	Mold height max.	mm	1100										
	Total daylight max.	mm	2300										
	Dist. Between tie-bars (H×V)	mm	1160×1160										
	Size of mold platen (H×V)	mm	1550×1550										
	Mold dimension min.	mm	770×770										
	Ejector stroke	mm	200										
	Ejector force	kN	230										
INJECTION UNIT			A	B	C	A	B	C	A	B	C	A	B	C
	Screw diameter	mm	65	70	80	75	80	90	80	90	100	90	100	110
	Screw L/D ratio	L/D	21.5	20	17.5	21.3	20	17.8	24.8	22	19.8	24.4	22	20
	Injection volume (theoretical) [1]	cm^3	1068	1239	1618	1634	1859	2353	2261	2862	3534	2989	3691	4466
	Injection weight (PS) [2]	g	972	1127	1472	1487	1692	2141	2058	2605	3216	2720	3359	4064
	Injection pressure [3]	MPa	210	180	138	205	180	142	227	180	145	222	180	149
		bar	2100	1800	1380	2050	1800	1420	2270	1800	1450	2220	1800	1490
	Holding pressure [3]	MPa	190	162	124	185	162	128	204	162	131	200	162	133
		bar	1900	1620	1240	1850	1620	1280	2040	1620	1310	2000	1620	1330
	Screw speed	rpm	240			220			190			170		
	Plasticizing rate (GPPS) [4]	g/s	62	71	88	70	92	105	85	107	131	103	127	150
	Plasticizing rate (HDPE) [5]	g/s	93	111	132	105	141	165	128	162	200	156	191	228
	Nozzle contact force	kN	85			85			85			85		
	INJECTION UNIT		**2250**			**3350**			**5200**			**6700**		
	Injection speed	mm/s	160			160			160			150		
	Injection rate (PS)	g/s	463	537	702	617	702	889	702	889	1097	833	1029	1245
	INJECTION UNIT		**2250h**			**-**			**-**			**-**		
	Injection speed	mm/s	250			-			-			-		
	Injection rate (PS)	g/s	723	839	1097	-	-	-	-	-	-	-	-	-
OTHERS	Connection power	kW/A	2250:65/109 2250h:89/150			83/138			98/164			126/211		
	Heating power	kW	36.1			42.6			54.3			75.6		
	Machine dimension	m	11.17×2.49×2.67			11.17×2.49×2.67			11.17×2.49×2.67			11.17×2.49×2.67		
	Machine weight	t	49.10			49.20			50.20			50.30		
	Hopper capacity (OP)	l	50			100			100			100		
	Pressure	MPa	21			21			21			21		
	Flow	l/min	248			248			248			248		
	Oil tank	l	411			411			411			411		

NOTE: [1] Shot volume is the theoretical value which equals to cross section area of screw cylinder or barrel plunger × screw stroke.

[2] Shot weight (PS) is the theoretical value of shot volume melt density of PS.It is not a measured value.

[3] Injection & holding pressure are theoretical values of machine output, not the actual resin pressure.

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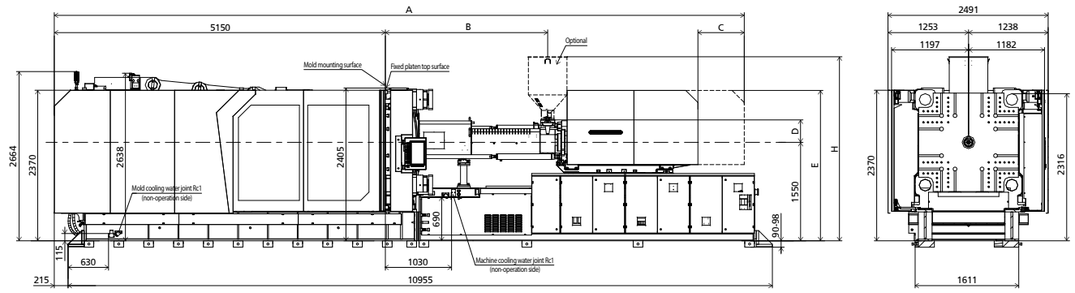
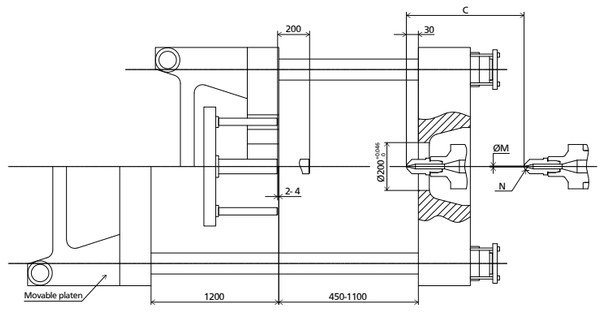
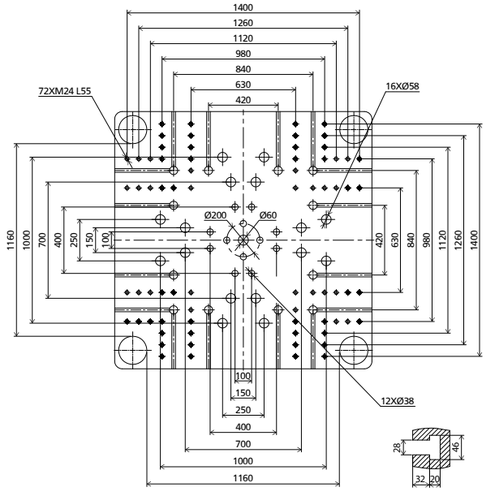
MACHINE DIMENSIONS



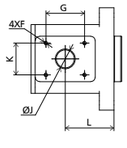
	A	B	C	D	E	F	G	H	I	J	K	L	M	N
2250h,2250	9280	1630	610	327	2201	4XM10 L20	115	2564	225	85	115	70	Ø4	SR15
3350	9549	1841	610	346	2201	4XM12 L25	170	2890	225	100	170	128	Ø4	SR15
5200	10371	2278	720	356	2367	4XM12 L20	170	2884	220	100	170	105	Ø4	SR15
6700	10732	2525	720	354	2367	4XM12 L20	170	2897	232	100	170	115	Ø6	SR20

PLATEN DIMENSIONS

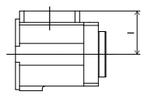


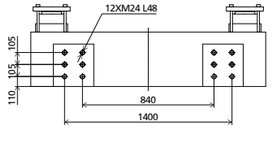


OTHERS DIMENSIONS



HOPPER MOUNTING DIMENSION





ROBOT TOP VIEW FIXED PLATEN

TECHNICAL DATA ZE10800 V

CLAMPING UNIT	Clamping force	kN	10800										
	Mold opening stroke	mm	1300										
	Mold height min.	mm	500										
	Mold height max.	mm	1200										
	Total daylight max.	mm	2500										
	Dist. Between tie-bars (H×V)	mm	1320×1320										
	Size of mold platen (H×V)	mm	1750×1750										
	Mold dimension min.	mm	870×870										
	Ejector stroke	mm	200										
	Ejector force	kN	230										
INJECTION UNIT			A	B	C	A	B	C	A	B	C	A	B	C
	Screw diameter	mm	75	80	90	80	90	100	90	100	110	100	110	120
	Screw L/D ratio	L/D	21.3	20	17.8	24.8	22	19.8	24.4	22	20	24.2	22	20.2
	Injection volume (theoretical) [1]	cm^3	1634	1859	2353	2261	2862	3534	2989	3691	4466	4005	4846	5767
	Injection weight (PS) [2]	g	1487	1692	2141	2058	2605	3216	2720	3359	4064	3644	4410	5248
	Injection pressure [3]	MPa	205	180	142	227	180	145	222	180	149	218	180	151
		bar	2050	1800	1420	2270	1800	1450	2220	1800	1490	2180	1800	1510
	Holding pressure [3]	MPa	185	162	128	204	162	131	200	162	133	195	162	136
		bar	1850	1620	1280	2040	1620	1310	2000	1620	1330	1950	1620	1360
	Screw speed	rpm	220			190			170			155		
	Plasticizing rate (GPPS) [4]	g/s	70	92	105	85	107	131	103	127	150	121	145	168
	Plasticizing rate (HDPE) [5]	g/s	105	141	165	128	162	200	156	191	228	181	217	247
	Nozzle contact force	kN	85			85			85			137.2		
	INJECTION UNIT		**3350**			**5200**			**6700**			**8700**		
	Injection speed	mm/s	160			160			150			150		
	Injection rate (PS)	g/s	617	702	889	702	889	1097	833	1029	1245	1029	1245	1482
	INJECTION UNIT		-			-			-			-		
	Injection speed	mm/s	-			-			-			-		
	Injection rate (PS)	g/s	-	-	-	-	-	-	-	-	-	-	-	-
OTHERS	Connection power	kW/A	83/138			98/164			126/211			151/254		
	Heating power	kW	42.6			54.3			75.6			82.8		
	Machine dimension	m	12.27×2.82×2.76			12.27×2.82×2.76			12.27×2.82×2.76			12.27×2.82×2.76		
	Machine weight	t	58.90			59.90			60.00			63.10		
	Hopper capacity (OP)	l	100			100			100			200		
	Pressure	MPa	21			21			21			21		
	Flow	l/min	248			248			248			248		
	Oil tank	l	431			431			431			431		

NOTE: [1] Shot volume is the theoretical value which equals to cross section area of screw cylinder or barrel plunger × screw stroke.

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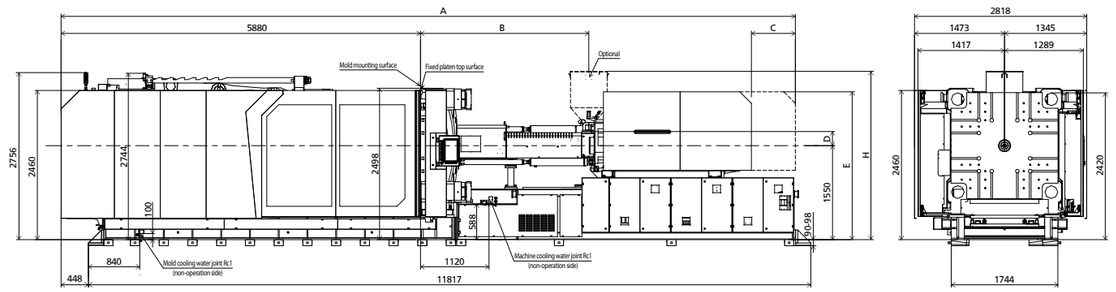
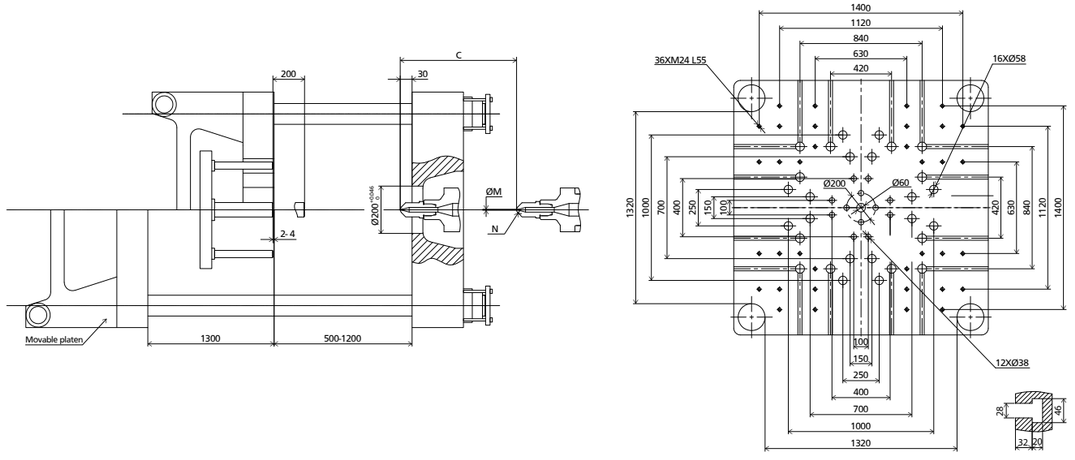
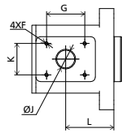


	A	B	C	D	E	F	G	H	I	J	K	L	M	N
3350	10389	1841	720	346	2201	4XM12 L25	170	2890	225	100	170	128	Ø4	SR15
5200	11101	2278	720	356	2367	4XM12 L20	170	2884	220	100	170	105	Ø4	SR15
6700	11462	2525	720	354	2367	4XM12 L20	170	2897	232	100	170	115	Ø6	SR20
8700	12012	2753	720	233	2439	4XM12 L20	170	2776	232	122	170	115	Ø6	SR20

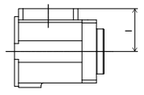
PLATEN DIMENSIONS

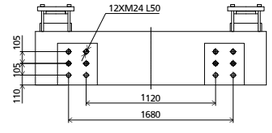


OTHERS DIMENSIONS



HOPPER MOUNTING DIMENSION





ROBOT TOP VIEW FIXED PLATEN

TECHNICAL DATA ZE13800 V

CLAMPING UNIT	Clamping force	kN	13800							
	Mold opening stroke	mm	1500							
	Mold height min.	mm	650							
	Mold height max.	mm	1300							
	Total daylight max.	mm	2800							
	Dist. Between tie-bars (H×V)	mm	1550×1450							
	Size of mold platen (H×V)	mm	2150×2050							
	Mold dimension min.	mm	1030×970							
	Ejector stroke	mm	250							
	Ejector force	kN	300							
INJECTION UNIT			A	B	C	A	B	C	A	B	C
	Screw diameter	mm	80	90	100	90	100	110	100	110	120
	Screw L/D ratio	L/D	24.8	22	19.8	24.4	22	20	24.2	22	20.2
	Injection volume (theoretical) [1]	cm^3	2261	2862	3534	2989	3691	4466	4005	4846	5767
	Injection weight (PS) [2]	g	2058	2605	3216	2720	3359	4064	3644	4410	5248
	Injection pressure [3]	MPa	227	180	145	222	180	149	218	180	151
		bar	2270	1800	1450	2220	1800	1490	2180	1800	1510
	Holding pressure [3]	MPa	204	162	131	200	162	133	195	162	136
		bar	2040	1620	1310	2000	1620	1330	1950	1620	1360
	Screw speed	rpm		190			170			155	
	Plasticizing rate (GPPS) [4]	g/s	85	107	131	103	127	150	121	145	168
	Plasticizing rate (HDPE) [5]	g/s	128	162	200	156	191	228	181	217	247
	Nozzle contact force	kN		85			85			137.2	
	INJECTION UNIT			**5200**			**6700**			**8700**	
	Injection speed	mm/s		160			150			150	
	Injection rate (PS)	g/s	702	889	1097	833	1029	1245	1029	1245	1482
	INJECTION UNIT			-			-			-	
	Injection speed	mm/s		-			-			-	
	Injection rate (PS)	g/s	-	-	-	-	-	-	-	-	-
OTHERS	Connection power	kW/A		98/164			126/211			151/254	
	Heating power	kW		54.3			75.6			82.8	
	Machine dimension	m		12.72×3.31×3.05			12.72×3.31×3.05			12.72×3.31×3.05	
	Machine weight	t		91.50			91.60			94.70	
	Hopper capacity (OP)	l		100			100			200	
	Pressure	MPa		21			21			21	
	Flow	l/min		333			333			333	
	Oil tank	l		506			506			506	

NOTE: [1] Shot volume is the theoretical value which equals to cross section area of screw cylinder or barrel plunger × screw stroke.

[2] Shot weight (PS) is the theoretical value of shot volume melt density of PS.It is not a measured value.

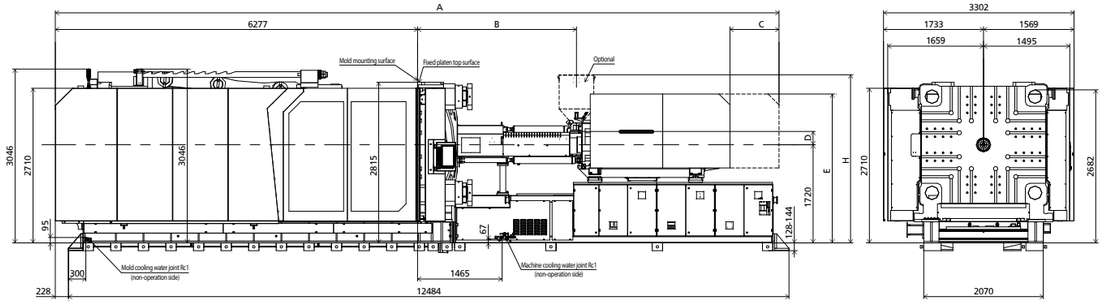
[3] Injection & holding pressure are theoretical values of machine output, not the actual resin pressure.

[4] Plasticizing capacity(GPPS):GB standard,with applicationg of GPPS plasticizing capacity of 3-zone screws.

[5] Plasticizing capacity(HDPE):Euromap 19.with application of HDPE plasticizing capacity of barrier screws.

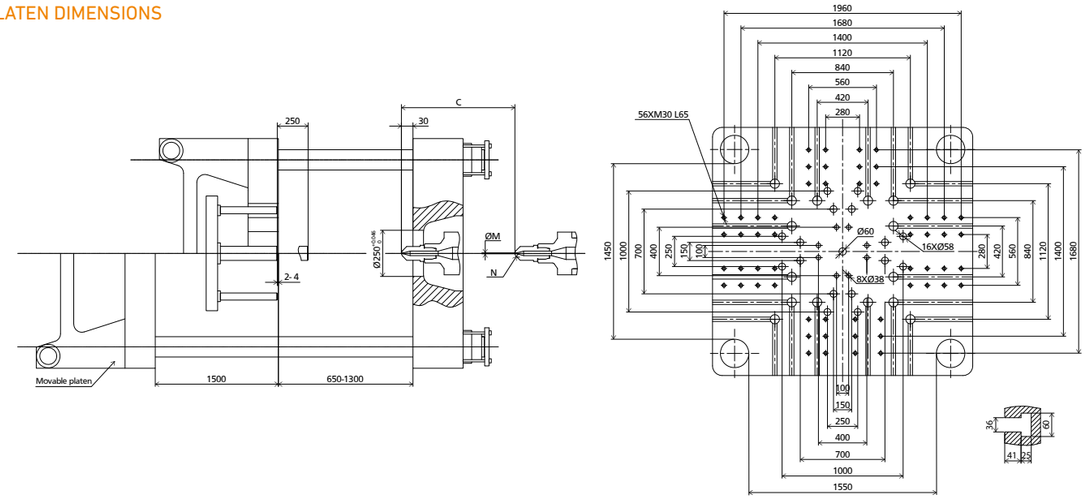
This parameter table is based on machine standard configuration;
We reserve the right to make changes as a result of further technical advances.

MACHINE DIMENSIONS

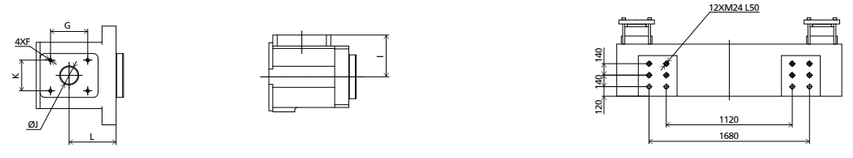


	A	B	C	D	E	F	G	H	I	J	K	L	M	N
5200	11628	2278	850	356	2537	4XM12 L20	170	3054	220	100	170	105	Ø4	SR15
6700	11989	2525	850	354	2537	4XM12 L20	170	3067	232	100	170	115	Ø6	SR20
8700	12539	2753	850	233	2609	4XM12 L20	170	2946	232	122	170	115	Ø6	SR20

PLATEN DIMENSIONS



OTHERS DIMENSIONS



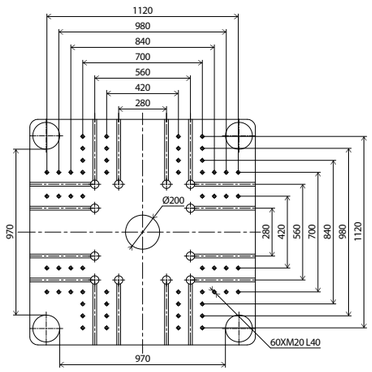
HOPPER MOUNTING DIMENSION

ROBOT TOP VIEW FIXED PLATEN

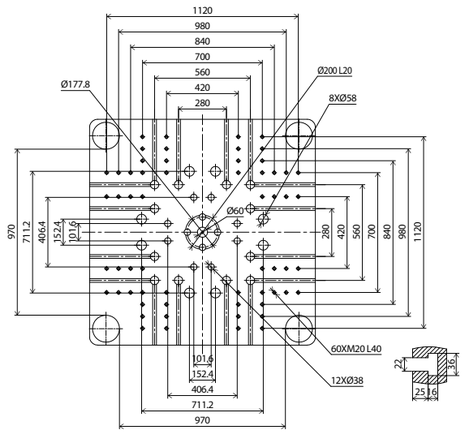
TECHNICAL DATA ZE5500 V

EUROPEAN VERSION

FIXED PLATEN

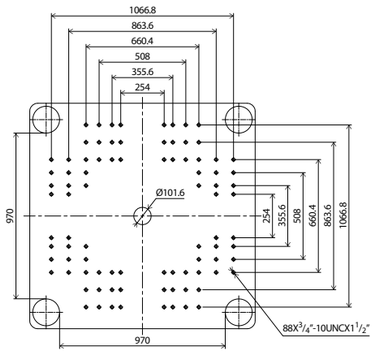


MOVABLE PLATEN



AMERICAN VERSION

FIXED PLATEN



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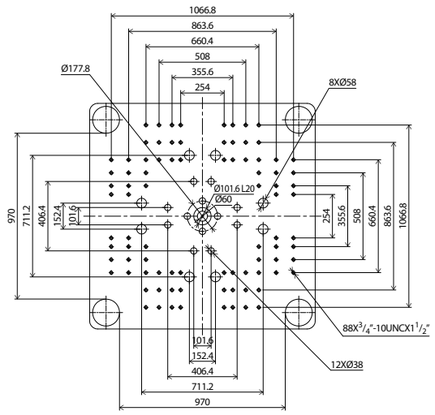
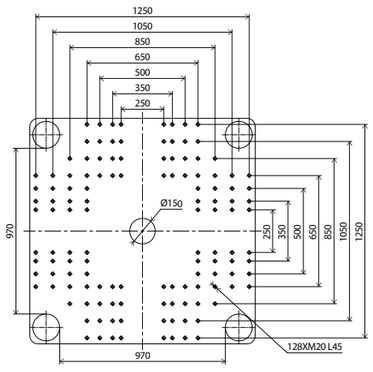


JAPANESE VERSION

FIXED PLATEN



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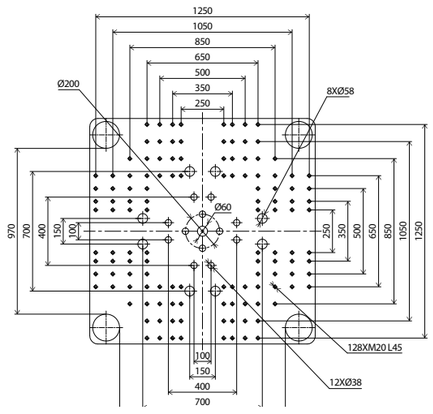
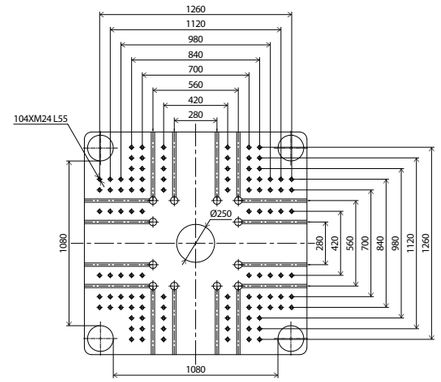


We reserve the right to make changes as a result of further technical advances.

TECHNICAL DATA ZE6500 V

EUROPEAN VERSION

FIXED PLATEN



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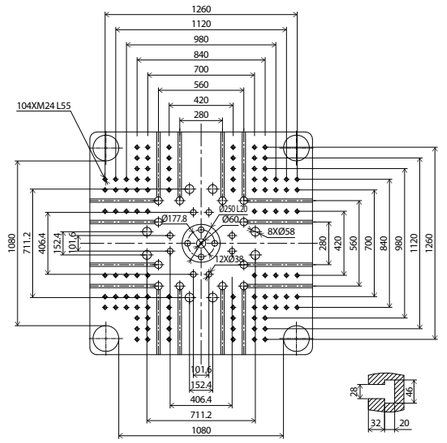
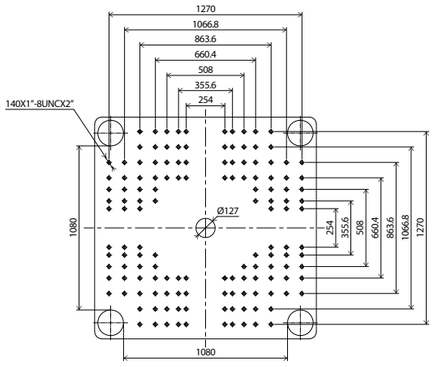


AMERICAN VERSION

FIXED PLATEN



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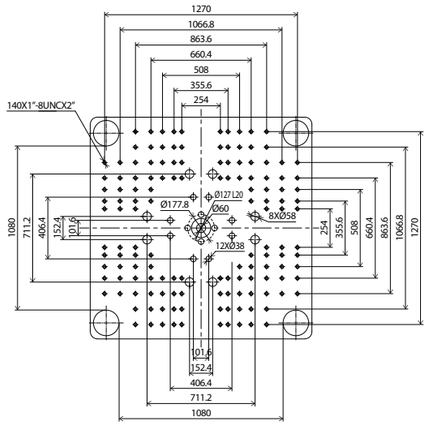

JAPANESE VERSION

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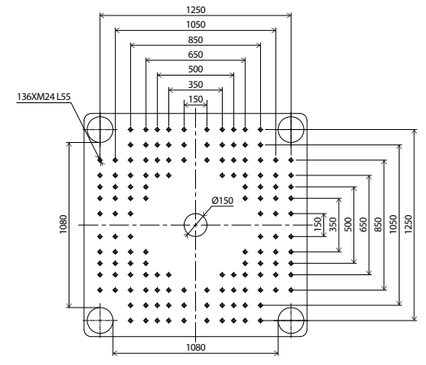

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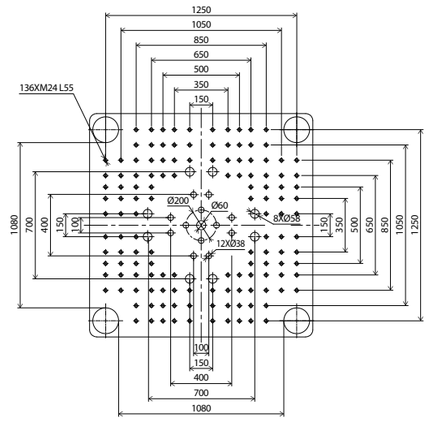

TECHNICAL DATA ZE8500 V

EUROPEAN VERSION

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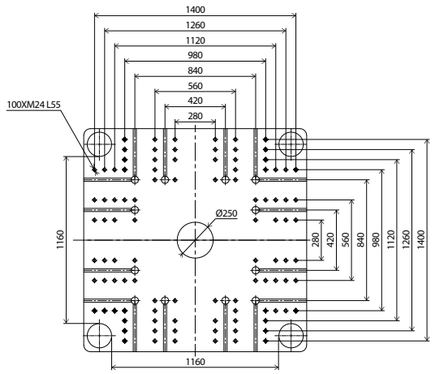

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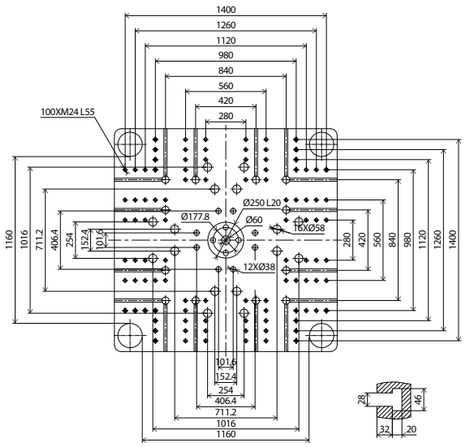

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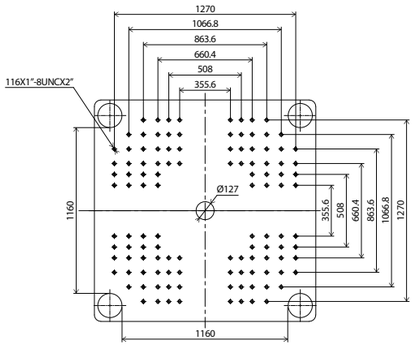
FIXED PLATEN



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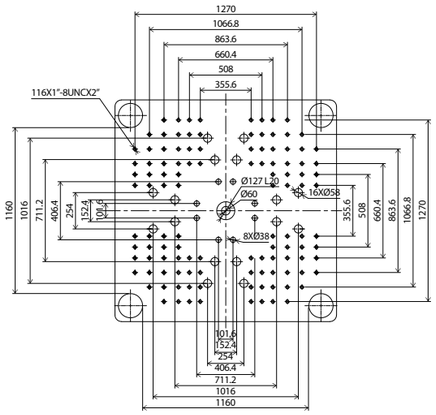
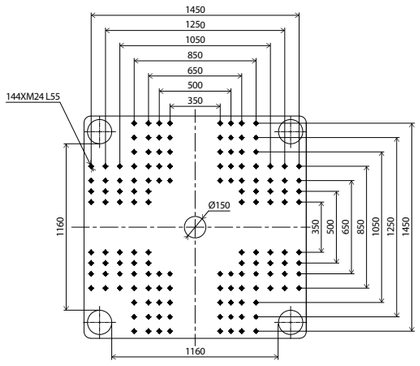


JAPANESE VERSION

FIXED PLATEN



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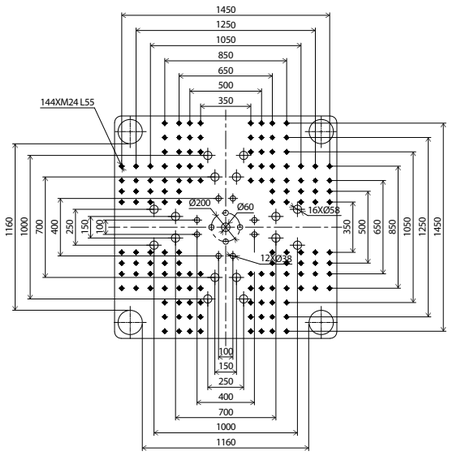
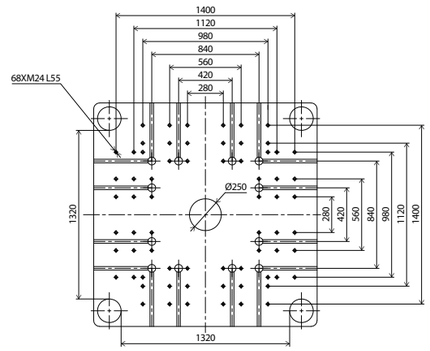


We reserve the right to make changes as a result of further technical advances.

TECHNICAL DATA ZE10800 V

EUROPEAN VERSION

FIXED PLATEN



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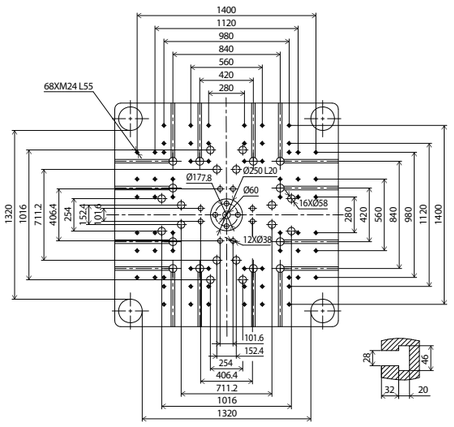

AMERICAN VERSION

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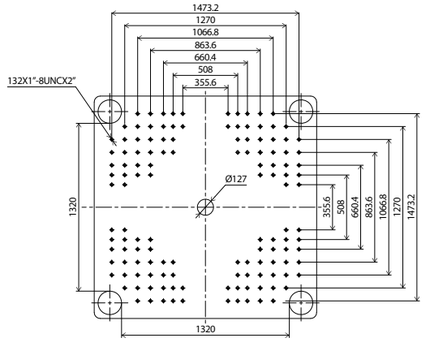

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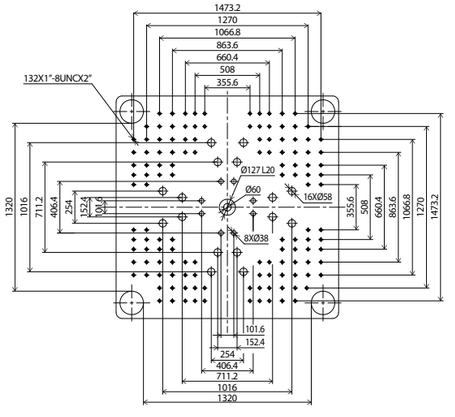
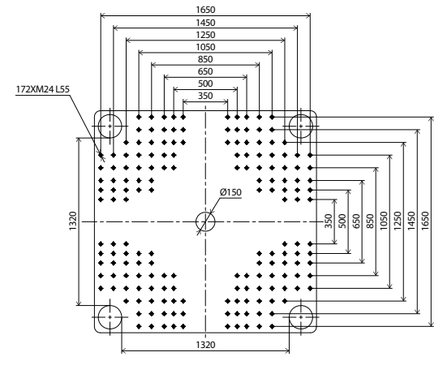


JAPANESE VERSION

FIXED PLATEN



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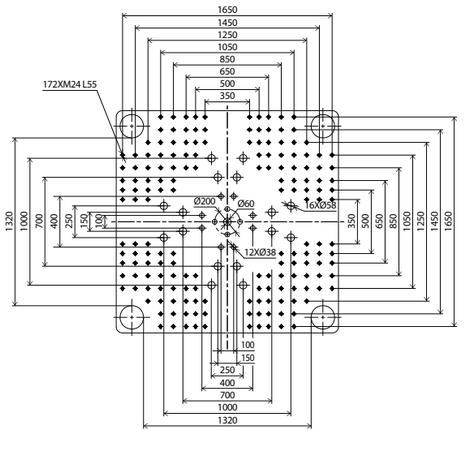
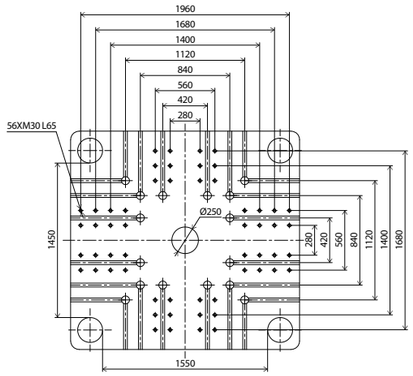


TECHNICAL DATA ZE13800 V

EUROPEAN VERSION

FIXED PLATEN



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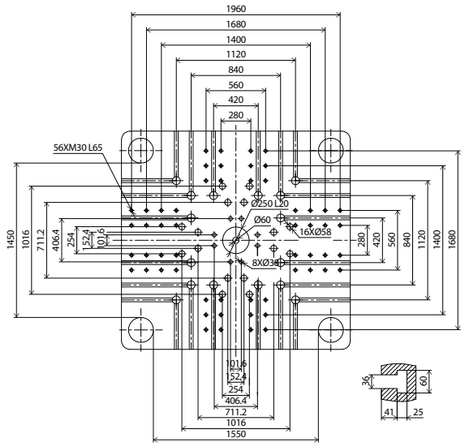
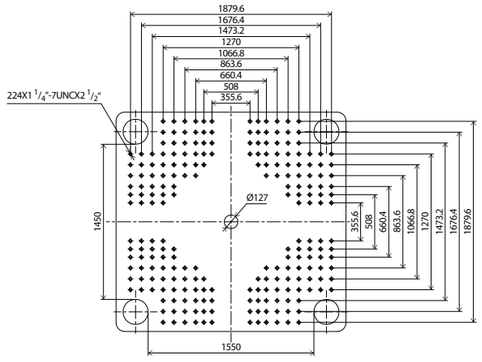


AMERICAN VERSION

FIXED PLATEN



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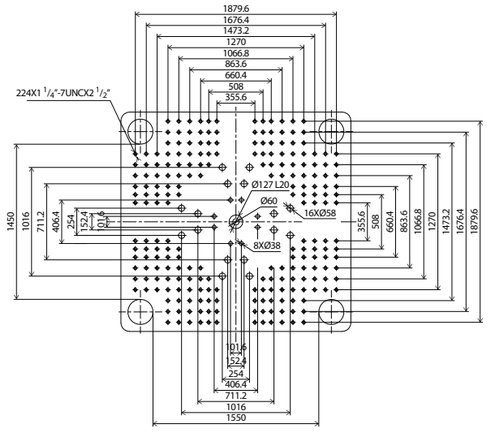
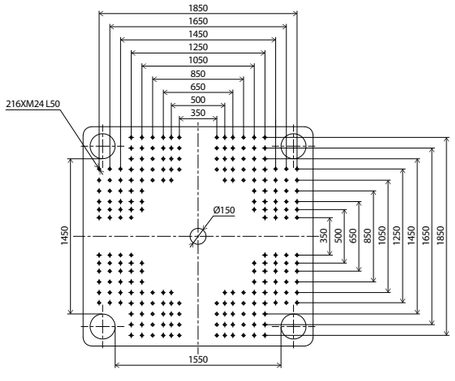


JAPANESE VERSION

FIXED PLATEN



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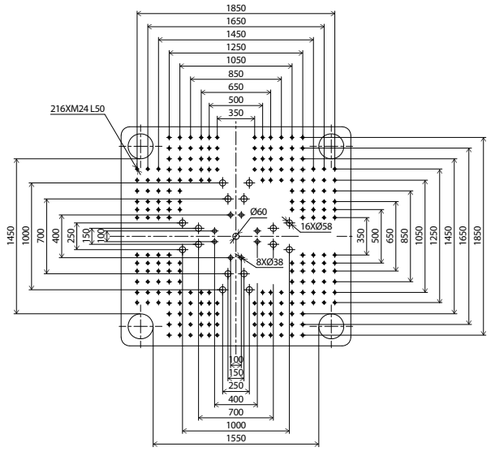

We reserve the right to make changes as a result of further technical advances.

STANDARD EQUIPMENT LIST

GENERAL EQUIPMENT

- Basic safety device according to GB/22530
- ZHAFIR colors: RAL9010, RAL5003
- Power supply: 380VAC, 3PH+N+PE
- Sigmatek controller, 15.1 inch touch screen
- Injection, dosing, platen movement and ejector movement driven independently by servo motor, optical encoder position detection
- LUBE central lubrication system

INJECTION UNIT

- Abrasion-resistant screw set, general version
- Open nozzle
- Barrel heating temperature PID control, SSR
- Extended nozzle, temperature PID control independently
- Feeding zone temperature closed-loop control
- Injection speed 6 steps
- Speed responding mode adjustable
- Holding pressure 4 steps
- Pressure responding mode adjustable
- V/P switch over methods by position/ time/ pressure combinations
- Dosing rotation speed 3 steps
- Back pressure 3 steps
- HPM over-filling protection function
- Screw retraction before and/or after dosing
- Auto purge

CLAMPING UNIT

- 5-point twin toggle mechanism
- Center pressing platen
- Clamping force settable at control panel
- Automatic mold-height adjustment
- Platen moving speed 6 steps
- AI mold protection
- Clamping force pre-release
- Ejector speed 3 steps
- Ejector pressure 3 steps
- Multi ejection function
- Ejection parallel to mold opening

FUNCTIONS & CONTROLS

- Multi-language available (Chinese, German, English, Japanese etc.)
- Metric/Imperial unit selectable
- Dosing parallel to mold opening
- Injection compression
- Production assistant device function
- Maintenance alert
- 5000 cycles process data recording
- Amendment report
- Alarm record
- Quality control function
- Mold profile data memory (up to 200 sets)
- 2 USB interface
- USB printer interface
- Injection speed & pressure curve
- 1 free programmable I/O
- Mold ejector protection interface
- EUROMAP 12 interface for handling device
- Auxiliary socket 3PH/380V 32A×1, 16A×2
- 3 color alarm lamp (red/yellow/green)

OTHERS

- Tool kit & spare parts package
- Leveling pads
- Documents with machine
- Operating manual

We reserve the right to make changes as a result of further technical advances.

NOTE

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