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硅橡胶注射剂系列  
Rubber Injection Machine Series

热压成型机系列  
Heating Press Forming Machine Series





HACEN 华城机械

## 提供高附加值的产品 是华城对客户的承诺

Offer the high value-added products is our acceptance to the customer

余姚市华城液压机电有限公司是专业研发和制造热固性、热塑性材料成型工艺及设备的专业公司，已积累了二十多年丰富经验。公司占地面积28000平方米，建筑面积25000平方米，依托华城机电研发中心，采用ERP管理软件，不断引进吸收国外先进技术、工艺。现也开发BMC、DAP、LSR热固性注射机及热塑性节能伺服注塑机等高端产品。本公司宗旨是“为客户提供最大附加值产品，满足客户需求”。年生产能力2000余台，出口多个国家和地区。华城以人才，技术，信誉为本，勇与创新，追求卓越。

华城的主要产品广泛行销热固性制品行业各领域，其间让我们引以为傲的，不是迭创佳绩的行销效果，而是在热固性机械开发过程中，华城始终提供客户高附加值的产品，协助客户达成需求目标，因为我们相信华城的成功是来自于客户的成就。

# 30

## 三十年精耕细作

Thirty years of intensive cultivation

## 专注热固成型设备

Focus on thermosetting equipment

**Yuyao Huacheng Hydraulic Electromechanical Co., Ltd.** is specializing in producing thermosetting material molding process and equipment with the history of more than 20 years. It is covering a land area of 28,000 square meter and building area of 25,000 square meter. Rely on the Huacheng machine electricity development center, adopt the ERP management software, use the advanced technique, craft in abroad in absorption continuously, now we have introduce BMC\DAPI\LSR those thermosetting injection machine. The principle of our products is to provide customers with Maximum value-added products, satisfy the customer's request. The annual production capacity is over 2000sets per year, which is exporting to many countries and regions. Huacheng is focusing in talent people, technology and reputation. And we have the courage to innovate and pursue outstanding.

Huacheng main product widespread marketing thermosetting products profession various domains, during let us take arrogantly to is not the repeat creates the good result the marketing effect, but in the rubber machine performance history, Huacheng always provides hight value-added products to the customer, assists the customer to achieve the demand goal; Because we believed that Hua Cheng the success is the whence in the customer achievement.





合作共赢  
Company introduction



华城机械 致力于成为您的事业合作伙伴  
Hand in hand we growing together



**卖点和客户价值 Selling and customer value**

**华城橡胶注塑机，源于追求及对痛苦的思考**

竞争越来越激烈  
销售价格越来越低廉  
各种成本上涨加剧  
效率及成本节约迫在眉睫  
进口设备价格高昂，回收期长  
劳动力难招募、难管理、难留住  
模具与机器配合不好，反复修改与延期现象严重

**HuaCheng begins from dream and your pain**

The competition will be fiercer and fiercer  
Low and low sale price  
Cost growing  
Efficiency and cost saving imminent  
European machine is too expensive  
Manual worker difficult be management also increased cost  
Problem between machine and mold

**我们为您承诺**

- 大幅度削减设备和厂房投资
- 大幅度削减工人数量和开支
- 大幅度提高效率
- 大幅度减少胶料浪费
- 大幅度减少电力消耗
- 大幅度缩短项目周期和风险
- 降低单件制造成本30%—40%

**We promised to you**

- Cut your total investment in machine and workshop
- Cut your labor and its attendant cost
- Cut your rubber waste
- Cut your power consumption
- Cut your project time
- Increase your efficiency
- Part cost saving 30-40%

**您是否需要这样的解决方案 Do you need solutions like this**



稳定、安全的欧洲机型  
Steady and safety machine using the latest technologies



经济价格  
Economic price



单机产能提高1.5倍  
Production increase to 1.5 times per set



电力消耗降低40%  
Power consumption saved 40%



超长的使用寿命  
Long service time



方便易用的附件拓展  
Easy and fast accessories



交钥匙工程服务  
Turnkey solutions



24小时贴身服务  
Service in 7\*24



永久的技术支持  
Technology service forever





HACEN 华城机械



**XZL-RH**  
角式注射机  
XZL-RH Horizontal  
Rubber Injection Molding Machine



**XZL-先进先出 (FIFO) 型**  
橡胶注射机  
XZL-FIFO type  
Rubber Injection Molding Machine



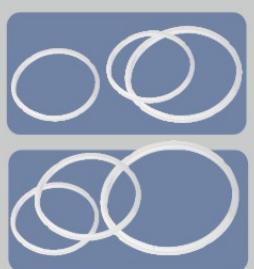
**XZL-立式**  
橡胶注射机  
XZL-Vertical type  
Rubber Injection Molding Machine

### 硅橡胶注射机系列

- 本机是立式橡胶注射成型机，由四柱式锁模机构和立式注射机构组成。
- 本机适用于注射天然橡胶、合成橡胶等各种橡胶模模型制品的生产。
- 本机具有长期稳定性，运行可靠，故障率低。
- 整机结构紧凑、布局合理、注射速度快、加热均匀、储料精确。
- 模座和注射位置均由电子尺控制，定位准确，储料和注射精度高，可有效降低浪费和不良率。
- 由伺服控制或双比例（压力流量）阀控制的变量泵比普通油泵配置省电达35%-40%，节能效果明显；结合电子尺，可实现模座和注射压力流量的三段控制，可满足各种工艺条件。
- 本机注重操作安全，采用围板四面保护，操作处由光栅保护兼双手启动，无安全隐患死角。

- The machine is XZL-Vertical Type Rubber Injection Molding Machine, including "four pole-clamping units and V type injection units."
- The machine is suitable for various rubber products(nature rubber and synthetic rubber)
- The machine with long stability and low malfunction rate running reliable
- The machine is compact instructure,rational in layout,fast injection, uniformity heating and accurate charging.
- The position of clamp and injection both cotrolled by electronic ruler, high accuracy, lower waste and bad product rate efficiently.
- Compared with normal pump system ,variable pump with proportional pressure and float valve can cut 35%-40% power,saving energy effect obvious; combining electronic ruler,realizing 3 section pressure and float control for clamp and injection,fitting for different working process.
- Design notice operation safety,using nozzle safety guard and both hand start to protect people's body.

行业应用：汽车、医疗、电力、电子、各类杂件。




**接角机系列**

- ◆ 本机主要用来汽车密封件接角和相关零件的加工。
- ◆ 本机具有长期稳定性，运行可靠，故障率低。
- ◆ 模座经加固设计，形变小，平行度好，加工产品飞边少。
- ◆ 锁模油缸独特设计，已申请专利，使模座和锁模更加可靠稳定。
- ◆ 模座和注射位置均由电子尺控制，定位准确，注射精度高，可有效降低浪费和不良率。
- ◆ 本机由三菱PLC及触摸屏控制，控制可靠，参数设置方便。
- ◆ 由双比例（压力流量）阀控制的变量泵比普通油泵配置省电达35%-40%，节能效果明显；结合电子尺，可实现模座和注射压力流量的三段控制。可满足各种工艺条件。
- ◆ 由温控表控制的温度均匀而稳定。
- ◆ 本机注重操作安全，采用座台防护罩和双手启动方式保护人身安全。

- ◆ This machine mainly applies to angle joining of automobile sealing strip and machining of relevant accessories.
- ◆ This machine features long stability, reliable operation and low fault rate.
- ◆ The working table adopting reinforcing design, features deformation small, good parallelism and less flash during machining.
- ◆ Unique design of mold locking cylinder, which has been patented, makes the working table and locking mold more reliable and stable.
- ◆ Both worker table and injection position are controlled by electric ruler which ensures accurate positioning and precise injection, effectively reducing waste and defect rate.
- ◆ This machine is controlled by Mitsubishi PLC and touch screen which ensure reliable control and convenient parameter setting.
- ◆ Variable pump controlled by double-proportion (pressure-flow) valve is more efficient and power saving than ordinary pump by 35%-40%; combined with electric ruler, it can achieve 3-stage control of working table and injection pressure-flow and meet all kinds of technological conditions.
- ◆ Temperature controlled by temperature controller is even and stable.
- ◆ Stressing operation safety, this machine uses base cover and double-hand start to protect personnel safety.

**行业应用：汽车或房屋门窗密封条。**




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产品展示  
Product display

## XLB-Y系列

橡胶平板硫化机

XLB-Y Series rubber compression molding machine

XLB-Y系列  
平板硫化双机

XLB double station with slide way and turning plate device



## ZXB系列

真空热压成型机

ZXB The Vacuum Heat Press Molding Machine



## XZB系列

橡胶注压成型机

XLB Series Rubber Injection &amp; Pressure Molding Machine



## 平板/真空/注压机系列

- 快速开合模，生产效率高，慢速锁紧，保护模具；
- 自动进出模及外顶出装置，劳动强度低；
- 可选择常规阀或比例阀，油路配置先进合理，节约能耗；
- 电气系统采用PLC可编程控制，触摸屏人机对话。
- 2RT/3RT/4RT分别选择
- 可选单机或双机

- fast-open mold features high production efficiency and slow locking to protect the mold;
- Automatic move-in-and-out and ejecting units allows low labor intensity;
- Conventional valve and proportional valve are optional; advanced and rational oil-way configuration is energy saving;
- Electric system adopts PLC and touch screen man-machine interaction.
- 2RT/3RT/4RT for option;
- Single machine and double machine for option;

## Operated:

- Two choices for central mold-transfer and back toward mold-transfer

行业应用：汽车、医疗、电力、电子、生活用品、各类杂件。




**液态硅胶注射机系列**

- ◆ LSR射出成型专用机
- ◆ 多段式精密模具电热温控；
- ◆ LSR专用气动封咀；
- ◆ LSR专用料管组；
- ◆ 隔热板（标准200°C以内）
- ◆ 圆盘或双滑板设计[一上二下模]，取放件更方便，更可利用LSR热固成型时的停顿时间，让操作员做另一下模取/放及清理模具工作，大大增加生产效率；
- ◆ 特殊加料射出设计，加料计量更精确；
- ◆ 选配可调试抽真空装置，防止产品气泡；
- ◆ HTV固态硅橡胶射出成型机
- ◆ 稳定的油压推动装置[团状硅橡胶]；
- ◆ 配以精准的螺杆计量及可靠的柱塞注射；

- ◆ LSR injection molding machine
- ◆ Multi stage precision mould electrothermal temperature control;
- ◆ LSR special pneumatic sealing nozzle;
- ◆ LSR special material pipe group;
- ◆ Heat insulation board (standard within 200 ° C)
- ◆ Disc or double slide plate design [one upper and two lower molds], which is more convenient for taking and placing parts, and also can make use of the pause time during LSR thermosetting molding, allowing the operator to do another mold taking / placing and cleaning mold work, which greatly increases the production efficiency;
- ◆ Special feeding injection design, feeding metering more accurate;
- ◆ Optional adjustable vacuum device to prevent product bubble;
- ◆ HTV solid silicone rubber injection molding machine
- ◆ Stable oil pressure pushing device [spherical silicone rubber];
- ◆ With accurate screw metering and reliable plunger injection;

**行业应用：电子产品、医疗用品、母婴用品。**




HACEN 华城机械

**XZL-先进先出 (FIFO) 型橡胶注射机**  
XZL-FIFO type Rubber Injection Molding Machine

规格 Item		单位 Unit	XZL-200	XZL-250	XZL-400	XZL-500	XZL-600
锁模部分	锁模力 Clamping force	(KN)	2000	2500	4000	5000	6000
	开模行程 Opening stroke	(mm)	450	500	600	700	700
	热板尺寸 Heating platens	(mm)	550x600	560x630	670x780	850x850	950x950
	热板最大间距(mm) Max opening between the heating plates	(mm)	550	600	780	900	900
	最小模厚 Min.mold height	(mm)	100	100	180	200	200
	上液压中子行程(选配) upper lifter stroke	(mm)	250	250	250	250	250
	下液压中子行程(选配) lower lifter stroke	(mm)	250	250	250	250	250
注射部分	螺杆直径 Screw diameter	(mm)	35	45	55	65	65
	螺杆转速 Screw speed	(Rpm)	0-100	0-100	0-100	0-100	0-100
	注射容量 Injection Volume	(cc)	1500	2000	4000	8000	10000
	注射压力 Injection Pressure	(Bar)	1970	2110	2070	2070	2070
	注射塞直径 Injection plunger diameter	(mm)	75	85	105	120	135
	加热分区数量 Number of heating zones	(piece)	2	2	2	2	2
	注射嘴抵模力 Injection unit contact force	(KN)	75	75	75	75	75
注射部分	系统压力 System pressure	(Bar)	210	210	210	210	210
	电机功率 Motor power	(KW)	11	15	22	18.5	22
	机台尺寸 Machine dimensions L×W×H	(M)	2.8x1.8x3.3	2.7x1.8x3.4	3.2x2.0x4	3.7x2x5	4.2x2.5x5.5
	机台重量 Weight	(Kg)	7000	7800	12000	16000	20000

**XZB系列橡胶注压成型机**  
XLB Series Rubber Injection & Pressure Molding Machine

规格 Item		单位 Unit	ZXB-100	ZXB-200	ZXB-250	ZXB-300	ZXB-350	ZXB-500
锁模力 Locking force	kN	1000	2000	2500	3000	3500	5000	
合模行程 Block stroke	mm	300	250	250	250	250	250	
最大开档 Max.opening	mm	200~360	200~400	200~400	200~400	200~400	200~400	
电热功率 Heater power	kW	7.8	17.1x2	18.3x2	19.2x2	21.6x2	28x2	
工作台面	上 up plate	mm	400x400	510x510	590x600	590x600	700x700	800x800
Heat plate size	下 down plate	mm	420x420	600x560	650x600	650x650	700x700	800x800
模具使用厚度 Mold height	mm	50~150	50~150	50~150	50~150	50~150	50~150	
主机马力 Main engine horse power	kW	4	5.5x2	5.5x2	7.5x2	7.5x2	11x2	
真空马力 Vcauum Horsepower	kW	VC-100 (2.2kW/50Hz)	VC-100 (2.2kW/50Hz)	VC-100 (2.2kW/50Hz)	VC-150 (3kW/50Hz)	VC-150 (3kW/50Hz)	VC-200 (4kW/50Hz)	

**XZL-RH角式注射机**  
XZL-RH Horizontal Rubber Injection Molding Machine

规格 Item		单位 Unit	200RH	300RH	400RH	500RH	800RH
锁模力 Clamping force	(Ton)	200	300	400	500	800	
注射容积 Injection capacity	(cc)	2000	3000	5000	8000	12000	
热板尺寸 Heated plate size	(mm)	600x600	650x650	750x750	850x850	1200x1200	
开模行程 Clamp stroke	(mm)	500	550	600	700	500	
最小模厚 Min.mold thickness	(mm)	50	50	50	50	100	
总功率 Total power	(kw)	29	40	42	46	97	
重量 Weight	(Ton)	7.5	10	12	15	24	
机台尺寸 Dimension	(m)	3.1x2.3x2.5	3.4x2.6x2.7	3.8x3x3	4.2x3.5x3.5	5.7x3x3.3	

**XZL-立式 橡胶注射机**  
XZL-Vertical type Rubber Injection Molding Machine

规格 Item		单位 Unit	XZL-1000(1500)×2000	XZL-1500(2000)×2500	XZL-2000(2500)×3000	XZL-4000×5000
注射装置	理论注射量 Capacity	cm³	1000 (1500)	1500 (2000)	2000 (2500)	4000
	最大注射压力 Max.Pre.	Mpa	192 (207)	207 (207)	207 (165)	190
	注射速率 Injec.Rate	cm³/s	90 (80)	80 (110)	110 (105)	120
	柱塞直径 Plunger Diameter	mm	60 (70)	70 (80)	80 (90)	110
	螺杆直径 Screw D	mm	45	45 (50)	50	50
	喷嘴接触半径 Nozzle Touching Radius	mm	SR15	SR15	SR15	SR15
	喷嘴口直径 Nozzle Outlet Diameter	mm	φ5	φ6	φ6	φ6
合模装置	胶条尺寸 Rubber Size	mm	45×10	45×10	45×10	45×10
	锁模力 Clamp. Force	KN	2000	2500	3000	5000
	合模行程 Clamp. Stroke	mm	350	450	500	700
	最小模厚 Min.Mold Thickness	mm	150	150	150	200
	最大开距 Daylight	mm	500	600	650	900
	热板尺寸 Heating platens	mm	550×600	560×630	670×780	850×850
	热板加热功率 Heating Plate Power	KW	2×9	2×9	2×9	2×18
其它	主油泵电机功率 Motor Power	KW	11	11	15	18.5
	系统压力 System Pre.	Mpa	21	21	21	21
	装机总容量 General Power	KW	36	36	40	61.5
	机械尺寸 MachineSize	L×W×H m	1.82×2.37×3.59	1.82×2.37×3.7	2.2×2.1×3.8	3.1×2.2×5
机械重量 Weight		T	6500	7500	9500	16000

**XLB-Y系列橡胶平板硫化机**  
XLB-Y Series rubber compression molding machine

规格 Item	单位 Unit	XLB-Y100	XLB-Y1000	XLB-Y1000B	XLB-Y1000A	XLB-Y1500	XLB-Y1600	XLB-Y2000B	XLB-Y2500	XLB-Y3000	XLB-Y4000A	XLB-Y4000B	XLB-Y5000	XLB-Y6000
锁模力 Mold-locking force	KN	1000	1000	1000	1000	1500	1600	2000	250	3000	4000	4000	5000	6000
最大工作压力 Max. working pressure	Mpa	21	21	21	21	21	21	21	21	21	21	21	21	21
合模行程 Block stroke	mm	250	300	300	300	250	300	250	250	250	400	500	500	500
热板尺寸 平板移出/连杆翻板 Heat plate size	mm	400×400	420×420	450×450	500×500	450×450	520×540	520×540	600×600	650×650	800×800	1000×1000	1000×1000	1200×1200
热板最大间距 Max. distance of heat plate	mm	0~300	280~440	270~400	190~400	180~360	200~420	180~240	180~420	200~420	700	700	700	800
电机功率 Motor power	KW	4	4	4	4	5.5	5.5	5.5	5.5	5.5	11	11	15	15

**XZB/C-350腭式橡胶注压成型机(胶条接头机)**  
XZB/C-350 The type rubber seal and pipe connect machine (the gum deals with contact the machine)

规格 Item	单位 Unit	参数 Parameters


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**XZL/C(接角机)橡胶注射机**  
**XZL/C rubber injection molding machine**

规格 Item	单位 Unit	XZL270/C	XZL500/C
锁模力 Clamping Force	(Ton)	27	50
热板尺寸 Heating Plate Size	(mm)	300×300 / 400×300	700×500
合模行程 Clamp Stroke	(mm)	310	400
最小模厚 Min.Mold Thick.	(mm)	69	200
最大热板开距 Daylight	(mm)	379	600
注射容积 Injection Capacity	(cc)	160	200
柱塞直径 Plunger Diameter	(mm)	32	34
注射压力 Injection Pressure	(Mpa)	131	180
螺杆直径 Screw Diameter	(mm)	30	30
注射速率 Injection Speed	(cc/s)	80	40
胶条尺寸 Rubber size	(mm)	35×5	38×5
喷嘴接触半径 Nozzle Touching Radius	(mm)	9.5	9.5
喷嘴口直径 Nozzle Outlet Diameter	(mm)	3	3
热板加热功率 Pot heating Power	(KW)	2×2.7 / 2×3.6	2×4.8
主油泵电机功率 Motor Power	(KW)	7.5	7.5
装机总容量 General Power	(KW)	16.3/18.1	26
最高油压 Max.Oil Pressure	(Mpa)	21	21
机器尺寸 Machine Dimension	(m)	2.2×1.2×3.1	3×1.4×2.8
机器重量 Machine Weight	(Kg)	2500	5000

**SZL/C(接角机)塑料注射机**  
**SZL/C plastic injection molding machine**

规格 Item	单位 Unit	SZL270/C	SZL400/C
锁模力 Clamping Force	(Ton)	27	40
热板尺寸 Heating Plate Size	(mm)	400×300	450×450
合模行程 Clamp Stroke	(mm)	310	410
最小模厚 Min.Mold Thick.	(mm)	100	150
最大热板开距 Daylight	(mm)	410	560
模具定位圈直径 Moulding ring diameter	(mm)	100H8	100H8
注射容积 Injection Capacity	(cc)	136	160
注射压力 Injection Pressure	(Mpa)	110	135
螺杆直径 Screw Diameter	(mm)	38	38
注射速率 Injection Speed	(cc/s)	90	110
喷嘴接触半径 Nozzle Touching Radius	(mm)	10	10
喷嘴口直径 Nozzle Outlet Diameter	(mm)	3	3
料筒加热功率 Pot heating Power	(KW)	3.3	3.3
主油泵电机功率 Motor Power	(KW)	7.5	7.5
装机总容量 General Power	(KW)	10.8	10.8
最高油压 Max.Oil Pressure	(Mpa)	21	21
机器尺寸 Machine Dimension	(m)	2.0×1.2×3.2	2.0×1.4×3.3
机器重量 Machine Weight	(Kg)	2700	3050

**V4-SD-LSR双滑板系列 / V3-2R-LSR转盘系列**  
**LSR double-Slide series / LSR Rotary series**

型号 Model		单位 unit	V4-SD-85 / V3-2R-85		V4-SD-120/V3-2R-120				V4-SD-160 / V3-2R-160				V4-SD-200 / V3-2R-200									
锁模装置 Lock Mode Pre-Set Up	锁模力 Clamping force	Kn(tf)	833(85)		1176(120)				1568(160)				1960									
	开模行程 Opening stroke	mm	250		280				300				350									
	最小模厚 Minimum mold height	mm	170(270)		220(320)				240(340)				290(290)									
	模板/转盘尺寸 Template/turntable dimensions	mm	1135*495	φ987	1290*560		φ1172		1400*650		φ1370		1590*730		φ1600							
	最大模具尺寸 Maximum die size	mm	500*475	340*340	580*540		400*400		640*630		500*500		890*770		770*680							
	成品顶出距离 Ejector stroke	mm	75	75	75		75		80		80		80		80							
	顶出力 Ejector force	Kn(tf)	26.5(2.7)	45(4.6)	45(4.6)		45(4.6)		45(4.6)		45(4.6)		45(4.6)		45(4.6)							
	系统压力 System pressure	Mpa(kgf/cm²)	13.7(140)		13.7(140)				13.7(140)				13.7(140)									
	电机功率 Motor power	KW	11		12				20				37.5(50)									
其它 Other	工作台高度 Workbench height	mm	1140	1180	1305		1295		1400		1350		1650		1540							
	机械尺寸 Mechanical dimension (L*W*H)	mm	2300*1700	2690(3410)	2140*1415	2710(3430)	2130*1980		3180(4020)	2480*1960		3260(4110)	2340*1970		3570(4490)	2690*1970		3640(4560)				
	机械重量 Machine weight	tf	3.6	3.9	5.7		6.2		8.5		8.8		13.2		13.6							

选用射出系统 Selection of ejection system			LSR-A					LSR-B					LSR-B					LSR-C									
注射装置 Injection device	螺杆直径 Screw diameter	mm	φ18	φ22	φ25	φ30	φ35	φ18	φ22	φ25	φ30	φ35	φ30	φ35	φ40	φ45	φ50	φ30	φ35	φ40	φ45	φ50	φ50	φ55	φ60	φ65	φ70
	理论注射容积 Theoretical injection volume	cm³	28.0	41.8	54.0	77.8	105.8	28.0	41.8	54.0	77.8	105.8	127.2	173.2	226.2	286.3	353.4	127.2	173.2	226.2	286.3	353.4	510	617	735	863	1000
	最大注射压力 Maximum injection pressure	Map(kgf/cm²)	2593(254)	1736(170)	1344(132)	933(91.5)	686(67.2)	2593(254)	1736(170)	1344(132)	933(91.5)	686(67.2)	2652(260)	1949(191)	1492(146)	1179(115)	955(93.6)	2652(260)	1949(191)	1492(146)	1179(115)	955(93.6)	1791(176)	1629(160)	1369(134)	1166(114)	1006(99)
	射出速率 Injection rate	cm³/s	46	68	88	127	173	46	68	88	127	173	106	144	188	238	294.5	127	173	226	286	353	208	252	300	352	408