



**All Right Machinery**

**Injection Machine  
Modified for PET Preform Molding**



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***PET Bottle Production Machine***

## Features

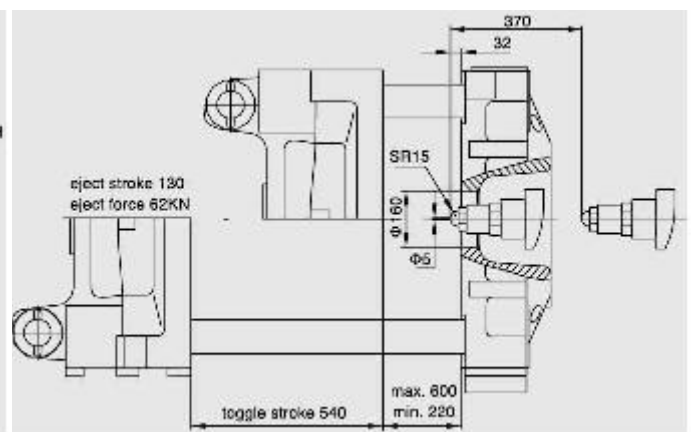
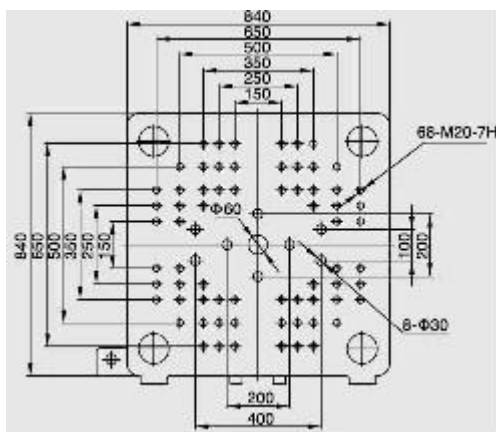
- ❖ Box mold platen design means stable and precise molding.
- ❖ Five-points toggle mechanism ensures long life span, reliable movement and simple maintenance.
- ❖ High-g geared hydraulic system design features accuracy, consistency and efficiency.
- ❖ Applied brand valves, pumps such as Vickers, Yukon and Rexroth to guarantee machine with high performance and low maintenance.
- ❖ Twin-cylinder makes balanced injection.
- ❖ Pressure and flow proportional controlled.
- ❖ Multi-stage pressure/speed injection.
- ❖ Low-pressure mold protection.
- ❖ Screw L/D ratio 25 with extra heating band and mixing head for PET preform molding.
- ❖ Linear sensors assure high accuracy on injection, clamping as well as ejection.
- ❖ Integrated self-diagnosis is programmed in the control system with clear indication of errors on the monitor.
- ❖ Mechanic, electric, hydraulic safety system conformity to CE norm.





# ALL-268

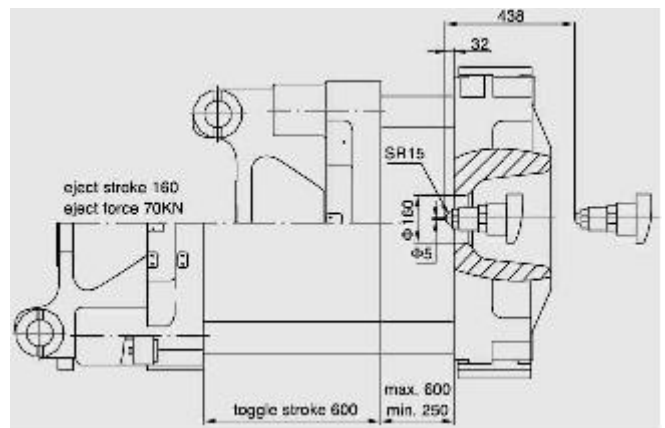
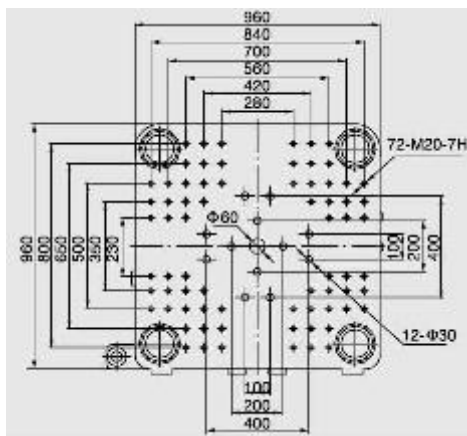
Specifications		
<b>INJECTION UNIT</b>		
Screw Diameter	mm	60
Screw L/D ratio		25
Shot Volume (theoretical)	cm	707
Shot Weight	g	636
	oz	22.4
Injection Pressure	MPa	142
Injection Speed	mm/s	91
Screw Speed	rpm	0~180
<b>CLAMPING UNIT</b>		
Clamping Force	KN	2680
Toggle Stroke	mm	540
Space between Tie-Bars	mm	570x570
Max. Mold Height	mm	600
Min. Mold Height	mm	220
Ejector Stroke	mm	130
Ejector Force	KN	62
Ejector Number		9
<b>OTHERS</b>		
Max. Pump Pressure	MPa	16
Pump Motor Power	KW	22
Heating Motor	KW	17
Machine Dimensions (LxWxH)	m	6.09x1.41x2.34
Oil Tank Capacity	Liter	315
Machine Weight	kg	9000



## PET Bottle Production Machine

# ALL-308

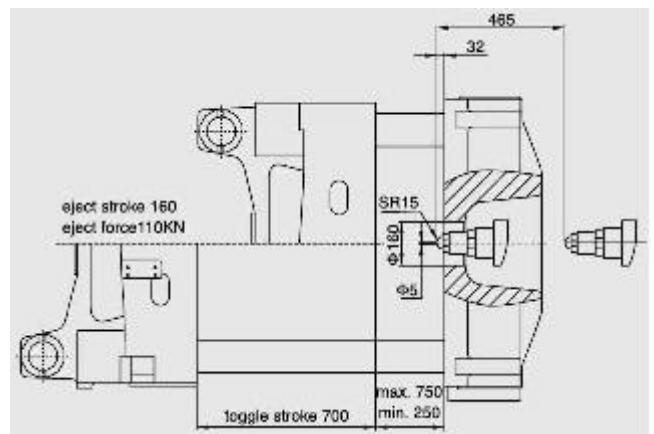
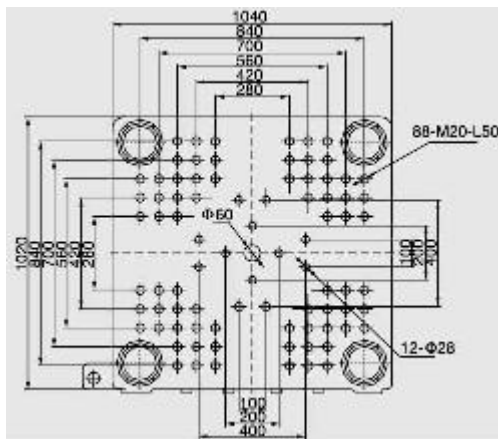
Specifications		
<b>INJECTION UNIT</b>		
Screw Diameter	mm	70
Screw L/D ratio		25
Shot Volume (theoretical)	cm	989
Shot Weight	g	900
	oz	31.7
Injection Pressure	MPa	157
Injection Speed	mm/s	86
Screw Speed	rpm	0~180
<b>CLAMPING UNIT</b>		
Clamping Force	KN	3080
Toggle Stroke	mm	600
Space between Tie-Bars	mm	660x660
Max. Mold Height	mm	660
Min. Mold Height	mm	250
Ejector Stroke	mm	160
Ejector Force	KN	70
Ejector Number		13
<b>OTHERS</b>		
Max. Pump Pressure	MPa	16
Pump Motor Power	KW	30
Heating Motor	KW	19
Machine Dimensions (LxWxH)	m	7.05x1.71x2.42
Oil Tank Capacity	Liter	550
Machine Weight	Kg	11000



## PET Bottle Production Machine

# ALL-368

Specifications		
<b>INJECTION UNIT</b>		
Screw Diameter	mm	75
Screw L/D ratio		25
Shot Volume (theoretical)	cm	1457
Shot Weight	g	1325
	oz	46.7
Injection Pressure	MPa	156
Injection Speed	mm/s	92
Screw Speed	rpm	0~180
<b>CLAMPING UNIT</b>		
Clamping Force	KN	3680
Toggle Stroke	mm	700
Space between Tie-Bars	mm	725x725
Max. Mold Height	mm	750
Min. Mold Height	mm	250
Ejector Stroke	mm	160
Ejector Force	KN	110
Ejector Number		13
<b>OTHERS</b>		
Max. Pump Pressure	MPa	16
Pump Motor Power	KW	37
Heating Motor	KW	22
Machine Dimensions (LxWxH)	m	7.53x1.87x2.57
Oil Tank Capacity	Liter	650
Machine Weight	Kg	15000



## PET Bottle Production Machine





## Main Components / Remarks

Item	Name /Description	Brand/Maker/Material
1	Mold adjust system	Hydraulic driven gear system
2	Motor for mold adjust system	Made in China
3	Clamping	European style boxed mold plan
4	Core pulling	1 set ( additional core pulling is optional at cost)
5	System hydraulic pump	VICKERS made in USA
6	P/Q valve	Made in Taiwan
7	Solenoid valve	VICKERS made in USA
8	System pressure gauge	IMT Made in Germany
9	Precharging back pressure gauge	IMT made in Germany
10	System high pressure hose	ALFAGOMMA made in Italy
11	Y sealing	Made in Japan
12	Lubrication	Grease
13	Lubrication hose	High pressure resistant hose+bronze pipe
14	Linear sensor (3 pcs)	NOVOTECH made in Germany
15	Special designed PLC for injection molding machine	TECHMANTION SA63-I500 made in Taiwan store 60 mold settings, white/black display. Color monitor optional at cost
16	Approaching switch	NATIONAL or OMRON made in Japan
17	Limited switch	OMRON made in Japan
18	Main motor	Made in China
19	Contactora	FUJI made in Japan
20	System air breaker	FUJI made in Japan
21	Controlling air breaker	FUJI made in Japan
22	Enhanced ripple hose	Yes
23	Alarm system	Yes
24	Air blast	Interface and circuit available
25	Precharging hydraulic motor	INTERMO made by Sino-Italy joint company
26	Screw and barrel	30CrMoAl
27	Tie-bars	40Cr
28	3 platens	Nodular cast iron with resin sand

## Preform Mold Cavitation / Injection Machine Model Selection

Preform Neck	Mold Cavity No.	Machine Model
30mm	16-24	ALL-268
	24	ALL-308
	32	ALL-368
	48	ALL-468
38mm	12	ALL-218
	16	ALL-308
	24	ALL-368
45mm	4 (100g)	ALL-218
	8(100g)	ALL-368
63mm	8 (<20g)	ALL-168
	8	ALL-268
90mm	4	ALL-218
	6	ALL-268
110mm	2	ALL-168 or ALL-218
	4 – 6	ALL-308
55mm (for 5gallon)	1	ALL-368

- ❖ Above table is for reference only. Maximum cavity number depends on preform neck size and weight.
- ❖ Machine with CE certificate is at extra cost.
- ❖ Standard machine comes with black/white display monitor (English/Chinese). Color monitor with English/Spanish/Chinese is available at extra cost.
- ❖ Dehumidifier, hopper dryer, autoloader, chiller, color mixer, mold temperature controller and other accessories and equipment can be purchased at extra cost.

**Any questions? Please contact**  
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