

**CLF**



Polaris

## **PAINT BUCKET**

**PLASTIC INJECTION MOLDING MACHINE**



**1 新型**  
**NEW MODEL**

**2 穩定**  
**STABLE**

**3 精確**  
**ACCURATE**

**4 高效能**  
**HIGH EFFICIENCY**

CLF offer 5L-20L paint buckets, include paint buckets cover and handle. In the clamping unit, CLF use the TWII outward toggle series and add the high standard of injection unit to meet the injection volume demand. In order to save cycle time and increase productivity, we increase injection speed and plan to use electric charge and core ejector on fly. In addition, we will follow customers request and choose the high rigidity of machine to operate. At the automatic production side, we can use the robot to pick up the products. We also can use IML systems on the paint buckets and the cover include some automatic production equipment. CLF injection molding machines have ability and confidence to turn-key export. Include the mold and other related equipments. CLF expect to create high efficiency and high productivity value for customers.

#### Features :

- Using servo energy-saving system, and energy saving is 60% higher than traditional hydraulic system.
- Improve the injection speed and high plasticizing ability, and also achieve product stability and high productivity.
- With high-mixing, high plasticizing type of PP special screw, the plastic mixing well and have high efficient production.
- The latest outward toggle type mold-clamping features, due to the supporting force is close to the middle, the mold is not easy deformed, and high yield rate of product.
- The newest injection unit using high rigidity and low-friction linear slide design.
- Up to 15L of paint buckets, the machine have include standard equipment of electric charging system, it also have the action of mold opening, charging, ejection and core-pulling, saving energy and shorten cycle time.



# PAINT BUCKET SERIES



| PAINT BUCKET TYPE      |        | 5L                   | 10L                  | 15L                               | 20L                   |
|------------------------|--------|----------------------|----------------------|-----------------------------------|-----------------------|
| Caliber                | mm     | φ180 x 230H          | φ275 x 273H          | φ302 x 316H                       | φ305 x 370H           |
| Single piece weight    | g      | 200                  | 470                  | 560                               | 730                   |
| Mold cavity            | Cavity | 1                    | 1                    | 1                                 | 1                     |
| Production cycle       | sec.   | 16                   | 17                   | 18                                | 20                    |
| Productivity (one day) | piece  | 5400                 | 5082                 | 4800                              | 4320                  |
| Machine model          |        | 300TWII + 1400 - D60 | 420TWII + 2810 - D80 | 500TWII + 4350 - D90              | 600TWII + 8000 - D110 |
| Remarks                |        | -                    | -                    | Triple circuit + electric storage |                       |

| PAINT BUCKET COVER TYPE |        | 5L                   | 10L                  | 15L                  | 20L                 |
|-------------------------|--------|----------------------|----------------------|----------------------|---------------------|
| Caliber                 | mm     | φ178 x 20H           | φ275 x 25H           | φ302 x 25H           | φ305 x 35H          |
| Single piece weight     | g      | 36                   | 155                  | 160                  | 260                 |
| Mold cavity             | Cavity | 2                    | 1                    | 1                    | 1                   |
| Production cycle        | sec.   | 12                   | 14                   | 14                   | 17                  |
| Productivity (one day)  | piece  | 14400                | 6171                 | 6171                 | 5082.352941         |
| Machine model           |        | 250TWII + 1100 - D50 | 300TWII + 1440 - D60 | 300TWII + 1400 - D60 | 300TWII + 1400 - D6 |

| PAINT BUCKET HANDLE TYPE |        | 5L                  | 10L                 | 15L                 | 20L                 |
|--------------------------|--------|---------------------|---------------------|---------------------|---------------------|
| Size                     | mm     | φ320 x 10 x 18.5    | φ470 x 10 x 18.5    | φ510 x 10 x 18.5    | φ520 x 10 x 18.5    |
| Single piece weight      | g      | 10                  | 13                  | 16                  | 18                  |
| Mold cavity              | Cavity | 4                   | 4                   | 4                   | 4                   |
| Production cycle         | sec.   | 12                  | 14                  | 14                  | 14                  |
| Productivity (one day)   | piece  | 28800               | 24686               | 24686               | 24686               |
| Machine model            |        | 200TWII + 720 - D45 | 200TWII + 720 - D45 | 200TWII + 720 - D45 | 200TWII + 720 - D45 |

| Machine Model                    |                      | 200TWII          | 250TWII         | 300TWII          | 420TWII         | 500TWII          | 600TWII         |
|----------------------------------|----------------------|------------------|-----------------|------------------|-----------------|------------------|-----------------|
| International code               |                      | 2000H-720        | 2500H-1100      | 3000H-1400       | 4200H-2810      | 5000H-4350       | 6000H-8000      |
| INJECTION UNIT                   |                      | Unit             |                 |                  |                 |                  |                 |
| Screw diameter                   | mm                   | 45               | 50              | 60               | 80              | 90               | 110             |
| Theoretical injection volume     | cm <sup>3</sup>      | 398              | 530             | 848              | 1960            | 2863             | 4989            |
| Injection pressure               | kg/cm <sup>2</sup>   | 1801             | 2077            | 1653             | 1434            | 1521             | 1621            |
| Injection rate                   | cm <sup>3</sup> /sec | 188              | 218             | 339              | 648             | 795              | 1150            |
| Shot weight in PP                | gram                 | 290              | 387             | 619              | 1431            | 2090             | 3642            |
| Screw rotating speed             | rpm                  | 283              | 269             | 200              | 240             | 200              | 150             |
| CLAMPING UNIT                    |                      |                  |                 |                  |                 |                  |                 |
| Distance between columns [H x V] | mm                   | 530 x 460        | 580 x 510       | 630 x 550        | 760 x 660       | 850 x 700        | 950 x 800       |
| Dimension of platens             | mm                   | 760 x 690        | 840 x 770       | 920 x 840        | 1090 x 990      | 1200 x 1050      | 1355 x 1205     |
| Mold hight max./min.             | mm                   | 550/150          | 600/200         | 650/200          | 750/250         | 750/250          | 900/300         |
| Mold opening stroke              | mm                   | 550              | 600             | 650              | 750             | 850              | 1000            |
| Clamping force                   | ton                  | 200              | 250             | 300              | 420             | 500              | 600             |
| Dia. of locating ring            | mm                   | 160              | 160             | 160              | 160             | 160              | 200             |
| Ejector stroke                   | mm                   | 150              | 150             | 150              | 200             | 200              | 200             |
| Ejector force                    | ton                  | 4.8              | 6.5             | 6.5              | 7.5             | 7.5              | 11              |
| GENERAL DATA                     |                      |                  |                 |                  |                 |                  |                 |
| Heating zones                    | zone                 | 5                | 5               | 6                | 8               | 9                | 11              |
| Heating capacity                 | kW                   | 12               | 15.1            | 19               | 30.6            | 36.6             | 52.8            |
| Pump driving motor               | kW                   | 22               | 30              | 37.5             | 75              | 93.5             | 145             |
| Oil tank capacity                | L                    | 300              | 450             | 600              | 850             | 1200             | 1800            |
| Machine dimension[L x W x H]     | m                    | 5.7 x 1.54 x 1.9 | 6.35 x 1.62 x 2 | 6.9 x 1.75 x 2.1 | 8.3 x 1.8 x 2.1 | 9.5 x 1.95 x 2.1 | 11 x 2.15 x 2.1 |
| Net weight                       | ton                  | 8                | 10              | 12               | 20              | 25               | 35              |

\* All specification, dimensions and design characteristics shown in this catalogue are subject to change without notice.

[www.clf.com.tw](http://www.clf.com.tw)



# PAINT BUCKET

## PLASTIC INJECTION MOLDING MACHINE

DESIGNED BY POLARIS 2019.09 / 1000PCS +886-4-24517070

### CHUAN LIH FA MACHINERY WORKS CO., LTD.

#### HEADQUARTER

No. 17, Ln. 360, Chung Cheng S. Rd., Yueng Kang Dist., Tainan 71047, TAIWAN  
TEL. +886-6-253-2111 FAX. +886-6-253-3311 / 254-8859 E-mail. [clf@clf.com.tw](mailto:clf@clf.com.tw)

#### KWAN-MIAO 3TH FACTORY

No. 68, Ln. 169, Sec. 2, Guanxin Rd., Guanmiao Dist., Tainan City 71841, TAIWAN  
TEL. +886-6-595-8133 FAX. +886-6-595-8130

#### ZHONG-SHAN FACTORY

No. 3, Nan-Ton Blvd., Nan-Tou Town, Zhong-Shan City, Guang-Dong Province, CHINA  
TEL. +86-7602-3116-801-5 FAX. +86-7602-3116-806

CE  
ISO9001



uCloud