

Good... Better!... BEST!...



**TWR Series**

Rotary Table / Separated Injection Multi-color  
Plastic Injection Molding Machines

**TXR Series**

Co-injection Multi-color Plastic Injection Molding  
Machines



**Multi-color  
Multi-resin  
Plastic Injection Molding**

**TWR** Series  
**TXR** Series



Being Advanced is Most Important at CLF.



# TWR/TXR Series

## TWR Series

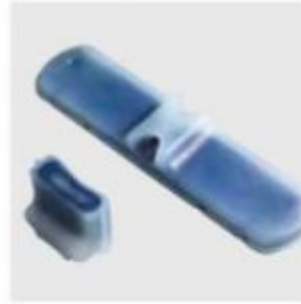
Rotary Table / Separated Injection Multi-color  
Plastic Injection Molding Machines

## TXR Series

Co-injection Multi-color Plastic Injection Molding  
Machines



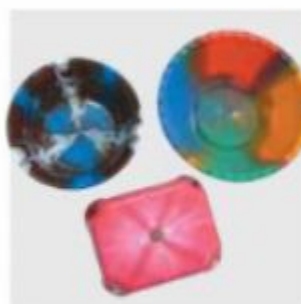
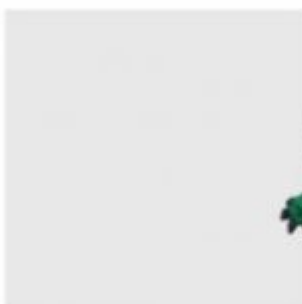




Designed and manufactured by CHUAN LIH FA, the multi-color with multi-material plastic injection molding machines enable customers to produce versatile and beautiful products, such as marble patterns, sandwich injection molded and multi-color products. These products feature heat isolation, anti-vibration and anti-slip.



The machine series provides maximum flexibility of production. This not only greatly upgrades added value on your products, But also helps you stay competitive. Other benefits are that you will get more profits and a greater market sharing percentage.



# TWR/TXR Series

## TWR Series

### Over Molding

- Rotating Table for Movable Platen
- Rotating Holder for Product Transfer
- Two Separate Injection Units and Two-color Combination

## TXR Series

### Co-injection

- Sandwich Injection Molding
- Marble Pattern Injection Molding
- Striped Product Injection Molding



**CLF125TWR**



**CLF-250TWR**



**CLF-950TXR**



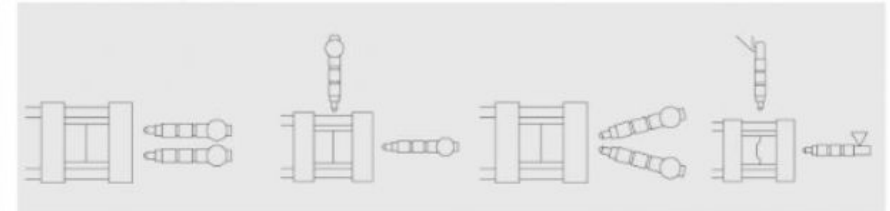
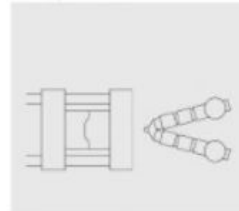
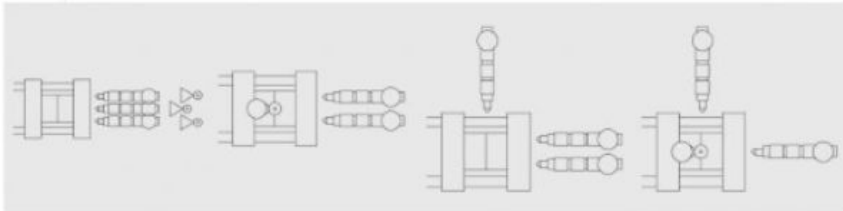
**CLF-1200TWR**



Three Injection Unit

Co-injection Unit

Over Molding Two Injection Unit





# Maximum Operational Convenience...

## Advanced TA Controllers Easy to Learn and Operate

- Japan-imported colorful TFT 14" LCD display.
- PID temperature control, screw protection and thermocouple breakage detection functions. High accuracy temperature control in  $\pm 1^{\circ}\text{C}$ .
- Micro-computer control provides memory function. Each injection unit features 6-step injection, 3-step pressure hold and 3-step changing.
- Independently intermittent injection is suitable for sandwich injection and color-mixing injection.
- 2-step pressure and speed control for rotary table ensures high positioning accuracy.
- 2-step pressure and speed control for ejecting.
- 60 data change records, 60 alarm message records.
- The controller provides 30 sets of molding parameter memory. Optional a 3-1/2" floppy disc can be used for saving over 1000 sets of molding parameter settings.
- The hydraulic pressure and flow can be controlled in linear slope according to variation on each step. This feature increases motion smoothness of the machine.
- 4-step mold open, 4-step mold-close with speed reduction settings for 3 platens to avoid bumping.
- By using ethernet, the data of the machine can be transferred to a far-end computer. This data can be printed and saved, allowing for S.P.C. analysis and reference to Q.C. department or production control department.
- Printing function
- 20 sets of shot data display for automatic molding and average value display.
- Interface with robot and hydraulic quick clamping device.







# TWR Series Rotary Table / Separated Injection Multi-color Plastic Injection Machines

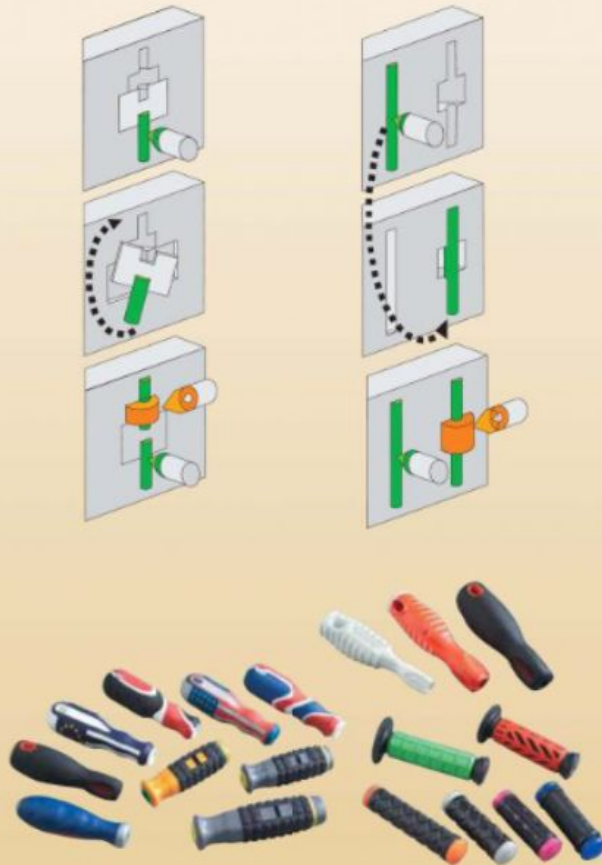
## A Rotary-table Injection Molding

This injection molding technology employs multiple same male molds and different female molds. The rotary table rotates male molds combined with multi-injection to produce multi-color and multi-material products.



## B Rotary Holder Injection Molding

This injection molding technology employs different male and female molds. The rotating shaft rotates the product holder to move the product. Such multiple injections produce products with special multi-color and multi-material effect.



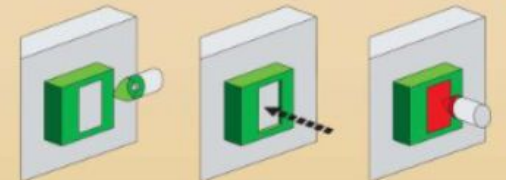
## C Bi-injection Molding

This injection molding technology employs two injection units. Both units shoot materials into the cavity through different ports, which produces a two-color effect.



### Shaft Return Injection Molding

This injection molding technology is operated together with the core function. When the first injection is finished, the mold core returns to leave a space. Then the second injection performs to produce products with multi-color and multi-material effect.



# TWR Series

## Rotary Table / Separated Injection Multi-color Plastic Injection Molding Machines

### Optional Equipment:

1. Rotary-table.
2. Rotary-shaft for product holder.
3. Rotary joint of rotary table for water or hydraulic.

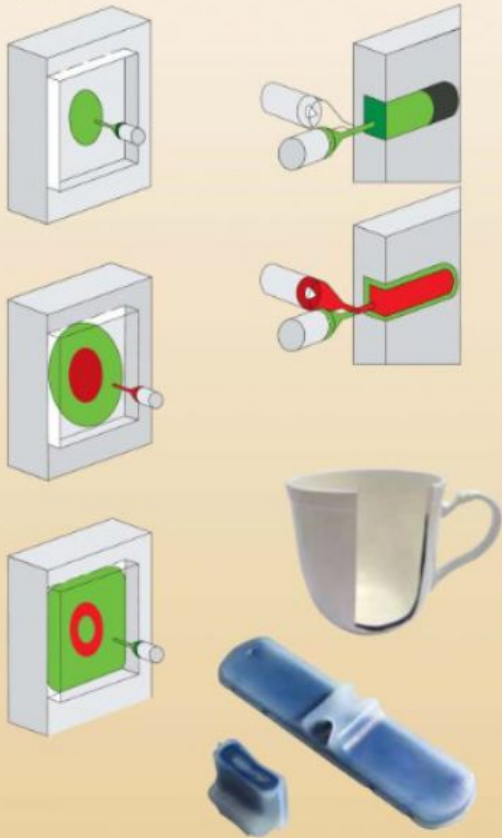
Machine Model		CLF-120TWR				CLF-180TWR				CLF-285TWR				CLF-400TWR				CLF500TWR				CLF-850TWR				CLF-1200TWR															
International Code		1200H-136 / 136				1800H-416 / 416				2850H-717 / 717				4000H-1000 / 1000				5000H-1470 / 1470				8500H-1470 / 1470				12000H-2436 / 2436															
INJECTION UNIT		第一射出單元		第二射出單元		第一射出單元		第二射出單元		第一射出單元		第二射出單元		第一射出單元		第二射出單元		第一射出單元		第二射出單元		第一射出單元		第二射出單元		第一射出單元		第二射出單元													
Screw Diameter	mm	25	28	25	28	30	35	40	30	35	40	40	45	50	40	45	50	45	50	55	45	50	55	50	55	60	50	55	60	50	55	60	50	55	60	65	70	75	65	70	75
Theoretical Inj. Volume	cm <sup>3</sup>	54	67	54	67	148	202	263	148	202	263	307	389	480	307	389	480	429	530	641	429	530	641	588	712	847	588	712	847	588	712	847	588	712	847	1095	1269	1457	1095	1269	1457
Injection Pressure	kg/cm <sup>2</sup>	2520	2009	2520	2009	2800	2057	1575	2800	2057	1575	2327	1839	1490	2327	1839	1490	2322	1881	1555	2322	1881	1555	2500	2066	1736	2500	2066	1736	2500	2066	1736	2500	2066	1736	2226	1920	1672	2226	1920	1672
Injection Rate	cm <sup>3</sup> /sec	56	70	56	70	65	89	116	65	89	116	94	118	146	94	118	146	121	150	181	121	150	181	150	182	216	150	182	216	150	182	216	150	182	216	312	362	416	312	362	416
Shot Weight	gram	49	60	49	60	134	182	237	134	182	237	277	351	433	277	351	433	387	478	578	387	478	578	531	643	764	531	643	764	531	643	764	531	643	764	988	1145	1315	988	1145	1315
Plasticizing Rate	kg/hr	18	23	18	23	31	42	55	31	42	55	56	71	88	56	71	88	69	85	103	69	85	103	73	88	105	73	88	105	73	88	105	73	88	105	190	220	253	190	220	253
Screw Rotation	RPM	240		240		260		260		234		234		201		201		161		161		150		150		213		213													
No. of Heating Zones	zones	4		4		5		5		5		5		5		5		5		5		6		6		7		7													
Heating Capacity	kw	3.4		3.4		5		5		7.9		7.9		10		10		13.9		13.9		13.9		13.9		19.5		19.5													
CLAMPING UNIT																																									
Distance Between Tie Bars (H x V)	mm	700 x 360				770 x 400				950 x 500				1120 x 550				1250 x 600				1520 x 720				1720 x 820															
Platen Size	mm	900 x 560				1030 x 660				1280 x 830				1510 x 940				1700 x 1030				2080 x 1280				2260 x 1460															
Rotary Table diameter	mm	750				800				1000				1150				1300				1600				1750															
Center Distance of Injection Nozzle	mm	360				400				500				550				650				700				900															
Mold Thickness	mm	150 - 450				150 - 550				200 - 650				250 - 750				300 - 900				350 - 1100				400 - 1300															
Die Opening Stroke	mm	420				500				610				800				1000				1000				1300															
Clamping Force	Tons(KN)	120 (1200)				180 (1800)				285 (2850)				400 (4000)				500 (5000)				500 (5000)				1200 (12000)															
Positioning Ring Diameter	mm	100		100		100		100		100		100		125		125		125		125		160		160		160		160													
Ejecting Stroke	mm	110		110		150		150		150		150		200		200		190		190		300		300		250		250													
GENERAL DATA																																									
Pump Driving Motor	Hp(kw)	30 (22.4)				40 (30)				50 (37)				60 (45)				80 (60)				80 (60)				150 (112)															
Oil Tank Capacity	Liters	500				550				800				1000				1250				1600				2000															
Machine Size(L x W x H)	m	5.6 x 1.65 x 1.8				6 x 1.75 x 1.9				7.2 x 2.1 x 2.1				8.5 x 2.4 x 2.2				9.2 x 2.5 x 2.2				9.7 x 2.7 x 2.4				13.2 x 3.2 x 2.9															
Net Weight	Tons	8				12				18				30				40				55				85															

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## D Sandwich Injection Molding

The sandwich injection molding is a multi-layer injection molding. This injection molding technology employs two injection units combined with specially designed co-injection nozzle. The injection system shoots surface and core materials to achieve special layers of products. The applicable core materials include recycled foam material or special-function resins.



## E Marble Pattern Injection Molding

This injection molding technology employs two injection units combined with a specially designed co-injection nozzle. The first and second injection unit performs alternative multi-function controlled by time and position. This produces marble patterns with special multi-color effect.



## F Striped Product Injection Molding

This injection molding technology employs two injection units combined with a specially designed co-injection nozzle. The first and second injection unit performs alternative multi-injection. This produces a stripe pattern on the product.



# TXR Series

## Co-injection Multi-color Plastic Injection Molding Machines

### Optional Equipment:

1. Co-injection nozzle.
2. Mix injection nozzle.
3. Sandwich injection nozzle.

Machine Model		CLF-120TXR				CLF-180TXR				CLF-285TXR				CLF-400TXR				CLF500TXR				CLF-750TXR				CLF-950TXR				CLF-1200TXR																	
International Code		1200H-136 / 136				1800H-416 / 416				2850H-717 / 717				4000H-1000 / 1000				5000H-1470 / 1470				7500H-1470 / 1470				9500H-2436 / 2436				12000H-2436 / 2436																	
INJECTION UNIT		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit		1st Inj. Unit		2nd Inj. Unit															
Screw Diameter	mm	25	28	25	28	30	35	40	30	35	40	40	45	50	40	45	50	45	50	55	45	50	55	50	55	60	50	55	60	50	55	60	50	55	60	65	70	75	65	70	75	65	70	75	65	70	75
Theoretical Inj. Volume	cm <sup>3</sup>	54	67	54	67	148	202	263	148	202	263	307	389	480	307	389	480	429	530	641	429	530	641	588	712	847	588	712	847	588	712	847	588	712	847	1095	1269	1457	1095	1269	1457	1095	1269	1457	1095	1269	1457
Injection Pressure	kg/cm <sup>2</sup>	2520	2009	2520	2009	2800	2057	1575	2800	2057	1575	2327	1839	1490	2327	1839	1490	2322	1881	1555	2322	1881	1555	2500	2066	1736	2500	2066	1736	2500	2066	1736	2500	2066	1736	2226	1920	1672	2226	1920	1672	2226	1920	1672	2226	1920	1672
Injection Rate	cm <sup>3</sup> /sec.	56	70	56	70	65	89	116	65	89	116	94	118	146	94	118	146	121	150	181	121	150	181	150	182	216	150	182	216	174	211	251	174	211	251	238	276	317	238	276	317	238	276	317	238	276	317
Shot Weight	gram	49	60	49	60	134	182	237	134	182	237	277	351	433	277	351	433	387	478	578	387	478	578	531	643	764	531	643	764	531	643	764	531	643	764	988	1145	1315	988	1145	1315	988	1145	1315	988	1145	1315
Plasticizing Rate	kg/hr	18	23	18	23	31	42	55	31	42	55	56	71	88	56	71	88	69	85	103	69	85	103	89	103	125	89	103	125	85	102	122	85	102	122	145	168	193	145	168	193	145	168	193	145	168	193
Screw Rotation	RPM	240		240		260		260		234		234		201		201		161		161		187		187		162		162		213		213															
No. of Heating Zones	zones	4		4		5		5		5		5		5		5		5		5		5		5		7		7		7		7															
Heating Capacity	kw	3.4		3.4		5		5		7.9		7.9		10		10		13.9		13.9		13.9		13.9		19.5		19.5		19.5		19.5															
CLAMPING UNIT																																															
Distance Between Tie Bars (H x V)	mm	420 x 420				510 x 510				610 x 610				730 x 730				810 x 810				960 x 960				1120 x 1120				1250 x 1250																	
Platen Size	mm	630 x 630				765 x 765				940 x 940				1120 x 1120				1260 x 1260				1480 x 1480				1720 x 1720				1900 x 1900																	
Mold Thickness	mm	150 - 450				150 - 550				200 - 650				250 - 750				300 - 900				350 - 1100				400 - 1200				400 - 1300																	
Die Opening Stroke	mm	420				500				610				750				800				1000				1200				1300																	
Clamping Force	Tons(KN)	120 (1200)				180 (1800)				285 (2850)				400 (4000)				500 (5000)				750 (7500)				950 (9500)				1200 (12000)																	
Positioning Ring Diameter	mm	125				160				160				160				200				200				250				250																	
Ejecting Stroke	mm	110				150				150				200				200				300				300				300																	
GENERAL DATA																																															
Pump Driving Motor	Hp(kw)	30 (22.4)				40 (30)				50 (37)				60 (45)				80 (60)				100 (74.6)				120 (89.6)				150 (112)																	
Oil Tank Capacity	Liters	500				550				800				1000				1250				1600				1800				2000																	
Machine Size(L x W x H)	m	5.6 x 1.65 x 1.8				6 x 1.75 x 1.9				7.2 x 2.1 x 2.1				8.5 x 2.4 x 2.2				9.2 x 2.5 x 2.2				9.7 x 2.7 x 2.4				11.8 x 2.9 x 2.7				13.2 x 3.2 x 2.9																	
Net Weight	Tons	8				12				18				30				40				50				65				85																	

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**TWR Series**  
**TXR Series**



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