



www.ssmachinery.com



双盛塑料机械



SSF系列注塑机产品

PLASTIC MACHINERY

SHUANGSHENG

宁波双盛塑料机械有限公司
NINGBO SHUANGSHENG PLASTIC MACHINERY CO.,LTD

宁波市鄞州区姜山镇明科路91号
No.91 Mingke Road,Yinzhou Industrial Zone,Jiangshan
Town,Yinzhou Area,Ningbo,China

电话(Tel):86-574-88095258
传真(Fax): 86-574-88095278
E-mail: ss@ssmachinery.com
www.ssmachinery.com



Shuangsheng Plastic Machinery

NINGBO SHUANGSHENG PLASTIC MACHINERY CO.,LTD

SHUANGSHENG, one of the scientific research and production enterprises with full experience and strength in precise medium and small injection molding machines, of which is located the world No.4 harbor city, south Yangtze River Delta economic center—Ningbo city.

We are providing customized machines for customers at home and abroad, including specialized machines such as color chips making injection molding machines, high heel making injection molding machines, plastic gears making injection molding machines, two color plastic flower making injection molding machines, full electric injection molding machines with favorable features of fast cycle time, stable, novel and automatic.

Based on strong scientific research capability, precise production process, professional service system, Shuangsheng has won invention patents and more than a dozen utility model patents. We continuously develops and research new production technology to fulfill market demand, to meet customers' different functional requirements for the machinery. SHUANGSHENG brand is also acknowledged and appraised by world customers for past 16 years. We not only establish sales service network in China, but also exported our machines to almost 30 countries and regions like USA, Russia, Western Europe, Australia, Middle East, South American, Africa, East Asia, Southeast Asia and so on.

As a contract-abiding and credit-abiding enterprise, honesty is the core value of our enterprise. Shuangsheng has been awarded the title of A-level "contract-abiding and credit-abiding" enterprise in Zhejiang Province. The construction of honesty and credit of the company has been highly recognized by the competent government departments and all sectors of society, showing a good image of the company's credit-abiding.

SHUANGSHENG core team has nearly 30 years professional experience, we has the complete capability from technical, production, sales to service, we are one of the senior team in China for medium and small precise injection molding machines. With progressive thoughts and challenge spirit, to continuously create more advanced, more efficiency and more perfect products and services, leading SHUANGSHENG to a more bright future.

双盛塑机，中国最具经验与实力的精密中小型注塑机科研生产企业之一；坐落于世界第四大港口城市、长三角南翼经济中心—宁波。

双盛为中国及全球客户量身定制中小型精密注塑机、色板专用注塑机、鞋跟专用注塑机、齿轮专用注塑机、塑料花双色机、全电注塑机等高效节能、性能稳定、结构新颖、自动化高的专业设备。

凭借强大的科研能力、精密的加工生产工艺、专业的服务体系，荣获发明专利及十几种实用新型专利，不断开拓进取、研发适合市场需求的生产技术，满足客户对机器设备不同功能要求。十六年来，双盛赢得了全球众多国家和地区客户的信赖及赞誉。不仅在国内建立销售网络，产品更远销美国、俄罗斯、西欧、澳大利亚、中东、南美洲、非洲、东亚与东南亚等近30个国家和地区。

作为守合同重信用企业，诚信是企业的核心价值观，双盛塑机荣获浙江省A级“守合同重信用”企业称号，公司诚信建设得到了政府主管部门和社会各界的高度认可，展示了公司重信用的良好形象。

双盛核心团队拥有近30年专业经验，具备完善的科技、生产、销售服务能力；是中国资深的中小型注塑机团队之一。更以进取、思考、挑战精神，持续创造更先进、更高效、更完善的产品与服务，引领双盛塑机通往更璀璨的未来。



Hydraulic System 液 压



www.ssmachinery.com

Hydraulic oil plate layout

The hydraulic oil flow design incorporates modular block technology for rapid oil transfer and dynamic system response. Control valves are located in close proximity with each major control group.

油路板分布在执行件(油缸、油马达)附近，反应速度快，动态性能好。

Charge back pressure

Charge back pressure makes melting precise and stable, of which can meet all kinds of new products with different injection molding process.

预塑背压使熔胶得以精确而稳定，可满足各类新产品的不同注塑工艺。

Components

Apply world famous valves to precisely control every movement of machine. Fixed pump and servo motor system provides stable output, quick response and powerful strength.

采用世界知名控制阀对注塑机各种动作进行精确控制。定量泵和伺服控制系统，输出稳定、响应速度快、力量强。

Major hydraulic components and seals are sourced from world famous manufacturers, providing high reliability and flexibility.

主要液压元件、密封件全部采用世界知名品牌，可靠、灵活

Pipeline

Oil pipelines are positioned for aesthetic appearance and easy of maintenance.

管路布置更为合理美观，维修保养方便。

Control System 电 控

The control panel applies color screen technology, of which detect production process and display all kinds of malfunction analysis. The latest computer control system provide fast information response with user-friendly operation.

Features

Screen protection function, extends the life of the screen.

屏幕保护功能，延长显示屏寿命。

Super light emitting diode display status for input/output point, make it easier for operation and maintenance personnel to master system's movement status.

超强发光二极管为输入/输出点显示状态，使操作和维修人员更容易掌握系统的动作状态。

Set the keyboard lock function, prevent operators to make any changes of stored information.

设置键盘锁功能，防止操作员任意改动成型资料。

控制面板采用LCD彩色屏幕，时时监测生产进程，并显示各种故障诊断。

最新易操作注塑机专用电脑控制系统，响应周期快。

Computer set and PID closed-loop controls barrel temperature precisely, the temperature ranges from 0-450 °C.

通过电脑设定和PID闭环方式精确控制料筒温度，可设定的温度范围0-450°C。

Complete close electrical control box, electrical components arranged neatly, mutual interference, and has the function of dustproof and waterproof.

全封闭电气控制箱，电气元件排布整齐，互不干扰，并具有防尘防水功能。

Clamping Unit 合 模

The platens were designed using finite element analysis software, ensuring a stable and rigid clamping system. five-point inward moving toggle system ensures high rigidity and precision for mold clamping and also reducing stress and strain effects.

内卷五支点曲肘式锁模机构，经有限元分析强化的箱形模板，有效降低应力和变形量，提高锁模部分结构刚性和精度。

Tie bars

Chrome plated tie bars, made from alloy structural steel are designed and manufactured for high rigidity and wear-resistance.

拉杆由优质合金结构钢经严格的调质处理，精加工，镀硬铬制成，具有高强度和高耐磨性。

Extended clamp opening stroke with larger distance between the tie Bar's to meet the special molding requirements.

加大的拉杆内间距和移模行程，能容许模具更大更深。

The movable platen

As standard the moving platen is fitted with adjustable slide supports system to improve platen parallelism and provide better tie bar and mould protection.

活动模板的支承采用滑块调节支承系统，提高模板平行度，保护拉杆、模具并延长其使用寿命。

Lubrication system

The toggle system uses oil-sleeve bushes lubricated by an automatically control central lubrication unit which provides excellent lubrication quality to all points and extends the clamping units working life.

曲肘存油衬套的设计，并配备集中自动润滑系统。使得关节各零部件润滑效果更好，提高关节使用寿命。



Injection Unit 注射

The screw

High quality nitride or chrome plated alloy screw with a nitrogen-treated barrel provides anti-corrosion with high wear resistance for an extended working life.

优质合金氮化或镀铬螺杆，氮化料筒，具有耐腐蚀、耐磨损、使用寿命长等特点。

Nozzle alignment is provided using a simple mechanism with fine adjustment for accurate centering.

喷嘴对中微调装置，可以通过简单的操作将喷嘴与模具中心对中。

A wide variety of screws are available for different polymer processing requirements. Special engineering materials are used to manufacture the screws to ensure optimal quality and processing life.

每种机型有多种不同直径的螺杆可供选择，对客户的产品具有更加广泛的适应性，品种繁多的特殊工程原料专用螺杆，确保产品质量最优化。

The injection

The injection unit incorporates a Dual-pillar supporting system with Balanced Twin Cylinder Injection Unit for evenly distributed force and rapid screw motion.

注射部件采用双导柱支承，双缸平衡注射装置，使螺杆在注射前进过程中受力平衡均匀。

www.ssmachinery.com

Servo Energy Saving Plastic Injection Molding Machine

伺服节能型塑料注射成型机

There is no extra energy consumption due to output volume changes according to load alteration. In the phase of holding pressure, servo motor lowers rotate speed and consumes a little of energies. In the phase of cooling, motor doesn't work and consumes no energy. According to different products, servo energy-saving injection molding machines will save 20%-80% energy and bring you prominent economic benefit.

伺服节能注塑机：输出功率随负载变化而变化，不存在多余能量的浪费。保压阶段伺服电机降低转速，耗能极低，而且在冷却阶段电机不工作，耗电为0。根据产品不同，伺服节能注塑机相比传统注塑机可节省用电20%-80%，给您带来真正的省电享受，经济效益显著。

High Precision High Response

高精度 高响应

The pressure sensor and rotary encoder with high precision and high sensitivity achieve pressure, flow closed-loop control, allows the repeat precision error to be less than 1%. It only takes 0.05 second to reach the largest output power.

高精度、高灵敏度的压力传感器和旋转编码器，实现了压力、流量闭环控制，重复精度误差小于1%。伺服电机达到最大输出功率仅需0.05秒。

Save The Cooling Water

节省冷却水

No constant flow pump and speed set motor overflow heating. When the temperature of hydraulic oil is lower, the cooling water is reduced greatly.

无定量泵+定速电机系统的溢流发热。液压油温度低，大幅度减少冷却水用量。



Super Energy Saving 超强节能

Compared with variable pump system, it can save 40% of the power. Compared with constant flow pump and fixed speed motor. It can save 60% of the power (the different kinds of products has different energy saving effects)

比变量泵系统节能40%。比定量泵+定速电机节能60% (视产品不节能效果也不同)

Low Noise 低噪音

The noise is below 78db. Servo motor has almost no noise when no movement of machine.

噪音值在78db以内，机器无动作时，伺服电机停转几乎无噪音

Schematic Structure

结构原理图



Technical Parameters
技术参数

Shuangsheng
plastic machinery

规格		SPECIFICATION	Unit	SSF320			SSF420			SSF520			SSF720		
				A	B	C	A	B	C	A	B	C	A	B	C
注射装置				INJECTION UNIT											
螺杆直径	Screw diameter	mm		19	22	25	25	27	30	25	28	32	32	34	36
螺杆长径比	Screw L/D ratio	L/D		20.5	17.7	15.5	19.8	18.4	16.5	22.6	20.2	17.7	22.3	21	19.8
理论注射容量	Shot volume(theoretical)	cm³		22.6	30	38	47	55	68	56	70	92	112	127	142.5
注射重量	Injection weight(ps)	g		20.6	27	34	43	50	62	51	64	84	102	116	130
		Oz		0.7	0.9	1.2	1.5	1.9	2.1	1.8	2.2	2.9	3.6	4.1	4.6
塑化能力	Plasticizing	g/s		2.0	2.6	3.3	3.5	4.3	5.9	5.6	6.9	8.8	10.5	11.6	13
注射速率	Injection rate	g/s		19	25	32	43	50	62	39	48	65	89	115	129
注射压力	Injection pressure	MPa		248	185	143	241	207	168	265	211	162	203	180	160
螺杆转速	Screw speed	rpm		190			200			200			200		
合模装置				CLAMPING UNIT											
合模力	Clamping force	KN		320			420			520			720		
移模行程	Open stroke	mm		155			245			270			300		
拉杆间距(宽x高)	Space between tie bars(WxH)	mm		245x195			260x260			300x300			330x330		
最大模厚	Max.Mold height	mm		260			300			340			360		
最小模厚	Min.Mold height	mm		80			100			100			130		
顶出行程	Ejector stroke	mm		40			65			70			85		
顶出力	Ejector force	KN		13			25			25			31		
顶出点数	Ejector Number	PC		1			1			1			5		
模具定位孔直径	Mould Align Diameter	mm		55			80			100			100		
其它				OTHERS											
最大油泵压力	Max.Pump pressure	MPa		14			16			16			16		
油泵马达功率	Pump motor power	KW		3			5.5			5.5			7.5		
伺服马达功率	Servo motor power	KW		5.5			7.5			7.5			12		
电热功率	Heating power	KW		2.6			3.2			4.7			6		
外形尺寸(长x宽x高)	Machine dimension(LxWxH)	m		2.80x0.86x1.35			3.1x1.10x1.4			3.3x1.10x1.6			3.9x1.20x1.65		
油箱容积	Oil tank capacity	L		85			95			115			130		
机器重量	Machine weight	t		1.05			1.65			2.2			2.8		
模板正面尺寸	Front side platen dimension														
模板侧面尺寸	Side face platen dimension														

Color Chips Making
Injection Molding Machine

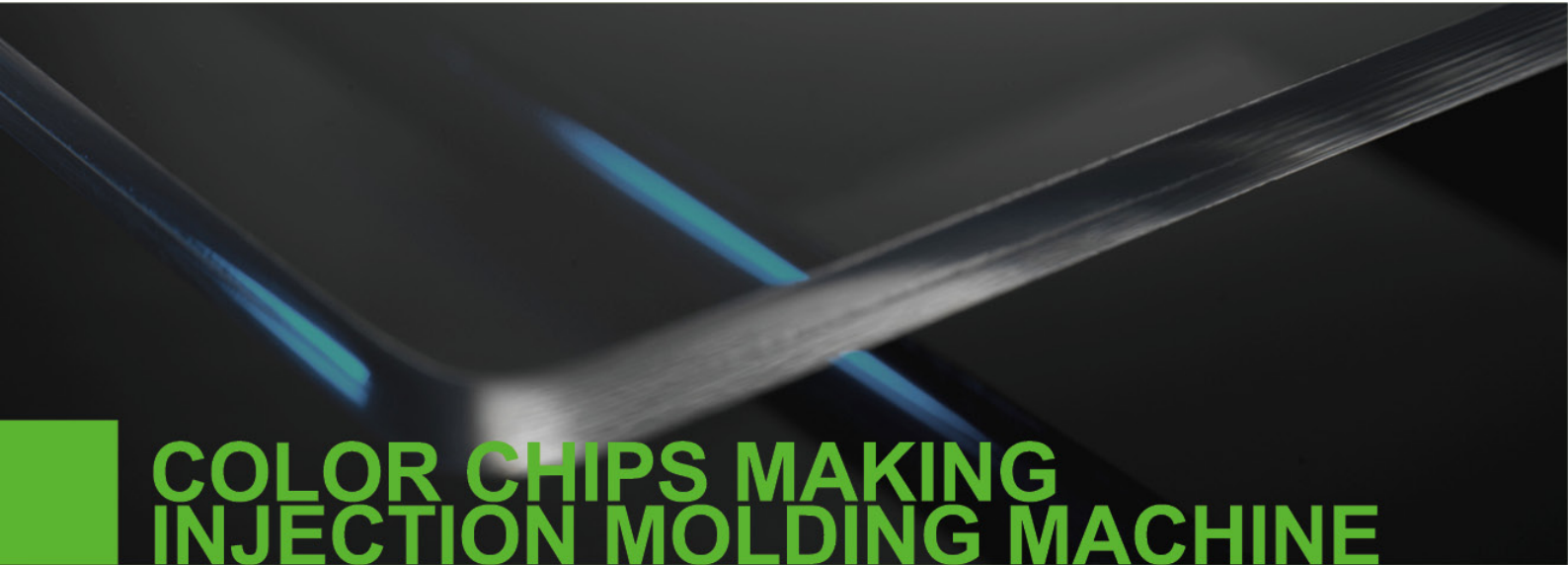
色板专用注塑机

Shuangsheng Brand professional color chips making injection molding machine is special designed for manufacturers deal with masterbatches and pigments, of which are deeply trusted by customers from home and abroad.

“双盛”牌色板专用注塑机专业为色母粒和颜料制造商打造，深受国内外客户的信赖。



Size 7cm*4.5cm(L*W)
2MM-1.5MM-1MM(T)



Features 特点

- Special designed screw, improve plasticizing capacity and surface roughness.
- Machine is small, easy to operate, investment and maintenance cost is low.
- For professional,so to be outstanding.
- 螺杆定制，提高塑化能力和表面光洁度。
- 机器小，易操作，投入和维修成本低。
- 因为专业，所以卓越。

Machine Main Parameters

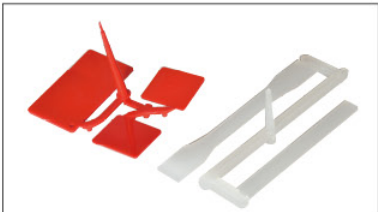
机器主要参数

锁模部分	CLAMPING UNIT		SSF380-M	SSF520-M
锁模力	Clamp force	KN	380	520
移模行程	Open stroke	mm	235	270
拉杆内间距 (宽 × 高)	Distance between tie bars (WxH)	mm	240x240	300x300
最大模厚	Max mould thickness	mm	270	340
最小模厚	Min mould thickness	mm	80	100
顶出行程	Ejector stroke	mm	60	70
顶出力	Ejector force	KN	17.5	25
顶出点数	Ejector number	PC	1	1
模具定位孔直径	Dia of mould location hole	mm	80	100
其他	OTHERS			
最大油泵压力	Max pump pressure	Mpa	14	16
油泵马达功率	Pump motor power	KW	4	5.5
电热功率	Heating power	KW	3.2	4.7
机器外形尺寸 (长 × 宽 × 高)	Machine dimension(LxWxH)	m	2.9x1.0x1.4	3.3x1.10x1.6
油箱容积	Oil tank capacity	L	90	115
机器重量	Machine weight	T	1.35	2.2

产品应用

PRODUCT APPLICATIONS

plastic injection molding machine



Configuration Options 配置

Standard Features 标准装置

- Double-cylinder balanced injection system
双缸平衡式注射系统
- Multi-stage pressure&speed injection
多级压力、多级速度射胶调整
- Back Pressure adjustment device
背压调节装置
- Low pressure mold protection
低压模保
- Single hydraulic core pulling valve block
液压单组抽芯阀块
- Multiple hydraulic ejector knock-out
多种液压顶出方式
- Mechanical, electrical safety device
机械、电气安全装置
- Auto Lubrication sysetm
自动润滑系统
- Hydraulic pressure full proportional control
油压安全比例控制
- All computer control system
全电脑控制
- Molding data memory system
模具记忆系统

Standard Components 标准配件

- Mechanical leveling pad
机械防震脚
- Extended nozzle
加长喷嘴
- Spare parts kit
备用零件
- Tool box
工具箱
- Lubrication grease
润滑脂

Optional Accessory&Function 可选配件和功能

- Robot system
机械手
- Hopper dryer
干燥料斗
- Auto loader
自动上料机
- Hopper magnet
磁力架
- Mold clamps
模具压板
- Chiller
冷水机
- Plastic dehumidifier
塑料除湿机
- Mold temperature controller
模温控制机
- Oil temperature controller
油温控制机
- Oil bypass filter
旁路滤油器
- Core pulling valve
抽芯阀
- Air blast valve
吹气阀
- Three color alarm light
三色报警灯
- Water flow regulator
水流调节器
- Ceramic Heat ring
陶瓷加热圈
- SSR
固态继电器
- Hydraulic safety
液压安全
- CE



Benelux distributor:



OBINION b.v.

Tel. +31 (0)85 784 28 33
E-mail: info@obinion.com
Web: www.obinion.com