



# MEGA MACHINERY MOLD CO.,LTD.

ADD: 47-8#HUANGZHOU RD., HUANGYAN, ZHEJIANG, CHINA  
TEL: 0086-576-84020122 FAX: 0086-576-84020107



HTTP://WWW.MEGAMACHINERY.CN  
E-MAIL: mega@hymega.com

## Company Introduction

**Mega Machinery** is the leading manufacturer of stretch blow moulding machines, extrusion blow moulding machines, injection molding machines and plastic injection moulds in China. our packaging department is focusing on a broad range of PET preform molding systems, closure moulding production line, stretch blow moulding equipments, and extrusion blow moulding machines. Injection mold department is dedicated in various plastic mould, such as the molds for automobiles, pallet, crate. Mega services to the global plastics industry.



### Our main products:

- \* Stretch blow moulding machine
- \* Extrusion blow moulding machine
- \* Injection moulding machines
- \* PET preform mould
- \* Cap mould
- \* Blow mould
- \* Injection mold

### MACHINE MANUFACTORY

MEGA Offers wide range of stretch blow molding machines and different type of injection molds. Every MEGA's machine or mold is designed for high performance, and easy to operate. We design and manufacture the parts by advanced machining tools, and follow strict ISO management for ensure the quality of our products. MEGA cares every little parts of our products.



### POWERFUL ADVANCED TECHNOLOGY

Our company owns high-precision numerical control machine tools and processing centers, advanced equipments and detectors, superior crafts and strict and sound quality management system. We also assemble a group of professional technique elites and leading scientific and technological personnel, making full use of the new technology, new crafts and new materials to ensure the stability and reliability of our products.



## EXPERTISE FOR TURN-KEY PRODUCTION LINE

We reduce packaging costs through line optimization measures like line audits, evaluation of bottle performance on each piece of equipment, validation of light-weight packages for pelletizing and shipping.



## HONORARY TESTIMONY

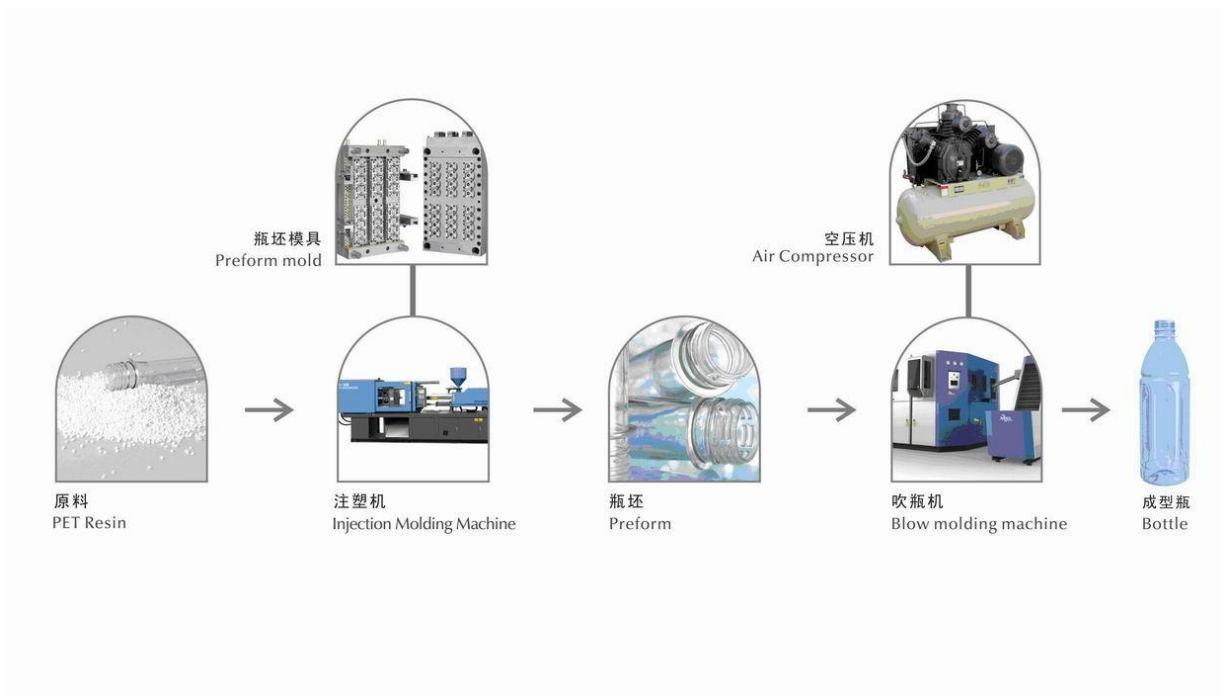
For year, Mega have gained many authorized attestations with our diligent works and innovations, Mega will always make effort to create wonders.



## PET preform line :



## PET preform making flow chart



## PET Preform Mould (Valve Gate)

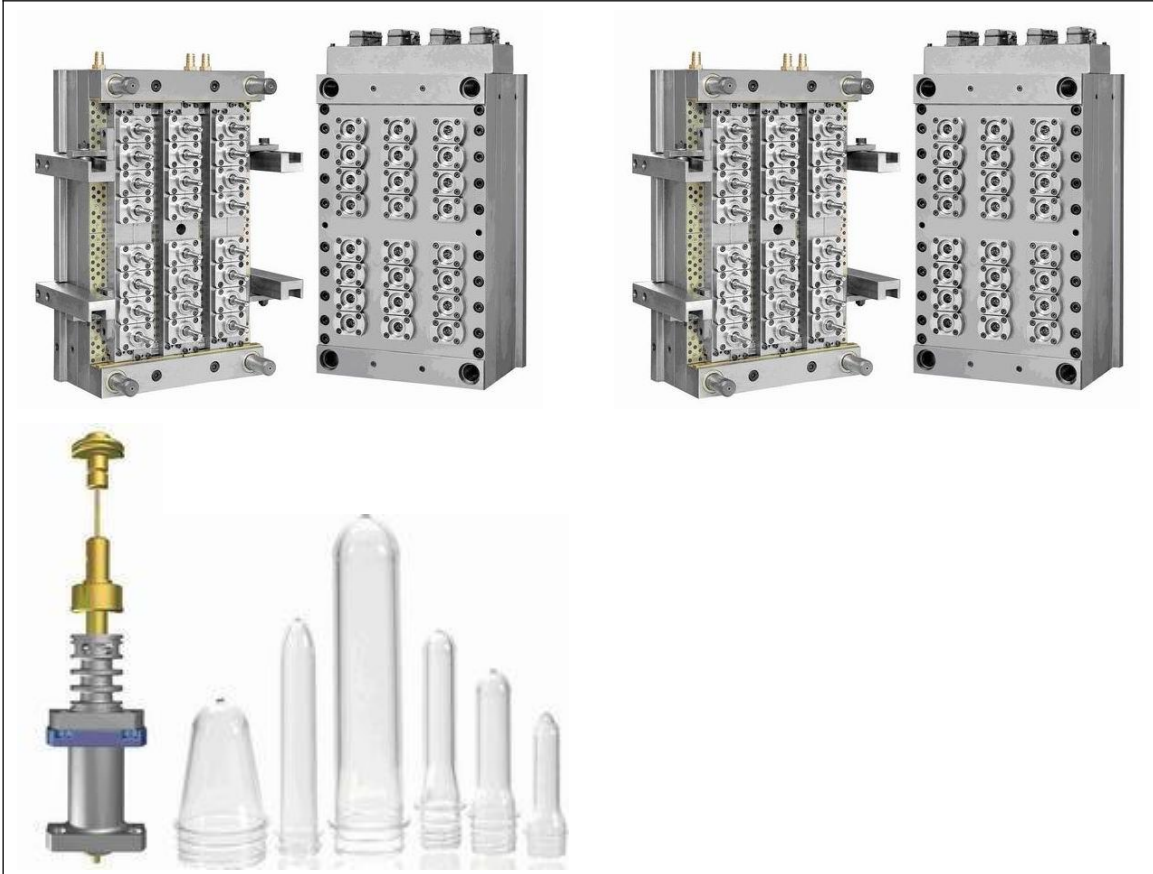


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## Quotation for the Preform Moulding production line

No	Product description	Model	QTY.	Unit Price (USD)	Amount (USD)	Capacity
<b>PET Injection molding system</b>						
1	MG-3980 PET Injection molding machine - servo motor	MG-3980 PET	1	47700	47700	
2	Preform 24 g 1881 neck mold	48 cavities	1	68000	68000	
3	Preform 9 g 1881 neck mold	48 cavities	1	64800	64800	
4	Autoloader	600	1	700	700	
5	Dehumidified drying	190kg	1	17700	17700	
6	air chiller	25HP	1	10000	10000	
8	Color dosing unit		1	3000	3000	
10	Air system LP		1	2500	2500	
				Amount : USD 214400		

Material of Preform mould(see as follows)	
Mould Base	4Cr13 Stainless Steel with HRC 32-38 with high grade steel
Cavity Insert	S136 with HRC50
Core Insert	S136 with HRC50
Neck Insert	S136 with HRC50
Heat Isolate Tip	America Dupont, Withstands 350 Degrees Temperature
Coiled Heater	Hotset Germany
Valve Pin	PUNCH JAPAN High Speed steel SKD51 with HRC 57-60
Gate Type	Hot Runner with Pneumatic Valve Gate System
Guarantee of the mold	5 million shot times



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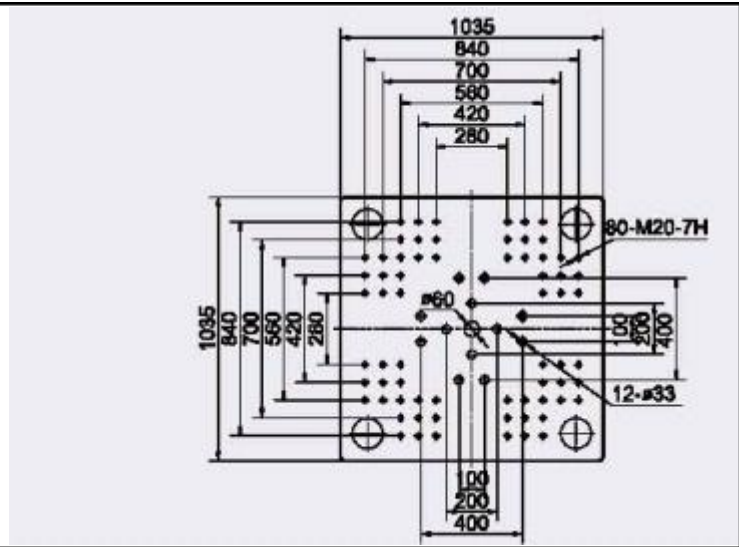


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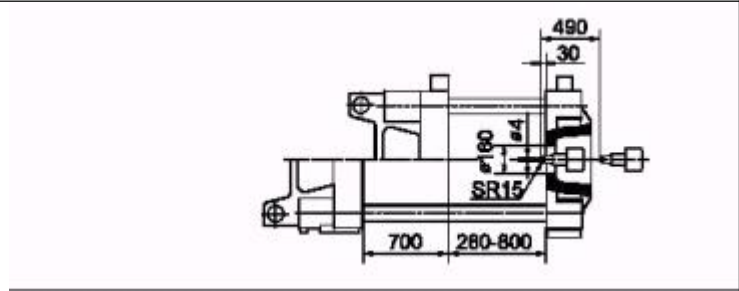
**Machine specification :**

SPECIFICATION	MG-3980		
	A	B	C
<b>INJECTION UNIT</b>			
Screw diameter      mm	70	75	80
Screw L/D ratio      L/D	21.4	20	18.8
Shot size (theoretical) cm <sup>3</sup>	1293	1485	1689
Injection weight(ps)    g	1177	1351	1537
Injection rate          g/s	366	395	446
Plasticizing capacity    g/d	60	65	70
Injection pressure      mpa	199	173	152
Screw speed            rpm	0~165		
<b>CLAMPING UNIT</b>			
Clamping tonnage      KN	3980		
Toggle stroke          mm	700		
Space between tie Bars   mm	720×720		
Max. mold height      mm	800		
Man. Mold height      mm	280		
Ejector stroke          mm	160		
Ejector tonnage        KN	110		
Ejector number        piece	13		
<b>OTHERS</b>			
Max. pump pressure    mpa	16		
Pump motor power      kw	37		
Heater power          kw	19.90		
Machine dimension(LxWxH) m	7.1×1.9×2.5		
Machine weight        t	15.7		
Hoper capacity        kg	50		
Oil tank capacity      L	750		

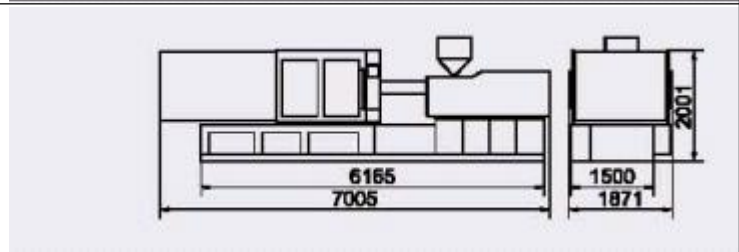
**Platen Dimensions Face**



**Platen Dimensions side**



**Machine dimensions**



Component list		
NO	ITEM	IMPORTED FORM
1	Controller	Techmation/Taiwan
2	Contactor	Schneider/France
3	Air breaker	Schneider/France
4	Thermal overload relay	Schneider/France
5	Linear transducer	Imported
6	Limited switches	Omron/Japan
7	Vane pump	SUMITOM/ Japan
8	Directional valve	Vickers/USA
9	Proportional valve	Dofluid/Taiwan

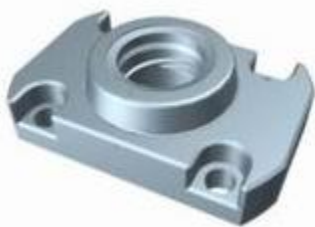
11	Five-star hydraulic motor	Intermot/Joint venture
12	Orbital hydraulic motor	Eaton/Joint venture
13	Lubrication pump	Automatic
14	Airproof piece	Imported

## Features:

### Individual Valve-Gate unit with balanced hot runner system



Perfectly balanced hot runners ensure uniform melt flow and pressure in all cavities. The design of the melt channels minimizes shear and pressure loss, and provides a uniform flow to all cavities. Optimized heat distribution results in consistent AA levels across all cavities. An advanced valve-gate system has been used for closing and opening the gate of preforms. Reliable valve shut off function; precise machining and low thermal expansion rate ensure the long working lift with less maintenance.



### -Dual Tapers design for Lock

Individual dual tapers locking design for thread splits, lock ring and cavity that reduce moulds wear. It guarantees the longer mold lift time and the tight tolerance for the injection moulded preforms.



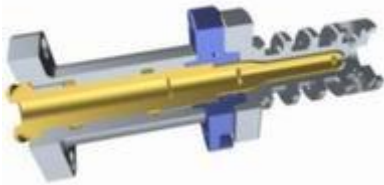
### -Maintenance free roller cams

Roller cams make both the opening and closing actions on the thread splits; The bearing has less friction, makes sure the movement of the thread split plate smoothly, and ensures the longer working lift. This roller cam system guarantees the longer service time.



#### -Low crystallinity in the gate area of the preform

Balanced hot runners with valve gates for PET processing, expedite the effective heat transfer to the nozzle tips. This results in shorter start-up times and minimizes crystallinity at the gate area.



#### -Fast and efficient cooling

Turbulent water flow ensures fast and efficient heat exchange between preforms and water. Separately water cooled neck rings lead to high preform quality and short cycle times.



#### -PVD coatings (optional)

Cores are TiN coated via a PVD process, to facilitate faster ejection of preforms and to prevent them from getting stuck to the core. This coating also permits higher injection rates, further reducing cycle time and providing the extremely wear resistant for the core pins.

#### -Precision machined and finished

Advanced machines and finishing techniques guarantee the minimum wall thickness within  $\pm 0.05$  mm and weight variation less than  $\pm 0.5$  % of preform weight.