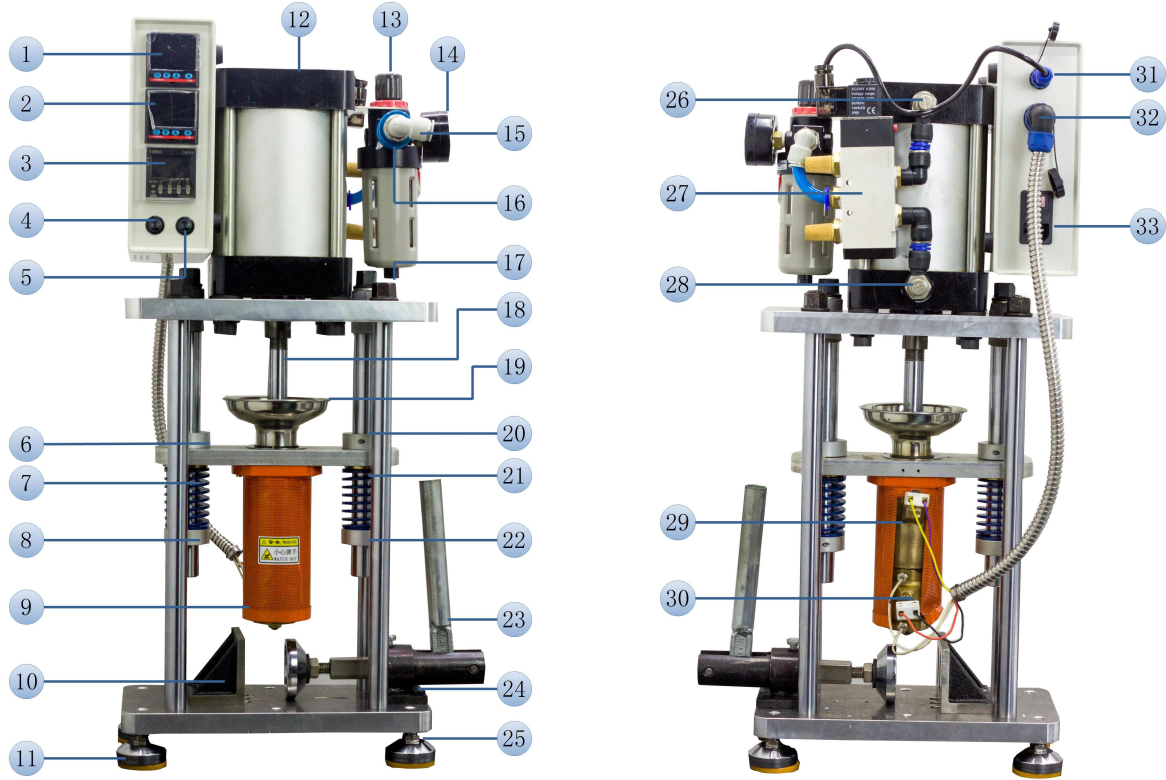


## 2. Features

### 2.1. Schematic diagram of physical function

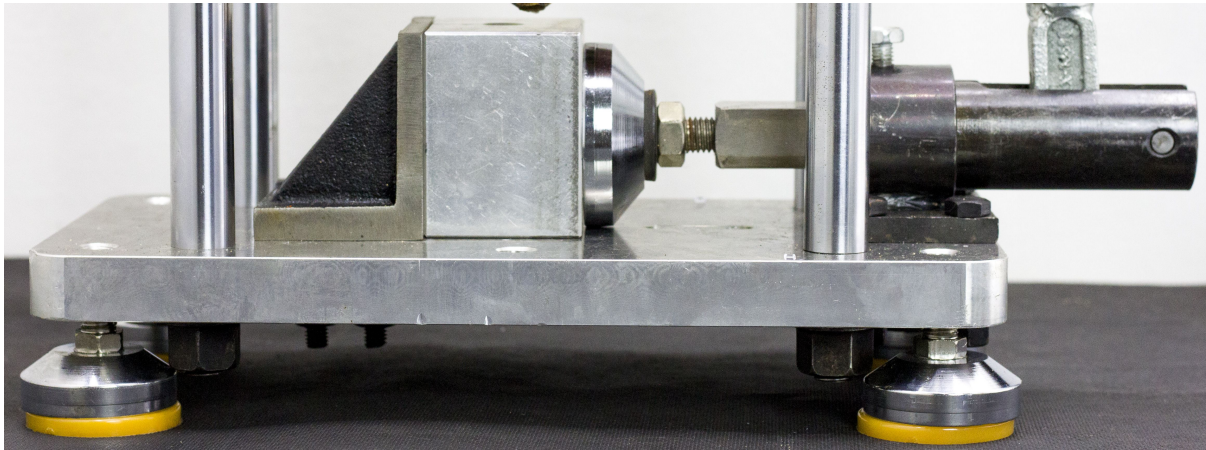


<b>1</b>	One stage temperature control	<b>12</b>	cylinder	<b>23</b>	Clamping handle
<b>2</b>	Two-stage temperature control	<b>13</b>	Air pressure control switch	<b>24</b>	Clamping screw
<b>3</b>	Control switch settings	<b>14</b>	Barometric pressure indicator	<b>25</b>	Supporting feet
<b>4</b>	Injection reset switch	<b>15</b>	Air input interface	<b>26</b>	Rising speed control valve
<b>5</b>	Injection start switch	<b>16</b>	Air switch	<b>27</b>	The electromagnetic valve
<b>6</b>	Stop ring	<b>17</b>	Air source drain valve	<b>28</b>	Down speed control valve
<b>7</b>	Cushion spring	<b>18</b>	Injection guide rod	<b>29</b>	The first section of heating ring
<b>8</b>	Stop ring	<b>19</b>	hopper	<b>30</b>	The second stage heating coil
<b>9</b>	Barrel	<b>20</b>	Stop ring	<b>31</b>	Solenoid valve voltage interface
<b>10</b>	Clamping column	<b>21</b>	Control buffer spring	<b>32</b>	Temperature control heating coil interface
<b>11</b>	Supporting feet	<b>22</b>	Stop ring	<b>33</b>	110V voltage input port

Note: The above is for reference only

## 2.2 Specifications

Specifications			
model	LSD-20G	LSD-30G	LSD-50G
size	38*22*65cm	38x27x75cm	45x45x95cm
weight	22kg	30kg	70kg
Material	6061 aluminum + 45# steel + copper	6061 aluminum + 45# steel + copper	6061 aluminum + 45# steel + copper
power	heating750W(其他 20W)	heating1100W ( 其他 20W )	heating1100W ( 其他 20W )
Heating temperature	Max300°	Max 400°	Max400°
Operating Voltage	110V	110V	110V
greatest pressure	约 1T	约 1.5T	约 4T
Injection volume	30G	40G	60G
Temperature control quantity	PID-2 位 , control 1 位	PID-2 位 , control 1	PID-2 位 , control 1
Suitable material	ABS,PC,AS,PP,PE,PET,PVCWait or not corrode various raw materials of copper		
Locking method	Manual clamping		
Clamping force	600KG		
Mold opening stroke	60mm ( Adjustable )		
Mold size	80x60x50mm ( Adjustable )		
Plasticizing uniform design	Have		



#### **2.2.4 Electrical part**

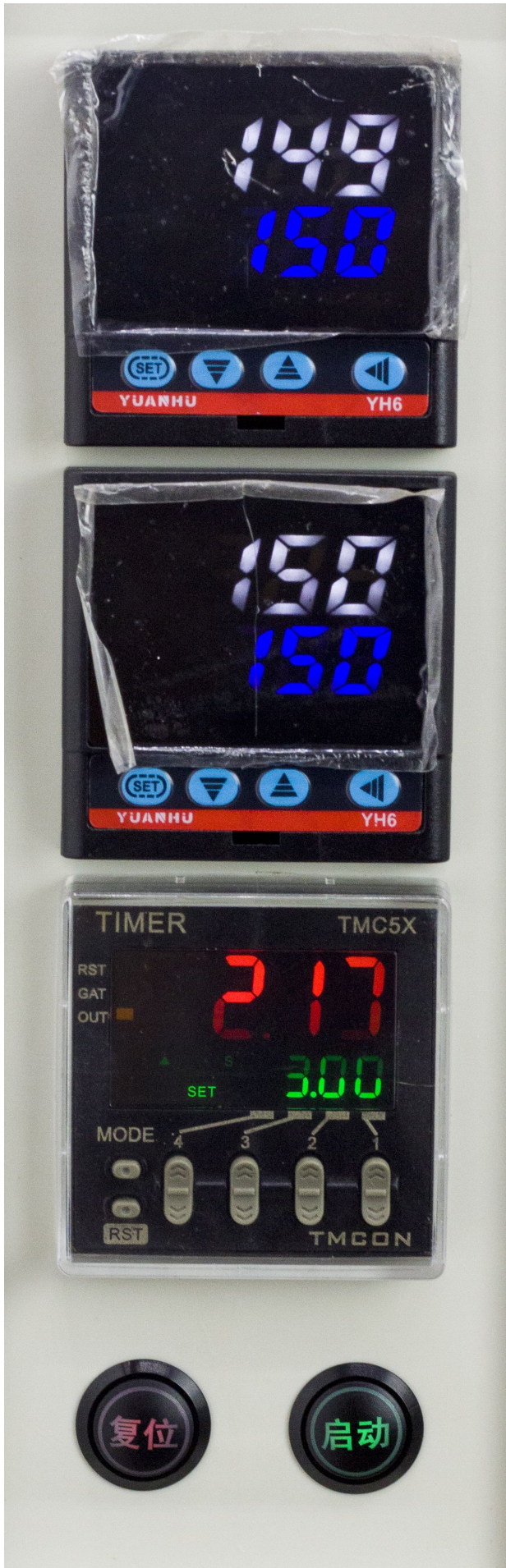
**The electrical part of this machine is composed of two temperature control tables and a cylinder control table**

**There are two commonly used modes for cylinder control:**

**D mode (the cylinder will act after the start switch is triggered, set the time for the cylinder to return) once**

**B mode (start the switch to trigger the cylinder action, set the actual length of the cylinder to return to the set time and then act again) cyclic action**

**Note: The time of this function is the holding time of injection molding,**



and the time can be adjusted by yourself according to the injection



Display, the white word is the actual temperature, the blue word is the set temperature



Set the button, press to set the temperature, and the blue number on the display will flash



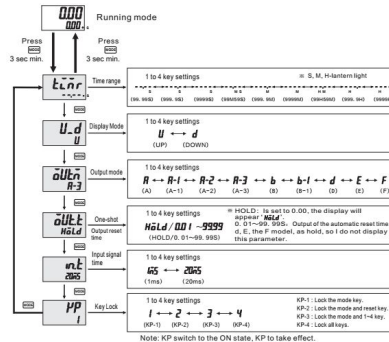
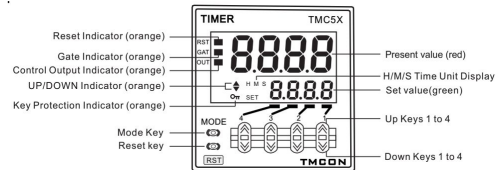
Move down the key, press down the value to decrease



Up shift key, press the value to increase



Confirm button, set the temperature and press OK to start heating or cooling



Terminate cylinder action and return



Start cylinder action injection

### **3. How to use**

**3.1.1. What kind of particles need to be injected? You need to find or know the injection temperature of the particles, such as AS resin 220-270 degrees, abs 200-230 degrees, etc., or 10 degrees higher than the original temperature. Then enter the temperature value to be heated on the temperature controller. Pour plastic materials into the barrel. Wait for the temperature to reach the specified temperature,**

**3.1.2. Prepare the abrasive tools that need to be injected, wait for ten minutes when the temperature reaches the temperature value, place the abrasive tools to align the nozzle and injection port, set the pressure holding time (2-8 seconds), trigger the pneumatic switch, and the cylinder will act. After waiting for the cylinder to return after maintaining the pressure, open the mold and take out the abrasive tools and products.**

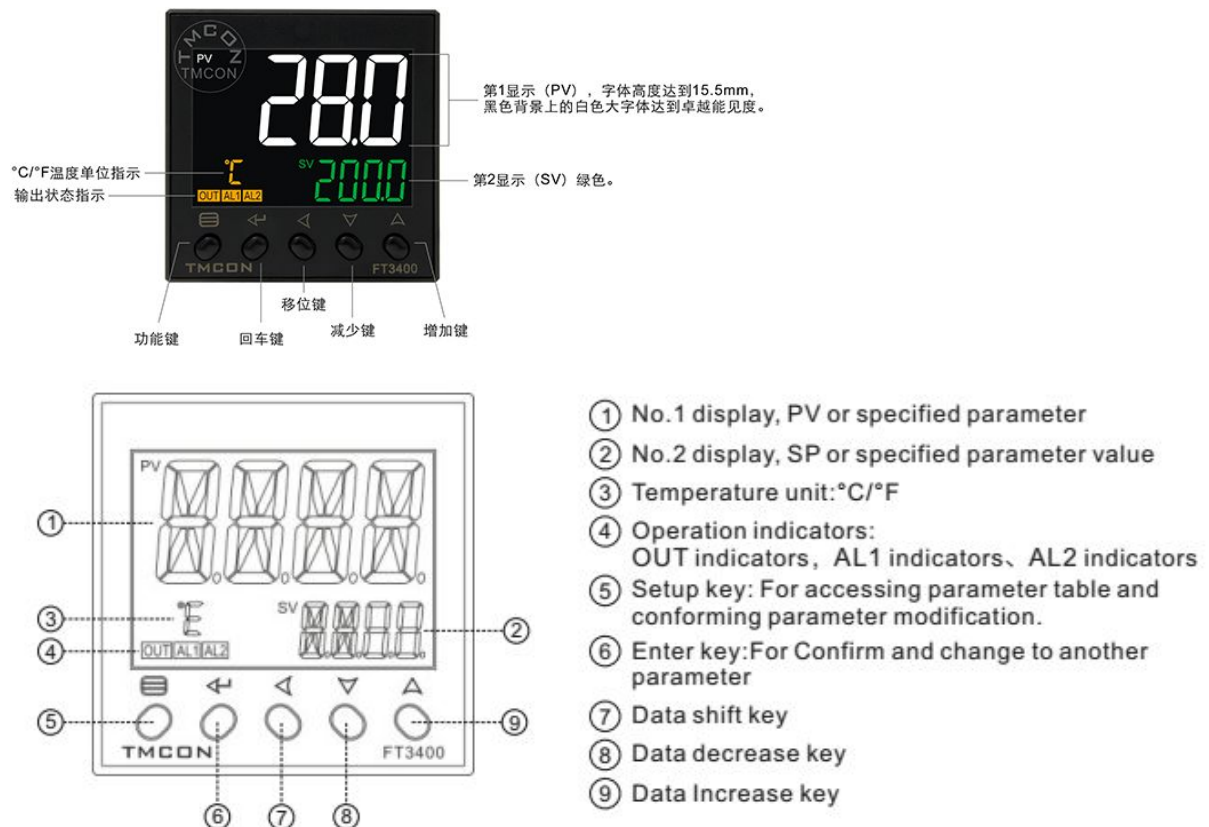
**3.1.3. The backstop ring of the injection molding machine can be adjusted up and down to match the height of the abrasive tool. Please adjust the suitable position according to your own model and grinding tool**

**Note: injection molding method, temperature, speed. It is very related, please master the skills according to your injection parts. It should be noted that the temperature is too high, and the plastic particles can not stay in the barrel for too long to avoid plasticization.**

#### 4. Matters needing attention

1. Please wear anti-scalding protective gear when using this injection molding machine.
2. Be careful not to load or unload the material by hand during the injection movement, so as not to pinch your arm.
3. When using this machine for production and experiment, the 110v voltage needs to be grounded safely, and the staff cannot operate the machine barefoot or wearing slippers to avoid electric shock.

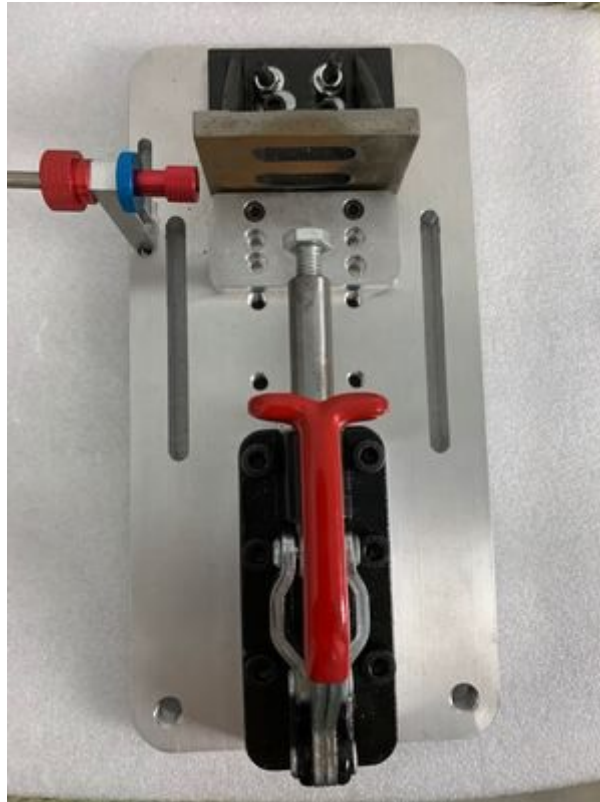
#### 5 Thermometer update



The use of the latest table is simpler and more stable than before. The green temperature is the temperature to be set. White is the actual temperature. For example, if you need a temperature of 260 degrees directly, press the decrease or increase key and the shift key to adjust the temperature. After pressing the enter key, the temperature control meter starts to heat up.

## **Quick mold clamping device**

### **Quick clamping device.**



- 1. The production price of abrasive tools is determined according to the material and complexity of the abrasive tools**
- 2. Abrasive tool display diagram**











