ONE-STEP BOTTLE MOLDING

Injection Stretch Blow Molding Machines

Model specifications and tooling references for single-stage container production.



120-V3

Three-station ISBM machine



750-V4

Four-station ISBM machine

20

WEBSITE MODEL PROFILES

03 / 04 / 06

PROCESS STATIONS

Find a machine

Technical specifications by model and station configuration.

THREE-STATION MACHINES

50-V5	Hydraulic	06
50-S6	All-electric	09
120-V3	All-electric	12
250-V3S	Hybrid	15
H50-V3-EV	All-electric	18

FOUR-STATION MACHINES

120-V4	Hydraulic	22
160-V4S	Hybrid	25
250-V4S	Hybrid	28
300-V4S	Hybrid	31
700-V4	Hydraulic	34
750-V4	Hydraulic	37
H150-V4	Hydraulic	41
H150-V4-VE	All-electric	45
H150S-V4	Hydraulic	49
H200-V4	Hydraulic	54
H200-V4B	Hydraulic	58
H250-V4	Hydraulic	63
H250-V4B	Hydraulic	68
H650-V4	Hydraulic	72

SIX-STATION MACHINE

H280S-V6	Hydraulic	76

Three-station process flow 04

Four-station process flow 05

Selection guide 03

Choose by container and process

Compare machines using the same bottle drawing, resin and output target. A model number or a cavity count alone does not establish project fit.

01

Start with the container

Provide the resin grade, drawing, neck finish, volume and target weight. Include tolerances and any handling or closure requirements.

02

Match the tooling layout

Compare body diameter, neck size and height as one cavity configuration. A maximum in one row does not carry over to another.

03

Select the station layout

Three stations cover injection, stretch blowing and take-out. Four add conditioning. For a six-station machine, confirm the exact station sequence.

04

Confirm the drive and utilities

Check each quoted drive option, the installation envelope and site utilities. Installed power does not describe average consumption.

05

Agree the acceptance criteria

Define appearance, dimensions, leak-test criteria and how sustained good output will be counted. Ask which resin, tooling and auxiliaries are included.

06

Request a project review

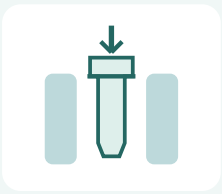
Send drawings, sample containers, resin details and target output. Ask for one specification covering the exact configuration before ordering.

Request a configuration review isbmmachine.net/contact/

SINGLE-STAGE ISBM

3-Station Process Flow

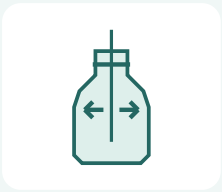
Injection, stretch blowing and take-out are integrated into three stations. The preform transfers directly from injection to stretch blowing.



STATION 01

Preform Injection

Inject molten resin into the preform mold to form the neck finish and preform body.



STATION 02

Stretch Blowing

Stretch the preform lengthwise and expand it with compressed air against the blow mold.



STATION 03

Bottle Take-Out

Release the formed bottle from the tooling and transfer it out of the machine.

Direct transfer to stretch blowing

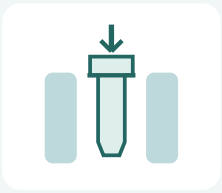
No dedicated preform conditioning station.

Process reference: ISBM technology guide

SINGLE-STAGE ISBM

4-Station Process Flow

An independent conditioning station sits between injection and stretch blowing. It adjusts the preform temperature profile before the bottle is formed.



STATION 01

Preform Injection

Inject molten resin into the preform mold to form the neck finish and preform body.



STATION 02

Preform Conditioning

Adjust the preform temperature profile before stretch blowing. This is a separate station on the four-station layout.



STATION 03

Stretch Blowing

Stretch the preform lengthwise and expand it with compressed air against the blow mold.



STATION 04

Bottle Take-Out

Release the formed bottle from the tooling and transfer it out of the machine.

Independent temperature conditioning

A separate station prepares the preform for stretch blowing.

Process reference: ISBM technology guide

THREE-STATION MACHINES

50-V5

Hydraulic three-station platform



CONFIGURATION AT A GLANCE

Process stations
3

Drive configuration
Hydraulic

Screw diameter
35 mm

Theoretical injection volume
130 cm³

Injection clamping force
100 kN

Installed power rating
20 kW

Machine envelope
3.4 × 1.2 × 2.5 m

Tooling & configuration

Compare the 35 mm injection screw, matched cavity layout and mold clearance against the proposed bottle.

Container and tooling references

1 cavity	**Body Ø 90 × H 200 mm; neck 60 mm; 105 g**
2 cavities	**Body Ø 80 × H 200 mm; neck 38 mm; 50 g**
3 cavities	**Body Ø 64 × H 200 mm; neck 30 mm; 35 g**
4 cavities	**Body Ø 45 × H 200 mm; neck 27 mm; 28 g**
5 cavities	**Body Ø 35 × H 200 mm; neck 20 mm; 22 g**
6 cavities	**Body Ø 28 × H 200 mm; neck 17 mm; 18 g**

View the model page >

THREE-STATION MACHINES

50-V5

DATA SHEET 01 / 02

Product specification by cavity count

Cavities (source)	Max. body diameter (mm)	Max. height (mm)	Max. neck size (mm)	Max. weight (g)	Max. volume (L)
1	90	200	60	105	2
2	80	200	38	50	1
3	64	200	30	35	0.5
4	45	200	27	28	0.3
5	35	200	20	22	0.15
6	28	200	17	18	0.1

Injection unit

Parameter	Quantity	Unit
Screw diameter	35	mm
Theoretical injection volume	130	cm^3
Injection rate	90	cm^3/s
Injection pressure	160	MPa
Screw rotation speed	0-200	rpm

Injection station

Parameter	Quantity	Unit
Injection clamping force	100	kN
Injection upper stroke	450	mm
Injection lower stroke	225	mm

Stretch-blow station (source: Blow station)

Parameter	Quantity	Unit
Blow clamping force	70	kN
Blow core stroke	200	mm
Blow mold opening stroke	70	mm

THREE-STATION MACHINES

50-V5

DATA SHEET 02 / 02

Take-out station

Parameter	Quantity	Unit
Take-out stroke	100	mm

Machine power

Parameter	Quantity	Unit
Installed power	20	kW

Machine dimensions and weight

Parameter	Quantity	Unit
Dimensions, L × W × H	3.4*1.2*2.5	m
Machine weight	3.5	t

Configuration notes

> Oil-tank capacity: confirm on the approved drawing.

THREE-STATION MACHINES

50-S6

All-electric three-station platform



CONFIGURATION AT A GLANCE

Process stations
3

Drive configuration
All-electric

Screw diameter
36 mm

Theoretical injection volume
146 cm³

Injection clamping force
100 kN

Installed power rating
25 kW

Machine envelope
3.4 × 1.2 × 2.5 m

Tooling & configuration

Match the 36 mm injection unit and the documented cavity layout to the bottle and resin. Check required utilities separately.

Container and tooling references

1 cavity	**Body Ø 90 × H 200 mm; neck 60 mm; 105 g**
2 cavities	**Body Ø 80 × H 200 mm; neck 38 mm; 50 g**
3 cavities	**Body Ø 64 × H 200 mm; neck 30 mm; 35 g**
4 cavities	**Body Ø 45 × H 200 mm; neck 27 mm; 28 g**
5 cavities	**Body Ø 35 × H 200 mm; neck 20 mm; 22 g**
6 cavities	**Body Ø 28 × H 200 mm; neck 17 mm; 18 g**

Confirm the injection lower stroke on the approved machine drawing before specifying tooling.

View the model page >

THREE-STATION MACHINES

50-S6

Product specification by cavity count

Cavities (source)	Max. body diameter (mm)	Max. height (mm)	Max. neck size (mm)	Max. weight (g)	Max. volume (L)
1	90	200	60	105	2
2	80	200	38	50	1
3	64	200	30	35	0.5
4	45	200	27	28	0.3
5	35	200	20	22	0.15
6	28	200	17	18	0.1

Injection unit

Parameter	Quantity	Unit
Screw diameter	36	mm
Theoretical injection volume	146	cm^3
Injection rate	100	cm^3/s
Injection pressure	210	MPa
Screw rotation speed	0-200	rpm

Injection station

Parameter	Quantity	Unit
Injection clamping force	100	kN
Injection upper stroke	400	mm
Injection lower stroke	Confirm drawing	mm

Stretch-blow station (source: Blow station)

Parameter	Quantity	Unit
Blow clamping force	70	kN
Blow core stroke	200	mm
Blow mold opening stroke	70	mm

THREE-STATION MACHINES

50-S6

DATA SHEET 02 / 02

Take-out station

Parameter	Quantity	Unit
Take-out stroke	100	mm

Machine power

Parameter	Quantity	Unit
Installed power	25	kW

Machine dimensions and weight

Parameter	Quantity	Unit
Dimensions, L × W × H	3.4*1.2*2.5	m
Machine weight	3.5	t

Configuration notes

> Injection lower stroke: confirm on the injection assembly drawing. Blow-core stroke is specified separately.

THREE-STATION MACHINES

120-V3

All-electric three-station platform with a 50 mm screw



CONFIGURATION AT A GLANCE

Process stations
3

Drive configuration
All-electric

Screw diameter
50 mm

Theoretical injection volume
440 cm³

Injection clamping force
150 kN

Installed power rating
45 kW

Machine envelope
4.3 × 1.5 × 3.1 m

Tooling & configuration

Use the 440 cm³ injection volume and the proposed cavity layout to size the shot and check tooling clearance.

Container and tooling references

1 cavity	**Body Ø 105 × H 200 mm; neck 80 mm; 200 g**
2 cavities	**Body Ø 105 × H 200 mm; neck 60 mm; 140 g**
3 cavities	**Body Ø 72 × H 200 mm; neck 35 mm; 90 g**
4 cavities	**Body Ø 46 × H 200 mm; neck 25 mm; 70 g**
5 cavities	**Body Ø 35 × H 200 mm; neck 20 mm; 55 g**
6 cavities	**Body Ø 25 × H 200 mm; neck 15 mm; 45 g**

View the model page >

THREE-STATION MACHINES

120-V3

DATA SHEET 01 / 02

Product specification by cavity count

Cavities (source)	Max. body diameter (mm)	Max. height (mm)	Max. neck size (mm)	Max. weight (g)	Max. volume (L)
1	105	200	80	200	2
2	105	200	60	140	1
3	72	200	35	90	0.5
4	46	200	25	70	0.3
5	35	200	20	55	0.15
6	25	200	15	45	0.1

Injection unit

Parameter	Quantity	Unit
Screw diameter	50	mm
Theoretical injection volume	440	cm^3
Injection rate	190	cm^3/s
Injection pressure	212	MPa
Screw rotation speed	0-150	rpm

Injection station

Parameter	Quantity	Unit
Injection clamping force	150	kN
Injection upper stroke	600	mm
Injection lower stroke	475	mm

Stretch-blow station (source: Blow station)

Parameter	Quantity	Unit
Blow clamping force	140	kN
Blow core stroke	250	mm
Blow mold opening stroke	115	mm

THREE-STATION MACHINES

120-V3

DATA SHEET 02 / 02

Take-out station

Parameter	Quantity	Unit
Take-out stroke	170	mm

Machine power

Parameter	Quantity	Unit
Installed power	45	kW

Machine dimensions and weight

Parameter	Quantity	Unit
Dimensions, L × W × H	4.3*1.5*3.1	m
Machine weight	6	t

Configuration notes

> All-electric drive configuration. Installed power: 45 kW.

THREE-STATION MACHINES

250-V3S

Hybrid three-station platform



CONFIGURATION AT A GLANCE

Process stations
3

Drive
Hybrid

Screw diameter
60 mm

Injection volume per shot
508 cm³

Injection clamping force
780 kN

Machine envelope
4.8 × 2.0 × 3.0 m

Machine weight
11.5 t

Tooling & configuration

Use the 60 mm injection screw and the 508 cm³ shot reference to start the tooling review. Compare with 250-V4S if the bottle requires a separate conditioning stage.

Container and tooling references

1 cavity	**Body Ø 150 × H 300 mm; neck 110 mm**
2 cavities	**Body Ø 130 × H 300 mm; neck 110 mm**
3 cavities	**Body Ø 130 × H 300 mm; neck 90 mm**
4 cavities	**Body Ø 100 × H 300 mm; neck 70 mm**
5 cavities	**Body Ø 80 × H 250 mm; neck 42 mm**
6 cavities	**Body Ø 66 × H 250 mm; neck 35 mm**
7 cavities	**Body Ø 55 × H 200 mm; neck 30 mm**
8 cavities	**Body Ø 48 × H 200 mm; neck 24 mm**
10* cavities	**Body Ø 36 × H 120 mm; neck 18 mm**

* Requires bottle-specific tooling review. 37 kW at 380 V drive; 12.5 kW at 220 V heating.

View the model page >

THREE-STATION MACHINES

250-V3S

DATA SHEET 01 / 02

Main technical parameters

Parameter	Unit	Value
Screw diameter	mm	Ø60
Screw length-to-diameter ratio L/D	-	24
Theoretical injection mass (PET)	g	640
Injection molding locking force	kN	780 kN
Blow molding locking force	kN	295 kN
Cooling water	L/min	80L/min
Cooling water tower	L/min	200L/min
Drive power - rated	kW	37 kW-380V
Heater power - rated	kW	12.5 kW-220V
Oil tank capacity (source English: Fuel tank capacity)	L	610L
Machine dimensions	L*W*H (mm)	4800*2000*3000
Machine weight	t	11.5
Maximum pressure of blow molding air	MPa	4MPA
Operating air pressure	MPa	1.0MPA

Product parameters by cavity

Cavities (source)	Neck diameter (E), mm	Body diameter (BD), mm	Height (H), mm	Maximum approximate volume, ml
1	110	150	300	4500
2	110	130	300	2500
3	90	130	300	2500
4	70	100	300	1500
5	42	80	250	800
6	35	66	250	500
7	30	55	200	300

THREE-STATION MACHINES

250-V3S

Product parameters by cavity (continued)

Cavities (source)	Neck diameter (E), mm	Body diameter (BD), mm	Height (H), mm	Maximum approximate volume, ml
8	24	48	200	200
<10>	18	36	120	120

Injection options

Screw diameter, mm	Injection capacity, cm³/shot
60	508

Configuration notes

Special cavity layouts are product-specific. Container volumes are approximate. PET shot mass (g) and injection volume (cm³) are distinct.

THREE-STATION MACHINES

H50-V3-EV

All-electric three-station platform for PET and PETG



CONFIGURATION AT A GLANCE

Process stations
3

Drive
All-electric

Screw diameter
40 / 50 / 55 mm

Injection clamping force
50 kN

Installed power rating
45.2 kW

Machine envelope
3.8 × 1.2 × 2.5 m

Machine weight
3.5 t

Tooling & configuration

Three screw sizes and five servo systems. Select the screw package for the required shot and tooling clearance.

Container and tooling references

1 PCS	**Body Ø 100 × H 150 mm; neck 60 mm; 130 g**
2 PCS	**Body Ø 90 × H 150 mm; neck 38 mm; 65 g**
3 PCS	**Body Ø 62 × H 150 mm; neck 30 mm; 43 g**
4 PCS	**Body Ø 45 × H 150 mm; neck 27 mm; 32 g**
5 PCS	**Body Ø 35 × H 150 mm; neck 20 mm; 26 g**
6 PCS	**Body Ø 28 × H 150 mm; neck 17 mm; 22 g**

View the model page >

THREE-STATION MACHINES

H50-V3-EV

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo systems	Using 5 sets of servo systems(Inovance/ MiRLE).
Servo motor power	Inovance/ WEICHI servo motor power:34.8 kW.
PLC	Using the Inovance/ MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor and a Taiwan TSUNTIEN reducer or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using integrated control box to control temperature, which is highly accurate, stable, and easy to operate; alternatively, you can choose the system's built-in temperature control system.
Screw and material-pipe heating	Heating power of screw and material pipes is 10.4 kW.
Lead screw	Lead screw: NSK Japan.
Blow-mould clamping	The blow molding structure adopts a dual servo motor mold clamping system with high-pressure compensation function.
Total machine power	Total power of the machine: 45.2 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	40	optional
Theoretical Injection Capacity	g	239	Not stated
Injection clamping force	kN	50	Not stated
Upper mold stroke	mm	280	Not stated
Lower mold stroke	mm	280	Not stated
Take-out stroke	mm	150	Not stated
Blowing clamping force	kN	100	single side
Blow core stroke	mm	100	Not stated

THREE-STATION MACHINES

H50-V3-EV

Machine Parameter (continued)

Item	Unit	Value	Qualification
Blow mold stroke	mm	60+60	Not stated
Size(L×W×H)	m	3.8*1.2*2.5	Not stated
Weight	T	3.5	Not stated

Detailed specification by option

Item	Unit	A	B	C
Material	Not stated	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55
Theoretical Injection Volume	cm^3	239	315	442
Screw Rotational Speed(RPM)	r/min	240	220	220
Injection Clamping Force	kN	50	50	50
Blowing Clamping Force(single side)	kN	100	100	100
Motor Power	kW	34.8	34.8	34.8
Heating Power	kW	10.4	10.4	10.4
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6
Voltage	V	370-400	370-400	370-400
Size(L*W*H)	MM	3800x1200x2500	3800x1200x2500	3800x1200x2500
Weight	T	3.5	3.5	3.5

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	100	150	60	2500	130
2	90	150	38	1500	65

THREE-STATION MACHINES

H50-V3-EV

DATA SHEET 03 / 03

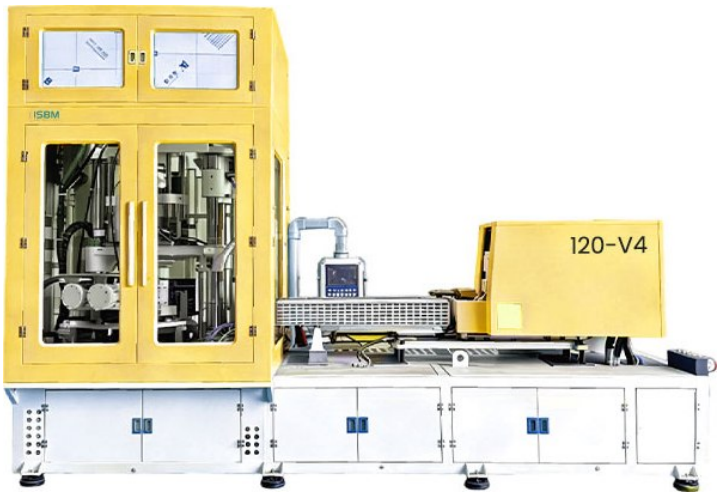
Product Dimensions (continued)

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
3	62	150	30	900	43
4	45	150	27	400	32
5	35	150	20	250	26
6	28	150	17	100	22

FOUR-STATION MACHINES

120-V4

Hydraulic platform with independent conditioning



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Screw diameter
45 mm

Theoretical injection volume
255 cm³

Injection clamping force
150 kN

Installed power rating
45 kW

Machine envelope
4.3 × 1.4 × 3.1 m

Tooling & configuration

The four-station sequence adds conditioning before stretch blowing. Check the 45 mm injection unit and the mold clearances for the specified layout.

Container and tooling references

1 cavity	**Body Ø 118 × H 200 mm; neck 83 mm; 130 g**
2 cavities	**Body Ø 80 × H 200 mm; neck 62 mm; 65 g**
3 cavities	**Body Ø 66 × H 200 mm; neck 48 mm; 43 g**
4 cavities	**Body Ø 56 × H 200 mm; neck 38 mm; 32 g**
5 cavities	**Body Ø 54 × H 200 mm; neck 32 mm; 26 g**
6 cavities	**Body Ø 45 × H 200 mm; neck 25 mm; 22 g**
7 cavities	**Body Ø 28 × H 150 mm; neck 17 mm; 18 g**
8 cavities	**Body Ø 26 × H 150 mm; neck 15 mm; 16 g**

View the model page >

FOUR-STATION MACHINES

120-V4

DATA SHEET 01 / 02

Product specification by cavity count

Cavities (source)	Max. body diameter (mm)	Max. height (mm)	Max. neck size (mm)	Max. weight (g)	Max. volume (L)
1	118	200	83	130	2.5
2	80	200	62	65	1.5
3	66	200	48	43	0.9
4	56	200	38	32	0.4
5	54	200	32	26	0.25
6	45	200	25	22	0.1
7	28	150	17	18	0.03
8	26	150	15	16	0.02

Injection unit

Parameter	Quantity	Unit
Screw diameter	45	mm
Theoretical injection volume	255	cm^3
Injection rate	135	cm^3/s
Injection pressure	174	MPa
Screw rotation speed	0-200	rpm

Injection station

Parameter	Quantity	Unit
Injection clamping force	150	kN
Injection upper stroke	600	mm
Injection lower stroke	475	mm

Conditioning station (source: Tuning station)

Parameter	Quantity	Unit
Conditioning core stroke	250	mm

FOUR-STATION MACHINES

120-V4

DATA SHEET 02 / 02

Conditioning station (source: Tuning station) (continued)

Parameter	Quantity	Unit
Conditioning cavity stroke	230	mm

Stretch-blow station (source: Blow station)

Parameter	Quantity	Unit
Blow clamping force	140	kN
Blow core stroke	250	mm
Blow mold opening stroke	150	mm

Take-out station

Parameter	Quantity	Unit
Take-out stroke	170	mm

Machine power

Parameter	Quantity	Unit
Installed power	45	kW

Machine dimensions and weight

Parameter	Quantity	Unit
Dimensions, L × W × H	4.3*1.4*3.1	m
Machine weight	5.5	t

Configuration notes

> Oil-tank capacity and reservoir service requirements: confirm for the quoted configuration.

FOUR-STATION MACHINES

160-V4S

Hybrid platform with two listed injection sizes



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hybrid

Screw diameter
45 / 50 mm

Injection volume per shot
254 / 314 cm³

Injection clamping force
300 kN

Machine envelope
4.5 × 1.95 × 3.0 m

Machine weight
5.5 t

Tooling & configuration

Select the screw and shot size together: the 45 mm screw is listed at 254 cm³ and the 50 mm screw at 314 cm³.

Container and tooling references

1 cavity	**Body Ø 118 × H 300 mm; neck 80 mm**
2 cavities	**Body Ø 100 × H 300 mm; neck 60 mm**
3 cavities	**Body Ø 75 × H 300 mm; neck 45 mm**
4 cavities	**Body Ø 58/66 × H 200 mm; neck 35 mm**
5 cavities	**Body Ø 55 × H 200 mm; neck 30 mm**
6 cavities	**Body Ø 44 × H 200 mm; neck 20 mm**
7* cavities	**Body Ø 30 × H 150 mm; neck 11 mm**
8* cavities	**Body Ø 25 × H 100 mm; neck 10 mm**

* Requires bottle-specific tooling review. † Confirm the 4-cavity body entry against the mold drawing. 24 / 11 / 7.8 kW at 380 V drive; 8.9 kW at 220 V heating.

View the model page >

FOUR-STATION MACHINES

160-V4S

DATA SHEET 01 / 02

Main technical parameters

Parameter	Unit	Value
Screw diameter	mm	Ø50
Screw length-to-diameter ratio L/D	-	25
Theoretical injection mass (PET)	g	380
Injection molding locking force	kN	300 kN
Blow molding locking force	kN	120 kN
Cooling water	L/min	80L/min
Cooling water tower	L/min	200L/min
Drive power - rated	kW	24 kW-380V; 11 kW-380V; 7.8 kW-380V
Heater power - rated	kW	8.9 kW-220V
Oil tank capacity (source English: Fuel tank capacity)	L	450L
Machine dimensions	L*W*H (mm)	4500*1950*3000
Machine weight	t	5.5
Maximum pressure of blow molding air	MPa	4MPA
Operating air pressure	MPa	1.0MPA

Product parameters by cavity

Cavities (source)	Neck diameter (E), mm	Body diameter (E), mm	Height (H), mm	Maximum approximate volume, ml
1	80	118	300	2500
2	60	100	300	2300
3	45	75	300	1000
4	35	58/66	200	500
5	30	55	200	300
6	20	44	200	150

FOUR-STATION MACHINES

160-V4S

Product parameters by cavity (continued)

Cavities (source)	Neck diameter (E), mm	Body diameter (E), mm	Height (H), mm	Maximum approximate volume, ml
<7>	11	30	150	70
<8>	10	25	100	50

Injection options

Screw diameter, mm	Injection capacity, cm³/shot
45	254
50	314

Configuration notes

Special cavity layouts are product-specific. Container volumes are approximate. PET shot mass (g) and injection volume (cm³) are distinct.

4-cavity body diameter: 58 / 66 mm; confirm on the tooling drawing.

FOUR-STATION MACHINES

250-V4S

Hybrid four-station platform for wide-neck projects



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hybrid

Screw diameter
60 mm

Injection volume per shot
508 cm³

Injection clamping force
680 kN

Machine envelope
5.25 × 2.12 × 3.13 m

Machine weight
11.5 t

Tooling & configuration

Use the matched body, neck and cavity references to review large or wide-neck containers. Do not combine the largest neck with the highest cavity count.

Container and tooling references

1 cavity	**Body Ø 204 × H 310 mm; neck 146 mm**
2 cavities	**Body Ø 153 × H 310 mm; neck 117 mm**
3 cavities	**Body Ø 130 × H 310 mm; neck 96 mm**
4 cavities	**Body Ø 120 × H 310 mm; neck 92 mm**
5 cavities	**Body Ø 99 × H 310 mm; neck 70 mm**
6 cavities	**Body Ø 79 × H 310 mm; neck 55 mm**
7 cavities	**Body Ø 66 × H 310 mm; neck 40 mm**
8 cavities	**Body Ø 54 × H 310 mm; neck 34 mm**
9* cavities	**Body Ø 53 × H 310 mm; neck 32 mm**
10 cavities	**Body Ø 45 × H 310 mm; neck 25 mm**
12* cavities	**Body Ø 37 × H 150 mm; neck 16 mm**
14* cavities	**Body Ø 33 × H 110 mm; neck 15 mm**

* Requires bottle-specific tooling review. 31 / 19 / 11 kW at 380 V drive; 15.8 kW at 220 V heating.

View the model page >

FOUR-STATION MACHINES

250-V4S

DATA SHEET 01 / 02

Main technical parameters

Parameter	Unit	Value
Screw diameter	mm	Ø60
Screw length-to-diameter ratio L/D	-	24
Theoretical injection mass (PET)	g	640
Injection molding locking force	kN	680 kN
Blow molding locking force	kN	280 kN
Cooling water	L/min	80L/min
Cooling water tower	L/min	200L/min
Drive power - rated	kW	31 kW-380V; 19 kW-380V; 11 kW-380V
Heater power - rated	kW	15.8 kW-220V
Oil tank capacity (source English: Fuel tank capacity)	L	630L
Machine dimensions	L*W*H (mm)	5250*2120*3130
Machine weight	t	11.5
Maximum pressure of blow molding air	MPa	4MPA
Operating air pressure	MPa	1.0MPA

Product parameters by cavity

Cavities (source)	Neck diameter (E), mm	Body diameter (BD), mm	Height (H), mm	Maximum approximate volume, ml
1	146	204	310	8000
2	117	153	310	4200
3	96	130	310	3200
4	92	120	310	2700
5	70	99	310	1500
6	55	79	310	800

FOUR-STATION MACHINES

250-V4S

Product parameters by cavity (continued)

Cavities (source)	Neck diameter (E), mm	Body diameter (BD), mm	Height (H), mm	Maximum approximate volume, ml
7	40	66	310	500
8	34	54	310	350
<9>	32	53	310	300
10	25	45	310	200
<12>	16	37	150	120
<14>	15	33	110	80

Injection options

Screw diameter, mm	Injection capacity, cm³/shot
60	508

Configuration notes

> Special cavity layouts are product-specific. Container volumes are approximate. PET shot mass (g) and injection volume (cm³) are distinct.

FOUR-STATION MACHINES

300-V4S

Hybrid four-station platform for multi-cavity layouts



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hybrid

Screw diameter
60 mm

Injection volume per shot
508 cm³

Injection clamping force
680 kN

Machine envelope
5.5 × 2.12 × 3.13 m

Machine weight
15.5 t

Tooling & configuration

The listed 8 to 24 cavity layouts cover a range of smaller container dimensions. Check the resin, part weight, runner and total shot against the selected layout.

Container and tooling references

8 cavities	**Body Ø 85 × H 200 mm; neck 50 mm**
10 cavities	**Body Ø 70 × H 200 mm; neck 45 mm**
12 cavities	**Body Ø 65 × H 200 mm; neck 40 mm**
14 cavities	**Body Ø 54 × H 200 mm; neck 34 mm**
16 cavities	**Body Ø 48 × H 200 mm; neck 25 mm**
18 cavities	**Body Ø 38 × H 150 mm; neck 21 mm**
20 cavities	**Body Ø 34 × H 80 mm; neck 17 mm**
22 cavities	**Body Ø 25 × H 80 mm; neck 15 mm**
24 cavities	**Body Ø 25 × H 80 mm; neck 13 mm**

31 / 31 / 15 kW at 380 V drive; 15.8 kW at 220 V heating.

View the model page >

FOUR-STATION MACHINES

300-V4S

DATA SHEET 01 / 02

Main technical parameters

Parameter	Unit	Value
Screw diameter	mm	Ø60
Screw length-to-diameter ratio L/D	-	24
Theoretical injection mass (PET)	g	640
Injection molding locking force	kN	680 kN
Blow molding locking force	kN	280 kN
Cooling water	L/min	80L/min
Cooling water tower	L/min	200L/min
Drive power - rated	kW	31 kW-380V; 31 kW-380V; 15 kW-380V
Heater power - rated	kW	15.8 kW-220V
Oil tank capacity (source English: Fuel tank capacity)	L	630L
Machine dimensions	L*W*H (mm)	5500*2120*3130
Machine weight	t	15.5
Maximum pressure of blow molding air	MPa	4MPA
Operating air pressure	MPa	1.0MPA

Product parameters by cavity

Cavities (source)	Neck diameter (E), mm	Body diameter (BD), mm	Height (H), mm	Maximum approximate volume, ml
8	50	85	200	1200
10	45	70	200	800
12	40	65	200	500
14	34	54	200	350
16	25	48	200	200
18	21	38	150	120

FOUR-STATION MACHINES

300-V4S

Product parameters by cavity (continued)

Cavities (source)	Neck diameter (E), mm	Body diameter (BD), mm	Height (H), mm	Maximum approximate volume, ml
20	17	34	80	60
22	15	25	80	40
24	13	25	80	40

Injection options

Screw diameter, mm	Injection capacity, cm³/shot
60	508

Configuration notes

> Special cavity layouts are product-specific. Container volumes are approximate. PET shot mass (g) and injection volume (cm³) are distinct.

FOUR-STATION MACHINES

700-V4

Hydraulic four-station platform with three screw options



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Screw diameter
45 / 50 / 60 mm

Theoretical injection volume
389 / 481 / 692 cm³

Injection clamping force
700 kN

Heating power rating
13 kW

Machine envelope
5.4 × 2.15 × 3.3 m

Tooling & configuration

The 45, 50 and 60 mm screw options have distinct injection volume, rate and pressure ratings. Compare the whole option, not the highest figure across columns.

Container and tooling references

1 cavity	**Body Ø 204 × H 350 mm; neck 149 mm; 311 g**
2 cavities	**Body Ø 153 × H 350 mm; neck 120 mm; 156 g**
3 cavities	**Body Ø 130 × H 350 mm; neck 99 mm; 104 g**
4 cavities	**Body Ø 120 × H 350 mm; neck 95 mm; 78 g**
5 cavities	**Body Ø 99 × H 350 mm; neck 73 mm; 62 g**
6 cavities	**Body Ø 79 × H 350 mm; neck 57 mm; 52 g**
7 cavities	**Body Ø 66 × H 350 mm; neck 42 mm; 44 g**
8 cavities	**Body Ø 54 × H 350 mm; neck 36 mm; 39 g**
9 cavities	**Body Ø 53 × H 350 mm; neck 34 mm; 35 g**
10 cavities	**Body Ø 45 × H 350 mm; neck 27 mm; 31 g**
12 cavities	**Body Ø 37 × H 350 mm; neck 18 mm; 26 g**

Confirm the screw option and matching mold dimensions before quoting.

View the model page >

FOUR-STATION MACHINES

700-V4

DATA SHEET 01 / 02

Injection unit: matched options

Parameter	45 mm screw	50 mm screw	60 mm screw
Theoretical injection volume (cm³)	389	481	692
Injection rate (cm³/s)	190	240	340
Injection pressure (MPa)	217	176	122
Screw speed (rpm)	0-150	0-150	0-150

Machine, station and utility ratings

Parameter	Value
Injection clamping force	700 kN
Injection upper stroke	450 mm
Injection lower stroke	325 mm
Conditioning core stroke	275 mm
Conditioning cavity stroke	250 mm
Blow clamping force	265 kN
Blow core stroke	275 mm
Blow mold opening stroke	300 mm
Take-out stroke	150 mm
Oil tank capacity	380 L
Installed power	89 kW
Heating power	13 kW
Dimensions (L × W × H)	5.4 × 2.15 × 3.3 m
Machine weight	13 t

Container and tooling references

Cavities	Body Ø (mm)	Height (mm)	Neck (mm)	Weight (g)	Max. volume (L)
1	204	350	149	311	10

FOUR-STATION MACHINES

700-V4

Container and tooling references (continued)

Cavities	Body Ø (mm)	Height (mm)	Neck (mm)	Weight (g)	Max. volume (L)
2	153	350	120	156	4.5
3	130	350	99	104	3.5
4	120	350	95	78	3
5	99	350	73	62	1.8
6	79	350	57	52	1
7	66	350	42	44	0.6
8	54	350	36	39	0.4
9	53	350	34	35	0.35
10	45	350	27	31	0.25
12	37	350	18	26	0.1

Configuration notes

> Installed power: 89 kW. Heating power: 13 kW. Screw ratings apply to their respective options.

FOUR-STATION MACHINES

750-V4

Hydraulic platform for large PC bottles



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic (servo-pump system)

Specified material
PC

Max. product volume reference
18.9 L

Screw diameter
75 mm

Platen effective area
760 × 610 mm

Machine envelope
7.5 × 2.4 × 4.0 m

Tooling & configuration

Large-container project review starts with the proposed bottle and closure, resin, tooling and accepted output.

Mold and installation references

Platen separation	**340 ~ 828 mm**
Clamping force	**340 kN**
Barrel heating power	**23.6 kW**

Maximum volume reference: 18.9 L. Check the resin, neck and tooling dimensions for 3- or 5-gallon containers.

View the model page >

FOUR-STATION MACHINES

750-V4

DATA SHEET 01 / 03

Machine and utility ratings

Parameter	Catalogue value	Unit
Materials	PC	Not stated
Maximum product-volume reference	18.9	L
Approximate dimensions, L × W × H	7.5 × 2.4 × 4.0	m
Machine weight	22	t
Screw diameter	75	mm
Screw L/D ratio	22:1	Not stated
Screw speed	0-80	rpm
Plasticizing capacity	80	kg/h
Barrel heating zones	4	Not stated
Barrel heating power	23.6	kW
Effective platen, W × H	760 × 610	mm
Platen separation	340-828	mm
Clamping force as listed	340	kN
Servo-pump power entry	47.2 × 3	kW
Water supply pressure	0.3-0.5	MPa
Electrical supply	AC 380	V
Supply frequency	50	Hz
Wiring	Three-phase, five-wire	Not stated
Total rated power, source entry	160; verify load schedule	kW
Average operating power	Test conditions not stated; verify with trial	Not stated
Air supply pressure	1.0-1.2	MPa
Working pressure, circuit to confirm	0.7-0.9	MPa
Air consumption, source entry	0.8	m³/min

FOUR-STATION MACHINES

750-V4

Listed equipment and component options

Item	Catalogue-listed configuration
Injection drive	Servo-hydraulic motor
Barrel and screw	Nitrided steel; mechanical description specifies 38CrMoAl
Screw tip	Wear-resistant hard alloy
Clamp	Direct hydraulic actuation. Confirm the selected tooling and station interfaces.
Clamp coordination	Interlocked with station movements
Process controls	Adjustable settings for the selected configuration
Oil pump	HYTEK
Hydraulic valves	YUKEN
Servo motor	MODROL
Seals	TRELLEBORG or VALQUA
Oil circuit	Proportional servo pressure and flow control
PLC	XINJE
Contactors	Schneider Electric
Relays	OMRON
Proximity switches	KFPS
Linear transducer	GEFRAN
Circuit breakers	Schneider Electric
Touchscreen	WEINVIEW
Pneumatic valves	AirTAC, Parker or SMC
Pneumatic fittings	AirTAC or SMC
Cylinders	ZHICHENG

FOUR-STATION MACHINES

750-V4

Mechanical assembly and handling

Assembly	Configuration to review
Rotary table	Servo motor and Sumitomo reducer; confirm build and positioning requirements.
Screw and mixing	Three-stage compression screw with mixing head.
Barrel and screw surface	38CrMoAl with nitrided surface as listed.
Take-out handling	Cylinder-driven manipulator with cushioning; confirm transfer and accessories.
Injection alignment	Traverse cylinder and adjustment screws to align the nozzle with the mold.
Hydraulic control	Proportional circuit with cartridge valves.

Process and site requirements

Station	Review items
1. Injection	Form the preform and neck finish in the injection mold. Model-specific material: PC.
2. Conditioning	Confirm the proposed preform temperature control, heater and tooling.
3. Stretch blowing	Review stretching, blow-air circuit and cooling for the actual bottle.
4. Bottle take-out	Confirm ejection motion, handling, discharge and interlocks.

Configuration notes

> 3- and 5-gallon PC bottle projects: 18.9 L maximum volume reference; fit depends on bottle geometry and tooling clearance.

> Utility load and simultaneous demand must follow the approved electrical schedule. Installed ratings do not establish operating consumption.

FOUR-STATION MACHINES

H150-V4

Hydraulic four-station platform for PET and PETG



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Screw diameter
40 / 50 / 55 / 60 mm

Theoretical injection volume
188 / 350 / 450 / 600 cm³

Injection clamping force
150 kN

Installed power rating
53.2 kW

Machine envelope
4.2 × 1.4 × 2.9 m

Tooling & configuration

Multiple screw configurations and an optional dual-servo blow clamp are available by configuration.

Container and tooling references

1 PCS	**Body Ø 118 × H 210 mm; neck 83 mm; 130 g**
2 PCS	**Body Ø 80 × H 210 mm; neck 62 mm; 65 g**
3 PCS	**Body Ø 66 × H 150 mm; neck 48 mm; 43 g**
4 PCS	**Body Ø 56 × H 150 mm; neck 38 mm; 32 g**
5 PCS	**Body Ø 54 × H 150 mm; neck 32 mm; 26 g**
6 PCS	**Body Ø 45 × H 150 mm; neck 25 mm; 22 g**
7 PCS	**Body Ø 28 × H 100 mm; neck 17 mm; 18 g**
8 PCS	**Body Ø 26 × H 100 mm; neck 15 mm; 16 g**

View the model page >

FOUR-STATION MACHINES

H150-V4

DATA SHEET 01 / 03

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 3 sets of servo pump systems(Inovance servo motor and controller plus Sumitomo servo pump from japan/ WEICHI servo motor plus OFITE servo pump).
Servo motor power	Inovance/ WEICHI servo motor power:43.2 kW.
PLC	Using the Inovance/ MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor and a Taiwan TSUNTIEN reducer or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using integrated control box to control temperature, which is highly accurate, stable, and easy to operate; alternatively, you can choose the system's built-in temperature control system.
Hydraulic pressure control valve	Using hydraulic pressure control valve of YUKEN from Taiwan, China.
Oil tube	Oil tube is made of imported material from Italy.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring(10 kW).
Blow-mould clamping	The blow molding structure adopts hydraulic cylinder or dual servo motor mold clamping system with high-pressure compensation function.
Injection unit	The injection unit is controled by single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Mould compatibility	Compatible with Japanese ASB-12M mould.
Total machine power	Total power of the machine: 53.2 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	50	optional

FOUR-STATION MACHINES

H150-V4

Machine Parameter (continued)

Item	Unit	Value	Qualification
Theoretical Injection Capacity	g	310	Not stated
Injection clamping force	kN	150	Not stated
Upper mold stroke	mm	250	Not stated
Lower mold stroke	mm	205	Not stated
TEMP. Regulating core stroke	mm	250	Not stated
TEMP. regulating barrel stroke	mm	230	Not stated
Take-out stroke	mm	170	Not stated
Blowing clamping force	kN	200	single side
Blow core stroke	mm	250	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	300	Not stated
Size(L×W×H)	m	4.2*1.4*2.9	Not stated
Weight	T	6	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55	60
Theoretical Injection Volume	cm^3	188	350	450	600
Screw Rotational Speed(RPM)	r/min	270	220	220	220
Injection Clamping Force	kN	150	150	150	150
Blowing Clamping Force(single side)	kN	200	200	200	200

FOUR-STATION MACHINES

H150-V4

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Motor Power	kW	43.2	43.2	43.2	43.2
Heating Power	kW	10	10	10	10
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	4200x1400x2900	4200x1400x2900	4200x1400x2900	4200x1400x2900
Weight	T	6	6	6	6

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	118	210	83	2500	130
2	80	210	62	1500	65
3	66	150	48	900	43
4	56	150	38	400	32
5	54	150	32	250	26
6	45	150	25	100	22
7	28	100	17	30	18
8	26	100	15	20	16

Configuration notes

> PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

FOUR-STATION MACHINES

H150-V4-VE

All-electric four-station platform for PET and PETG

CONFIGURATION AT A GLANCE

Process stations
4
Drive
All-electric
Screw diameter
40 / 50 / 55 mm
Injection clamping force
150 kN
Installed power rating
112.8 kW
Machine envelope
5.2 × 1.8 × 3.3 m
Machine weight
7 t

Tooling & configuration

Check the electric drive configuration and utility requirements. Installed power is not operating consumption.

Container and tooling references

1 PCS	**Body Ø 118 × H 210 mm; neck 83 mm; 130 g**
2 PCS	**Body Ø 80 × H 210 mm; neck 62 mm; 65 g**
3 PCS	**Body Ø 66 × H 150 mm; neck 48 mm; 43 g**
4 PCS	**Body Ø 56 × H 150 mm; neck 38 mm; 32 g**
5 PCS	**Body Ø 54 × H 150 mm; neck 32 mm; 26 g**
6 PCS	**Body Ø 45 × H 150 mm; neck 25 mm; 22 g**
7 PCS	**Body Ø 28 × H 100 mm; neck 17 mm; 18 g**
8 PCS	**Body Ø 26 × H 100 mm; neck 15 mm; 16 g**

View the model page >

FOUR-STATION MACHINES

H150-V4-VE

DATA SHEET 01 / 03

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo motor control systems	Using 10 sets of servo motor control systems (Inovance servo motor and controller/ WEICHI servo motors and controllers).
Servo motor power	Inovance/ WEICHI servo motor power: 102.8 kW.
PLC	Using the Inovance/ MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor and a Taiwan TSUNTIEN reducer or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
Blow-mould clamping	The blow molding structure adopts a dual servo motor mold clamping system with high-pressure compensation function.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using integrated control box to control temperature, which is highly accurate, stable, and easy to operate.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring(10 kW).
Lead screw	Lead screw: NSK Japan.
Mould compatibility	Compatible with Japanese ASB-12M mould.
Total machine power	Total power of the machine:112.8 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	50	optional
Theoretical Injection Capacity	g	392	Not stated
Injection clamping force	kN	150	Not stated
Upper mold stroke	mm	250	Not stated
Lower mold stroke	mm	205	Not stated
TEMP. Regulating core stroke	mm	250	Not stated

FOUR-STATION MACHINES

H150-V4-VE

Machine Parameter (continued)

Item	Unit	Value	Qualification
TEMP. regulating barrel stroke	mm	230	Not stated
Take-out stroke	mm	170	Not stated
Blowing clamping force	kN	200	single side
Blow core stroke	mm	250	Not stated
Blow mold stroke	mm	75+75	Not stated
Size(L×W×H)	m	5.2*1.8*3.3	Not stated
Weight	T	7	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55	/
Theoretical Injection Volume	cm^3	188	392	475	/
Screw Rotational Speed(RPM)	r/min	350	350	350	/
Injection Clamping Force	kN	150	150	150	150
Blowing Clamping Force(single side)	kN	200	200	200	200
Motor Power	kW	102.8	102.8	102.8	102.8
Heating Power	kW	10	10	10	10
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25

FOUR-STATION MACHINES

H150-V4-VE

DATA SHEET 03 / 03

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	5200x1800x3300	5200x1800x3300	5200x1800x3300	5200x1800x3300
Weight	T	7	7	7	7

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	118	210	83	2500	130
2	80	210	62	1500	65
3	66	150	48	900	43
4	56	150	38	400	32
5	54	150	32	250	26
6	45	150	25	100	22
7	28	100	17	30	18
8	26	100	15	20	16

Configuration notes

PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

Confirm the electric configuration against the approved nameplate and drawings.

FOUR-STATION MACHINES

H150S-V4

Four-station platform with separately listed plasticizing drive



CONFIGURATION AT A GLANCE

Process stations
4
Drive
Hydraulic
Screw diameter
40 / 50 / 55 mm
Theoretical injection volume
188 / 392 / 475 cm³
Injection clamping force
150 kN
Installed power rating
77.5 kW
Machine envelope
5.0 m long × 3.0 m high

Tooling & configuration

37.7 kW plasticizing servo. PET and PETG tooling options; confirm the selected blow-clamp configuration.

Container and tooling references

1 PCS	**Body Ø 118 × H 210 mm; neck 83 mm; 130 g**
2 PCS	**Body Ø 80 × H 210 mm; neck 62 mm; 65 g**
3 PCS	**Body Ø 66 × H 150 mm; neck 48 mm; 43 g**
4 PCS	**Body Ø 56 × H 150 mm; neck 38 mm; 32 g**
5 PCS	**Body Ø 54 × H 150 mm; neck 32 mm; 26 g**
6 PCS	**Body Ø 45 × H 100 mm; neck 25 mm; 22 g**
7 PCS	**Body Ø 28 × H 100 mm; neck 17 mm; 18 g**
8 PCS	**Body Ø 26 × H 100 mm; neck 15 mm; 16 g**

View the model page >

FOUR-STATION MACHINES

H150S-V4

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 2 sets of servo pump systems(Inovance servo motor and controller plus Sumitomo servo pump from japan/ WEICHI servo motor plus OFITE servo pump).
Servo motor power	Inovance/WEICHI servo motor power: 29.8 kW.
PLC	Using the Inovance/ MiRLE PLC.
Injection-unit melt servo motor	The injection unit melts by Inovance/ WEICHI servo motor:37.7 kW.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor and a Taiwan TSUNTIEN reducer or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using integrated control box to control temperature, which is highly accurate, stable, and easy to operate; alternatively, you can choose the system's built-in temperature control system.
Hydraulic pressure control valve	Using hydraulic pressure control valve of YUKEN from Taiwan, China.
Oil tube	Oil tube is made of imported material from Italy.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring(10 kW).
Blow-mould clamping	The blow molding structure adopts hydraulic cylinder or dual servo motor mold clamping system with high-pressure compensation function.
Injection unit	The injection unit is controled by single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Mould compatibility	Compatible with Japanese ASB-12M mould.
Total machine power	Total power of the machine:77.5 kW.

FOUR-STATION MACHINES

H150S-V4

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	50	optional
Theoretical Injection Capacity	g	310	Not stated
Injection clamping force	kN	150	Not stated
Upper mold stroke	mm	250	Not stated
Lower mold stroke	mm	205	Not stated
TEMP. Regulating core stroke	mm	250	Not stated
TEMP. regulating barrel stroke	mm	230	Not stated
Take-out stroke	mm	170	Not stated
Blowing clamping force	kN	200	single side
Blow core stroke	mm	250	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	300	Not stated
Size(L×W×H)	m	5*1.75*3	Not stated
Weight	T	6	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55	/
Theoretical Injection Volume	cm^3	188	392	475	/
Screw Rotational Speed(RPM)	r/min	300	300	300	/
Injection Clamping Force	kN	150	150	150	150

FOUR-STATION MACHINES

H150S-V4

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Blowing Clamping Force(single side)	kN	200	200	200	200
Motor Power	kW	67.5	67.5	67.5	67.5
Heating Power	kW	10	10	10	10
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	5000x1750x3000	5000x1750x3000	5000x1750x3000	5000x1750x3000
Weight	T	6	6	6	6

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	118	210	83	2500	130
2	80	210	62	1500	65
3	66	150	48	900	43
4	56	150	38	400	32
5	54	150	32	250	26
6	45	100	25	100	22
7	28	100	17	30	18
8	26	100	15	20	16

FOUR-STATION MACHINES

H150S-V4

Configuration notes

PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

FOUR-STATION MACHINES

H200-V4

Hydraulic four-station platform for PET and PETG



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Screw diameter
40 / 50 / 55 / 60 mm

Theoretical injection volume
240 / 350 / 450 / 600 cm³

Injection clamping force
300 kN

Installed power rating
59.2 kW

Machine envelope
4.8 × 2.0 × 3.2 m

Tooling & configuration

Use the exact body, neck and quantity reference together. The H200-V4B has different injection and conditioning strokes; verify the tooling on the quoted machine.

Container and tooling references

1 PCS	**Body Ø 118 × H 210 mm; neck 83 mm; 150 g**
2 PCS	**Body Ø 110 × H 210 mm; neck 68 mm; 65 g**
3 PCS	**Body Ø 105 × H 210 mm; neck 68 mm; 45 g**
4 PCS	**Body Ø 100 × H 210 mm; neck 65 mm; 35 g**
5 PCS	**Body Ø 68 × H 150 mm; neck 55 mm; 30 g**
6 PCS	**Body Ø 65 × H 150 mm; neck 50 mm; 28 g**
7 PCS	**Body Ø 48 × H 150 mm; neck 40 mm; 25 g**
8 PCS	**Body Ø 45 × H 150 mm; neck 25 mm; 20 g**
10 PCS	**Body Ø 38 × H 100 mm; neck 23 mm; 15 g**
12 PCS	**Body Ø 26 × H 100 mm; neck 15 mm; 10 g**

View the model page >

FOUR-STATION MACHINES

H200-V4

DATA SHEET 01 / 03

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 3 sets of servo pump systems(Inovance servo motor and controller plus Sumitomo servo pump from japan/ WEICHI servo motor plus OFITE servo pump).
Servo motor power	Inovance/ WEICHI servo motor power: 49.2 kW.
PLC	Using the Inovance/ MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor and a Taiwan TSUNTIEN reducer or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using integrated control box to control temperature, which is highly accurate, stable; alternatively, you can choose the system's built-in temperature control system.
Hydraulic pressure control valve	Using hydraulic pressure control valve of YUKEN from Taiwan, China.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring(10 kW).
Blow-mould clamping	The blow molding structure adopts hydraulic cylinder or dual servo motor mold clamping system with high-pressure compensation function.
Injection unit	The injection unit is controled by single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Total machine power	Total power of the machine: 59.2 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	50	optional
Theoretical Injection Capacity	g	310	Not stated
Injection clamping force	kN	300	Not stated

FOUR-STATION MACHINES

H200-V4

Machine Parameter (continued)

Item	Unit	Value	Qualification
Upper mold stroke	mm	460	Not stated
Lower mold stroke	mm	210	Not stated
TEMP. Regulating core stroke	mm	250	Not stated
TEMP. regulating barrel stroke	mm	250	Not stated
Take-out stroke	mm	175	Not stated
Blowing clamping force	kN	200	single side
Blow core stroke	mm	300	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	300	Not stated
Size(L×W×H)	m	4.8*2*3.2	Not stated
Weight	T	13	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55	60
Theoretical Injection Volume	cm^3	240	350	450	600
Screw Rotational Speed(RPM)	r/min	270	220	220	220
Injection Clamping Force	kN	300	300	300	300
Blowing Clamping Force(single side)	kN	200	200	200	200
Motor Power	kW	49.2	49.2	49.2	49.2
Heating Power	kW	10	10	10	10
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5

FOUR-STATION MACHINES

H200-V4

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	4800x2000x3200	4800x2000x3200	4800x2000x3200	4800x2000x3200
Weight	T	13	13	13	13

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	118	210	83	2500	150
2	110	210	68	1500	65
3	105	210	68	900	45
4	100	210	65	750	35
5	68	150	55	350	30
6	65	150	50	200	28
7	48	150	40	100	25
8	45	150	25	50	20
10	38	100	23	30	15
12	26	100	15	20	10

Configuration notes

> PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

FOUR-STATION MACHINES

H200-V4B

Hydraulic four-station platform with extended tooling movements



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Screw diameter
40 / 50 / 55 / 60 mm

Theoretical injection volume
240 / 350 / 450 / 600 cm³

Injection clamping force
300 kN

Installed power rating
64.2 kW

Machine envelope
4.8 × 2.0 × 3.8 m

Tooling & configuration

Injection upper and lower strokes: 600 mm and 350 mm. Verify mold clearance and conditioning reach for PET or PETG tooling.

Container and tooling references

1 PCS	**Body Ø 118 × H 280 mm; neck 90 mm; 150 g**
2 PCS	**Body Ø 110 × H 280 mm; neck 90 mm; 65 g**
3 PCS	**Body Ø 105 × H 280 mm; neck 90 mm; 45 g**
4 PCS	**Body Ø 100 × H 280 mm; neck 65 mm; 35 g**
5 PCS	**Body Ø 68 × H 150 mm; neck 38 mm; 30 g**
6 PCS	**Body Ø 65 × H 150 mm; neck 32 mm; 28 g**
7 PCS	**Body Ø 48 × H 150 mm; neck 26 mm; 25 g**
8 PCS	**Body Ø 45 × H 150 mm; neck 25 mm; 20 g**
10 PCS	**Body Ø 38 × H 100 mm; neck 23 mm; 15 g**
12 PCS	**Body Ø 26 × H 100 mm; neck 15 mm; 10 g**

View the model page >

FOUR-STATION MACHINES

H200-V4B

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 3 sets of servo pump systems: Inovance servo motor and controller plus Sumitomo servo pump from Japan, or WEICHI servo motor plus OFITE servo pump.
Servo motor power	Inovance / WEICHI servo motor power: 49.2 kW.
PLC	Using the Inovance / MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor and a Taiwan TSUNTIEN reducer, or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using an integrated control box to control temperature, described as highly accurate and stable; alternatively, the system's built-in temperature-control system can be selected.
Hydraulic pressure control	Using a hydraulic pressure-control valve from YUKEN, Taiwan.
Blow-mould clamping	The blow-moulding structure uses a hydraulic cylinder, or a dual-servo-motor mould-clamping system with high-pressure compensation.
Screw and material-pipe heating	Heating power of the screw and material pipes is 15 kW.
Injection and plasticizing drive	The injection unit is controlled by a single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Total machine power	Total power of the machine: 64.2 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	50	optional
Theoretical Injection Capacity	g	442	Not stated
Injection clamping force	kN	300	Not stated

FOUR-STATION MACHINES

H200-V4B

Machine Parameter (continued)

Item	Unit	Value	Qualification
Upper mold stroke	mm	600	Not stated
Lower mold stroke	mm	350	Not stated
TEMP. Regulating core stroke	mm	300	Not stated
TEMP. regulating barrel stroke	mm	350	Not stated
Take-out stroke	mm	175	Not stated
Blowing clamping force	kN	250	single side
Blow core stroke	mm	300	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	300	Not stated
Size(L×W×H)	m	4.8*2*3.8	Not stated
Weight	T	13	Not stated
Mould compatibility	Not stated	Japanese AOKI-250 mould	source claim; verify actual mould/configuration

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55	60
Theoretical Injection Volume	cm^3	240	350	450	600
Screw Rotational Speed(RPM)	r/min	270	220	220	220
Injection Clamping Force	kN	300	300	300	300
Blowing Clamping Force(single side)	kN	250	250	250	250
Motor Power	kW	49.2	49.2	49.2	49.2

FOUR-STATION MACHINES

H200-V4B

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Heating Power	kW	15	15	15	15
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	4800x2000x3800	4800x2000x3800	4800x2000x3800	4800x2000x3800
Weight	T	13	13	13	13

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	118	280	90	2500	150
2	110	280	90	1500	65
3	105	280	90	900	45
4	100	280	65	750	35
5	68	150	38	350	30
6	65	150	32	200	28
7	48	150	26	100	25
8	45	150	25	50	20
10	38	100	23	30	15
12	26	100	15	20	10

FOUR-STATION MACHINES

H200-V4B

Configuration notes

PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

FOUR-STATION MACHINES

H250-V4

Hydraulic four-station platform for larger bodies and necks



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Theoretical injection volume
350 / 450 / 600 cm³

Injection clamping force
300 kN

Installed power rating
82.7 kW

Machine envelope
6.3 × 2.4 × 3.7 m

Machine weight
16 t

Tooling & configuration

Lower-quantity tooling layouts accommodate larger body and neck dimensions. For PET and PETG, use the dimensions from the same tooling row.

Container and tooling references

2 PCS	**Body Ø 200 × H 220 mm; neck 130 mm; 200 g**
3 PCS	**Body Ø 160 × H 220 mm; neck 130 mm; 180 g**
4 PCS	**Body Ø 120 × H 220 mm; neck 100 mm; 150 g**
5 PCS	**Body Ø 80 × H 220 mm; neck 65 mm; 120 g**
6 PCS	**Body Ø 60 × H 180 mm; neck 55 mm; 80 g**
8 PCS	**Body Ø 45 × H 180 mm; neck 40 mm; 60 g**
9 PCS	**Body Ø 40 × H 180 mm; neck 32 mm; 50 g**
10 PCS	**Body Ø 40 × H 100 mm; neck 28 mm; 35 g**
14 PCS	**Body Ø 30 × H 100 mm; neck 16 mm; 25 g**

Confirm the paired screw and shot options before finalizing the configuration.

View the model page >

FOUR-STATION MACHINES

H250-V4

DATA SHEET 01 / 04

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 3 sets of servo pump systems: Inovance servo motor and controller plus Sumitomo servo pump from Japan, or WEICHI servo motor plus OFITE servo pump.
Servo motor power	Inovance / WEICHI servo motor power: 67.7 kW.
PLC	Using the Inovance / MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor or Inovance servo motor and a Taiwan TSUNTIEN reducer, or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
Blow-mould clamping	The blow-moulding structure uses a hydraulic cylinder, or a dual-servo-motor mould-clamping system with high-pressure compensation.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using an integrated control box to control temperature, described as highly accurate and stable; alternatively, the system's built-in temperature-control system can be selected.
Hydraulic pressure control	Using a hydraulic pressure-control valve from YUKEN, Taiwan.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring (15 kW).
Injection and plasticizing drive	The injection unit is controlled by a single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Oil tube	The oil tube is made of imported material from Italy.
Total machine power	Total power of the machine: 82.7 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	55	optional
Theoretical Injection Capacity	g	420	Not stated

FOUR-STATION MACHINES

H250-V4

Machine Parameter (continued)

Item	Unit	Value	Qualification
Injection clamping force	kN	300	Not stated
Upper mold stroke	mm	640	Not stated
Lower mold stroke	mm	350	Not stated
TEMP. Regulating core stroke	mm	300	Not stated
TEMP. regulating barrel stroke	mm	300	Not stated
Take-out stroke	mm	190	Not stated
Blowing clamping force	kN	200	single side
Blow core stroke	mm	300	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	600	Not stated
Size(L×W×H)	m	6.3*2.4*3.7	Not stated
Weight	T	16	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	55	55	60	/
Theoretical Injection Volume	cm^3	350	450	600	/
Screw Rotational Speed(RPM)	r/min	220	220	220	/
Injection Clamping Force	kN	300	300	300	300
Blowing Clamping Force(single side)	kN	200	200	200	200
Motor Power	kW	67.7	67.7	67.7	67.7
Heating Power	kW	15	15	15	15

FOUR-STATION MACHINES

H250-V4

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	6300x2400x3700	6300x2400x3700	6300x2400x3700	6300x2400x3700
Weight	T	16	16	16	16

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
2	200	220	130	2500	200
3	160	220	130	1500	180
4	120	220	100	900	150
5	80	220	65	750	120
6	60	180	55	350	80
8	45	180	40	200	60
9	40	180	32	100	50
10	40	100	28	50	35
14	30	100	16	30	25

Configuration notes

> PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

FOUR-STATION MACHINES

H250-V4

Configuration notes

55 mm screw configurations: 350 or 450 cm³. Confirm the selected configuration.

FOUR-STATION MACHINES

H250-V4B

Hydraulic four-station platform with double-row tooling



CONFIGURATION AT A GLANCE

Process stations
4

Drive
Hydraulic

Screw diameter
50 / 55 / 60 mm

Theoretical injection volume
350 / 450 / 600 cm³

Injection clamping force
300 kN

Installed power rating
82.7 kW

Machine envelope
5.2 × 2.5 × 3.8 m

Tooling & configuration

Double-row mold arrangement with 8 to 28 PCS tooling references for PET and PETG. Output depends on the actual mold and cycle.

Container and tooling references

8 PCS	**Body Ø 85 × H 260 mm; neck 58 mm; 55 g**
10 PCS	**Body Ø 85 × H 260 mm; neck 56 mm; 44 g**
12 PCS	**Body Ø 79 × H 260 mm; neck 48 mm; 36 g**
14 PCS	**Body Ø 66 × H 260 mm; neck 38 mm; 32 g**
16 PCS	**Body Ø 54 × H 260 mm; neck 32 mm; 28 g**
20 PCS	**Body Ø 45 × H 260 mm; neck 26 mm; 25 g**
24 PCS	**Body Ø 37 × H 260 mm; neck 24 mm; 20 g**
28 PCS	**Body Ø 25 × H 260 mm; neck 15 mm; 15 g**

View the model page >

FOUR-STATION MACHINES

H250-V4B

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 3 sets of servo pump systems: Inovance servo motor and controller plus Sumitomo servo pump from Japan, or WEICHI servo motor plus OFITE servo pump.
Servo motor power	Inovance / WEICHI servo motor power: 67.7 kW.
PLC	Using the Inovance / MiRLE PLC.
Turntable rotation	The turntable is equipped with an Inovance servo motor or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using an integrated control box to control temperature, described as highly accurate and stable; alternatively, the system's built-in temperature-control system can be selected.
Hydraulic pressure control	Using a hydraulic pressure-control valve from YUKEN, Taiwan.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring (15 kW).
Blow-mould clamping	The blow-moulding structure uses a hydraulic cylinder, or a dual-servo-motor mould-clamping system with high-pressure compensation.
Injection and plasticizing drive	The injection unit is controlled by a single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Oil tube	The oil tube is made of imported material from Italy.
Total machine power	Total power of the machine: 82.7 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	60	optional
Theoretical Injection Capacity	g	680	Not stated

FOUR-STATION MACHINES

H250-V4B

Machine Parameter (continued)

Item	Unit	Value	Qualification
Injection clamping force	kN	300	Not stated
Upper mold stroke	mm	600	Not stated
TEMP. Regulating core stroke	mm	250	Not stated
TEMP. regulating barrel stroke	mm	250	Not stated
Take-out stroke	mm	200	Not stated
Blowing clamping force	kN	250	single side
Blow core stroke	mm	300	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	300	Not stated
Size(L×W×H)	m	5.2*2.5*3.8	Not stated
Weight	T	16	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	50	55	60	/
Theoretical Injection Volume	cm^3	350	450	600	/
Screw Rotational Speed(RPM)	r/min	220	220	220	/
Injection Clamping Force	kN	300	300	300	300
Blowing Clamping Force(single side)	kN	250	250	250	250
Motor Power	kW	67.7	67.7	67.7	67.7
Heating Power	kW	15	15	15	15
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5

FOUR-STATION MACHINES

H250-V4B

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	5200x2500x3800	5200x2500x3800	5200x2500x3800	5200x2500x3800
Weight	T	16	16	16	16

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
8	85	260	58	1000	55
10	85	260	56	900	44
12	79	260	48	800	36
14	66	260	38	600	32
16	54	260	32	400	28
20	45	260	26	250	25
24	37	260	24	100	20
28	25	260	15	50	15

Configuration notes

> PCS denotes a tooling quantity, not a production rate. Component options vary by configuration.

FOUR-STATION MACHINES

H650-V4

Hydraulic platform for large-container projects



CONFIGURATION AT A GLANCE

Process stations
4
Drive
Hydraulic
Screw diameter
50 / 55 / 60 mm
Theoretical injection volume
350 / 450 / 600 cm³
Injection clamping force
400 kN
Installed power rating
90.7 kW
Machine envelope
6.1 × 2.6 × 4.0 m

Tooling & configuration

Large-container project review starts with the proposed bottle and closure, resin, tooling and accepted output.

Container and tooling references

1 PCS	**Body Ø 280 × H 510 mm; neck 140 mm; 900 g**
2 PCS	**Body Ø 235(280) × H 510 mm; neck 120 mm; 460 g**
3 PCS	**Body Ø 230 × H 510 mm; neck 90 mm; 310 g**
4 PCS	**Body Ø 180 × H 510 mm; neck 84 mm; 230 g**

For 3- or 5-gallon projects, confirm the resin, screw and mold. 2 PCS body diameter: 235 (280) mm; confirm against the bottle drawing.

View the model page >

FOUR-STATION MACHINES

H650-V4

DATA SHEET 01 / 03

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 3 sets of servo pump systems: Inovance servo motor and controller plus Sumitomo servo pump from Japan, or WEICHI servo motor plus OFITE servo pump.
Servo motor power	Inovance / WEICHI servo motor power: 75.7 kW.
PLC	Using the Inovance / MiRLE PLC.
Turntable rotation	The turntable is equipped with a Japan Yaskawa servo motor or Inovance servo motor and a Taiwan TSUNTIEN reducer, or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
Blow-mould clamping	The blow-moulding structure uses a hydraulic cylinder, or a dual-servo-motor mould-clamping system with high-pressure compensation.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using an integrated control box to control temperature, described as highly accurate and stable; alternatively, the system's built-in temperature-control system can be selected.
Hydraulic pressure control	Using a hydraulic pressure-control valve from YUKEN, Taiwan.
Screw heating	The screw is heated by a nano-far-infrared energy-saving heating ring (15 kW).
Injection and plasticizing drive	The injection unit is controlled by a single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Oil tube	The oil tube is made of imported material from Italy.
Total machine power	Total power of the machine: 90.7 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	60	optional
Theoretical Injection Capacity	g	480	Not stated

FOUR-STATION MACHINES

H650-V4

Machine Parameter (continued)

Item	Unit	Value	Qualification
Injection clamping force	kN	400	Not stated
Upper mold stroke	mm	1070	Not stated
Lower mold stroke	mm	550	Not stated
TEMP. Regulating core stroke	mm	300	Not stated
TEMP. regulating barrel stroke	mm	300	Not stated
Take-out stroke	mm	300	Not stated
Blowing clamping force	kN	400	single side
Blow core stroke	mm	300	Not stated
Blow mold stroke	mm	175+175	Not stated
Oil tank VOL	L	600	Not stated
Size(L×W×H)	m	6.1*2.6*4	Not stated
Weight	T	28	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET / PETG*	PET / PETG*	PET / PETG*	PET / PETG*
Screw Diameter	MM	50	55	60	/
Theoretical Injection Volume	cm^3	350	450	600	/
Screw Rotational Speed(RPM)	r/min	220	220	220	/
Injection Clamping Force	kN	400	400	400	400
Blowing Clamping Force(single side)	kN	400	400	400	400
Motor Power	kW	75.7	75.7	75.7	75.7
Heating Power	kW	15	15	15	15

FOUR-STATION MACHINES

H650-V4

DATA SHEET 03 / 03

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	6100x2600x4000	6100x2600x4000	6100x2600x4000	6100x2600x4000
Weight	T	28	28	28	28

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (L)	Max. bottle weight (g)
1	280	510	140	20	900
2	235(280)	510	120	20	460
3	230	510	90	12	310
4	180	510	84	5(7)	230

Configuration notes

> 3- or 5-gallon projects require resin and tooling checks. The 2 PCS body diameter is 235 (280) mm; this is not a range.

> * PET/PETG and PC/Tritan are documented for different configurations. Confirm resin compatibility for the quoted machine.

SIX-STATION MACHINE

H280S-V6

Six-station platform with two injection units

CONFIGURATION AT A GLANCE

Process stations
6

Drive
Hydraulic

Injection units
2

Injection clamping force
150 kN

Installed power rating
125.2 kW

Machine envelope
5.9 × 2.6 × 3.2 m

Machine weight
14 t

Tooling & configuration

Two injection units for PET and PETG configurations. Tooling depends on the assigned injection functions, station sequence and part transfer.

Container and tooling references

1 PCS	**Body Ø 120 × H 210 mm; neck 85 mm; 130 g**
2 PCS	**Body Ø 110 × H 210 mm; neck 70 mm; 65 g**
4 PCS	**Body Ø 68 × H 150 mm; neck 50 mm; 43 g**
5 PCS	**Body Ø 55 × H 150 mm; neck 38 mm; 32 g**
6 PCS	**Body Ø 50 × H 150 mm; neck 32 mm; 26 g**
7 PCS	**Body Ø 45 × H 150 mm; neck 25 mm; 22 g**
9 PCS	**Body Ø 35 × H 100 mm; neck 17 mm; 18 g**
10 PCS	**Body Ø 20 × H 100 mm; neck 12 mm; 16 g**

View the model page >

SIX-STATION MACHINE

H280S-V6

Engineering configuration and available component alternatives

Item	Catalogue-listed configuration
Servo pump systems	Using 2 sets of servo pump systems: Inovance servo motor and controller plus Sumitomo servo pump from Japan, or WEICHI servo motor plus OFITE servo pump.
Servo motor power	Inovance / WEICHI servo motor power: 29.8 kW.
PLC	Using the Inovance / MiRLE PLC.
Injection-unit plasticizing servo motors	The Chinese source specifies two sets of Inovance / WEICHI servo motors for injection-unit plasticizing: 75.4 kW. The English line says injection-unit melting by Inovance / WEICHI servo motor: 75.4 kW.
Turntable rotation	The turntable is equipped with an Inovance servo motor or a WEICHI servo motor and a Taiwan TSUNTIEN reducer.
High-pressure valve	Using the American Parker high-pressure valve.
Air cylinder	Using the Airtak air cylinder.
Temperature control	Using an integrated control box to control temperature, described as highly accurate, stable and easy to operate.
Hydraulic pressure control	Using a hydraulic pressure-control valve from YUKEN, Taiwan.
Oil tube	The oil tube is made of imported material from Italy.
Twin-screw heating	The twin screws are heated by nano-far-infrared energy-saving heating rings (10 kW+10 kW).
Blow-mould clamping	The blow-moulding structure uses a hydraulic cylinder, or a dual-servo-motor mould-clamping system with high-pressure compensation.
Double-injection unit and plasticizing drive	The double-injection unit is controlled by a single cylinder. The melt motor may be controlled either hydraulically or by a servo motor.
Total machine power	Total power of the machine: 125.2 kW.

Machine Parameter

Item	Unit	Value	Qualification
Screw Diameter	mm	50	optional

SIX-STATION MACHINE

H280S-V6

Machine Parameter (continued)

Item	Unit	Value	Qualification
Theoretical Injection Capacity	g	310	Not stated
Injection clamping force	kN	150	Not stated
Upper mold stroke	mm	250	Not stated
Lower mold stroke	mm	205	Not stated
TEMP. Regulating core stroke	mm	250	Not stated
TEMP. regulating barrel stroke	mm	230	Not stated
Take-out stroke	mm	170	Not stated
Blowing clamping force	kN	200	single side
Blow core stroke	mm	250	Not stated
Blow mold stroke	mm	75+75	Not stated
Oil tank VOL	L	300	Not stated
Size(L×W×H)	m	5.9*2.6*3.2	Not stated
Weight	T	14	Not stated

Detailed specification by option

Item	Unit	A	B	C	D
Material	Not stated	PET/PETG	PET/PETG	PET/PETG	PET/PETG
Screw Diameter	MM	40	50	55	60
Theoretical Injection Volume	cm^3	188	350	450	600
Screw Rotational Speed(RPM)	r/min	270	220	220	220
Injection Clamping Force	kN	150	150	150	150
Blowing Clamping Force(single side)	kN	200	200	200	200

SIX-STATION MACHINE

H280S-V6

Detailed specification by option (continued)

Item	Unit	A	B	C	D
Motor Power	kW	105.2	105.2	105.2	105.2
Heating Power	kW	20	20	20	20
Blow Molding Air Pressure	MPa	2.0-3.5	2.0-3.5	2.0-3.5	2.0-3.5
Cooling Water Pressure	MPa	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Machine Oil Cooler Water Pressure	MPa	0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4
Machine Oil Cooler Water Temperature	°C	20-25	20-25	20-25	20-25
Voltage	V	370-400	370-400	370-400	370-400
Size(L*W*H)	MM	5900x2600x3200	5900x2600x3200	5900x2600x3200	5900x2600x3200
Weight	T	14	14	14	14

Product Dimensions

Quantity (PCS)	Body diameter (mm)	Bottle height (mm)	Neck diameter (mm)	Max. bottle volume (mL)	Max. bottle weight (g)
1	120	210	85	2500	130
2	110	210	70	1500	65
4	68	150	50	900	43
5	55	150	38	400	32
6	50	150	32	250	26
7	45	150	25	100	22
9	35	100	17	30	18
10	20	100	12	20	16

Configuration notes

> Confirm each injection unit’s function and the transfer sequence. PCS denotes a tooling quantity, not a production rate.