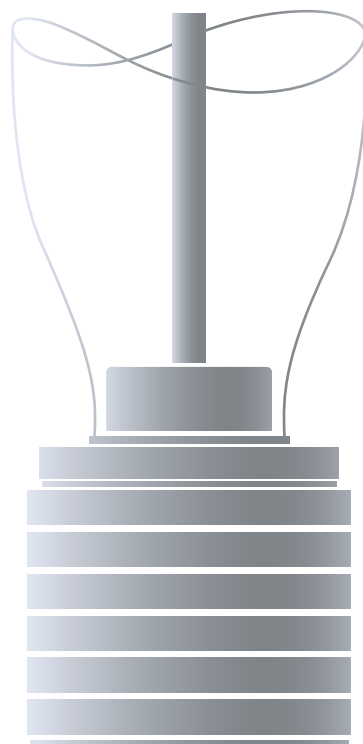
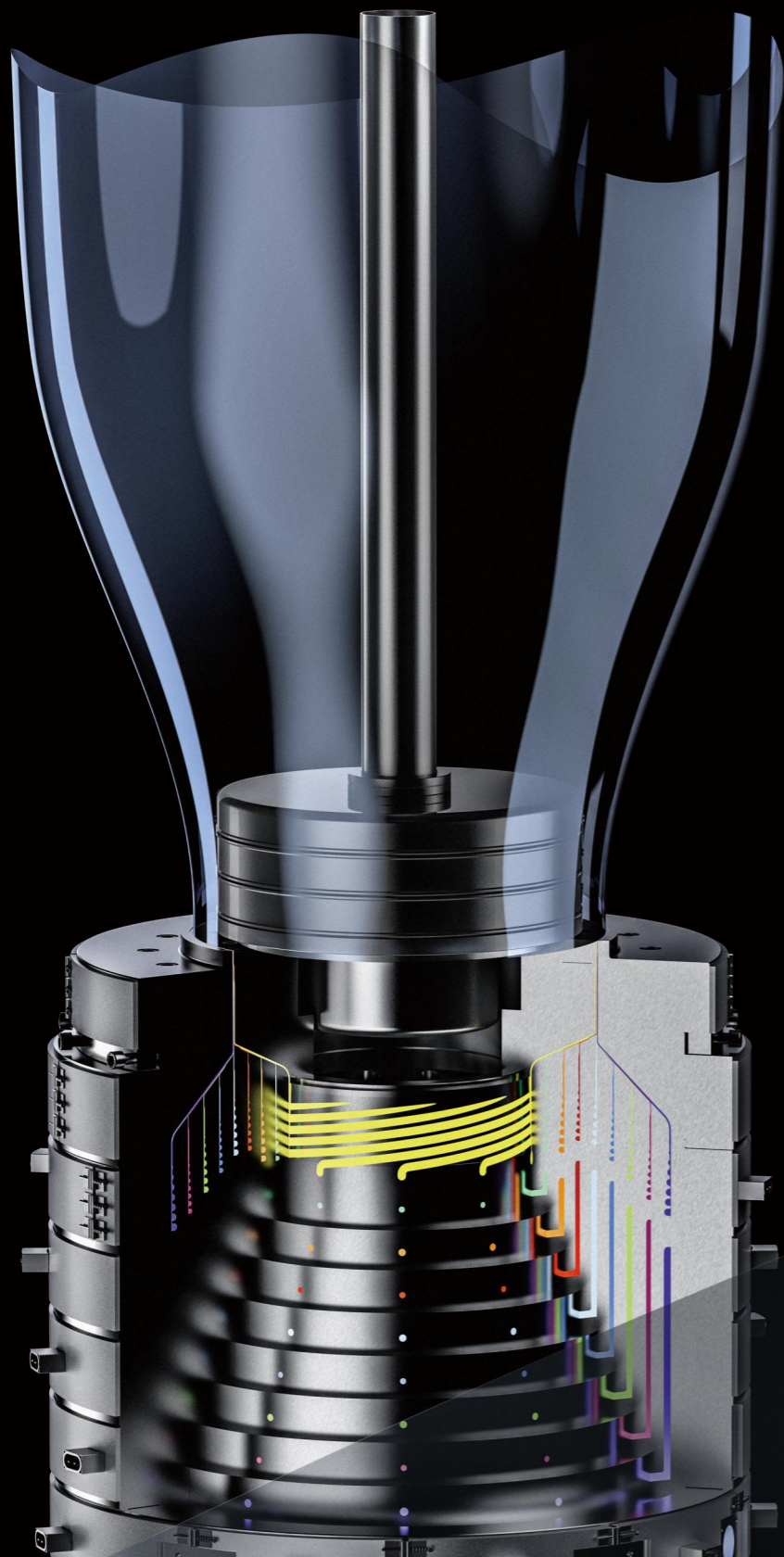


BLOWN FILM DIE



From
Dreams
to
Reality

知您所需
创您所想



Multilayer Coextrusion Blown Film Die

精诚以精工细制的严谨,持续拓宽高端吹膜模头的应用边界
为用户提供超越期待的品质体验。

JCtimes continues to expand the application boundaries of high-end blown film die, with the rigor of
craftsmanship, providing exceeding customer expectations experience.

04 Product Category

多层共挤吹膜模头 主要类别

中心进料模头

「口模从Φ30mm-Φ2650mm」

单层 / 三层 / 五层 / 七层 / 九层

侧边进料模头

「口模从Φ30mm-Φ1000mm」

单层 / 三层 / 五层 / 七层 / 九层

平面锥度叠加模头

「口模从Φ150mm-Φ800mm」

单层 / 三层 / 五层 / 七层

平面叠加模头

「口模从Φ150mm-Φ800mm」

单层 / 三层 / 五层 / 七层 / 九层 / 十一层

- 模头钢材采用具有超高强度和韧性的优质钢材，钢材硬度HRC38-42。
- 模头流道表面粗糙度：0.02-0.03μm。
- 模头流道表面镀铬处理：
镀层厚度0.02-0.04mm，镀层硬度Rockwell c60-65；
镀层厚度0.015-0.02mm，镀层硬度Rockwell c65-70。
- 外模唇及内模唇圆度<0.02mm。
- 模头紧固零件选用12.9级高强度螺栓。
- 模头最高承受压力为550bar。
- 模头内冷循环风管采用peek隔温材料。

Main Categories of Multilayer Coextrusion Blown Film Die

01

Center Feed Die

Die lip from Φ30mm-Φ2650mm

Single floor / Three / Five / Seven / Nine

02

Side Feed Die

Die lip from Φ30mm-Φ1000mm

Single floor / Three / Five / Seven / Nine

03

Flat Tapered Stacking Die

Die lip from Φ150mm-Φ800mm

Single floor / three / five / seven

04

Flat Stacking Die

Die lip from Φ150mm-Φ800mm

Single floor / three / five / seven / nine / eleven

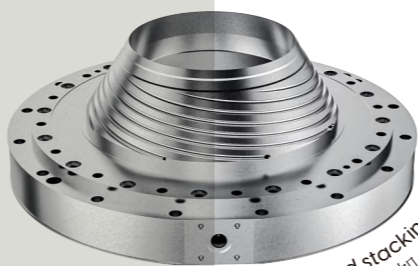
- The material of die is made of high quality steel with high strength and toughness. Hardness of Steel is HRC 38-42.
- Surface roughness of die manifold: 0.02-0.03μm.
- Die manifold plating with chrome: thickness 0.02-0.04mm, hardness Rockwell c60-65; thickness 0.015-0.02mm, plating Rockwell c65-70.
- Roundness of outer and inner die lip < 0.02mm.
- The die fastening parts are made of grade 12.9 high strength bolts.
- The maximum pressure of die is 550 bar.
- The internal cold circulating air duct is made of peek insulation material.



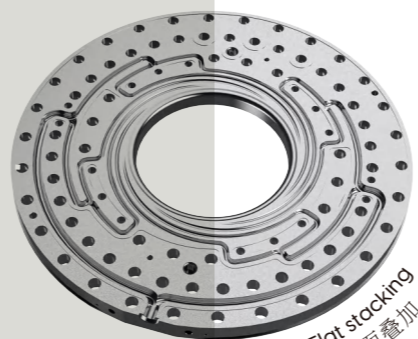
Center Feed
中心进料



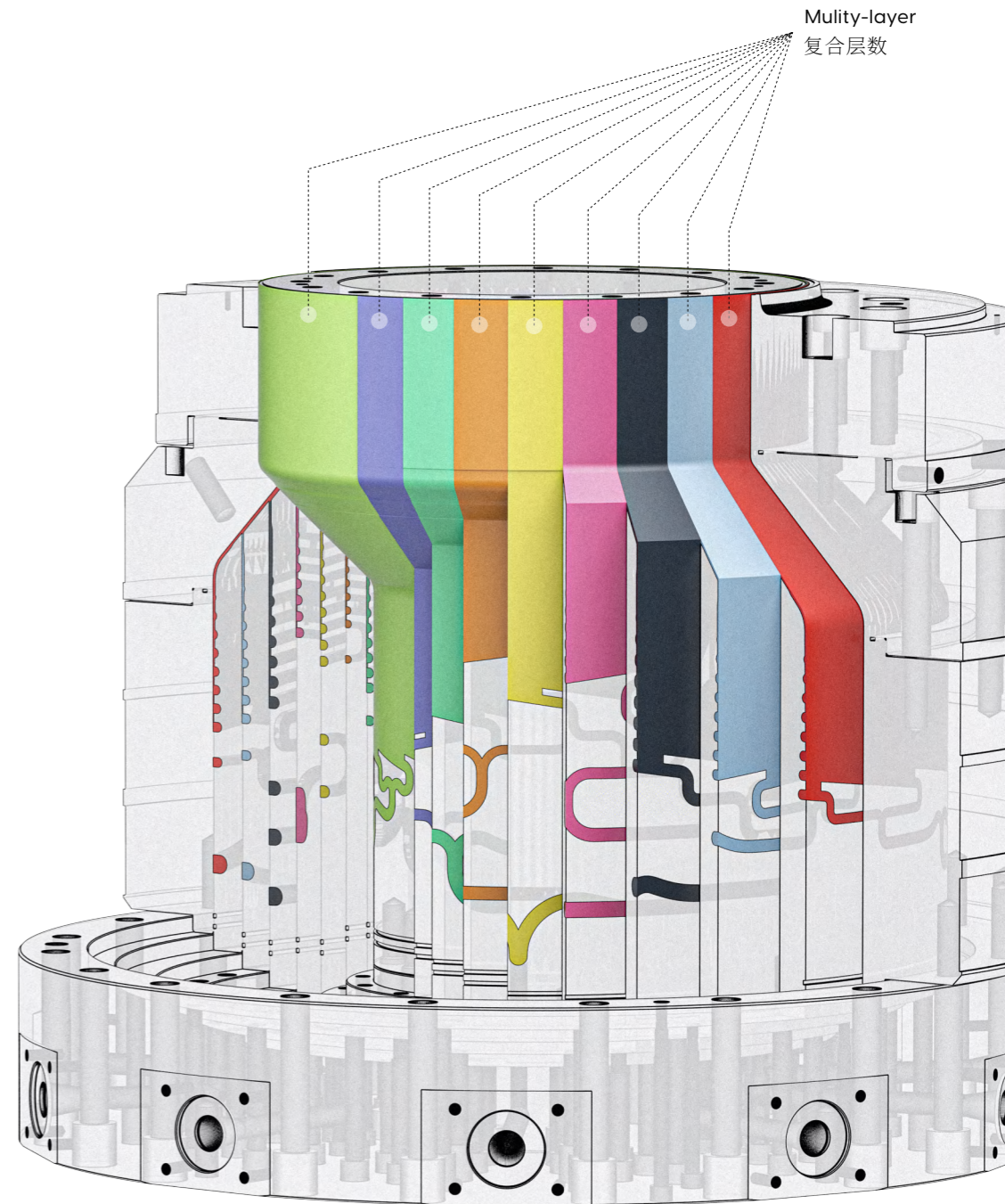
Side Feed
侧边进料



Flat tapered stacking
平面锥度叠加



Flat stacking
平面叠加

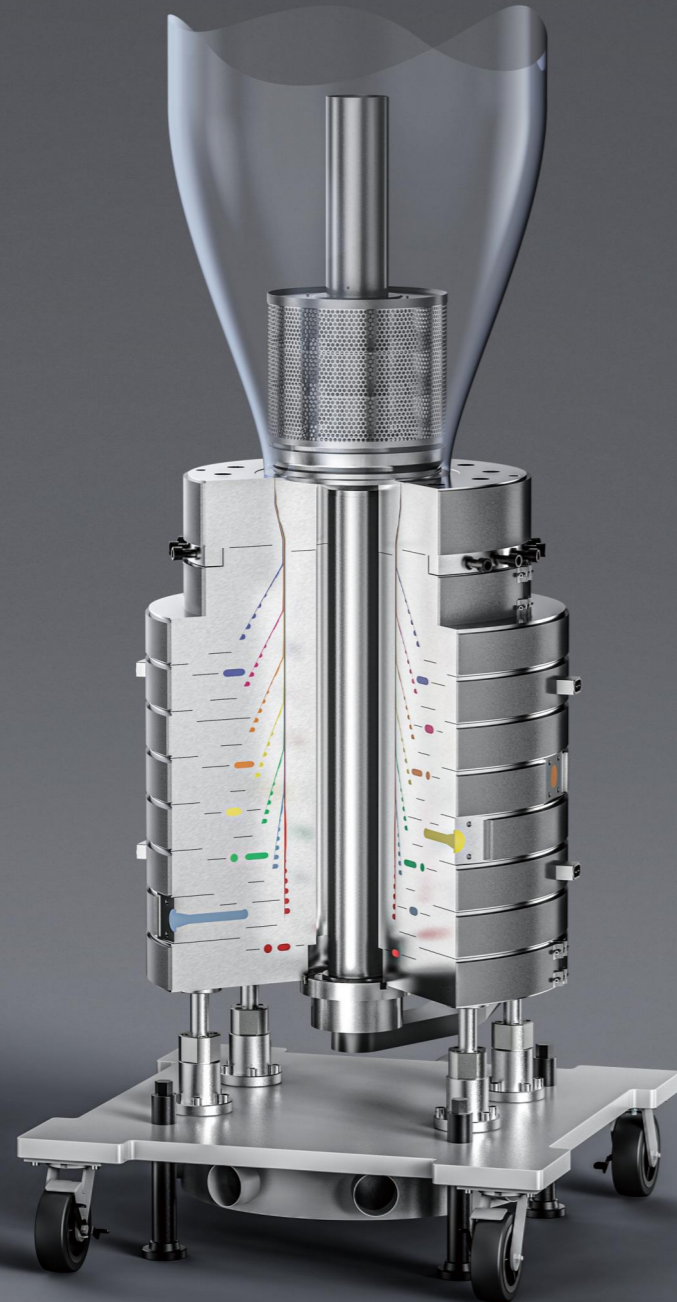


Side feed 9-layer coextrusion blown film die
侧边进料9层共挤吹膜模头

06

Multilayer Coextrusion

Multilayer layer coextrusion in multimanifold die. The layers can be arbitrarily swapped, and the temperature of each layer can be controlled individually. Satisfy the high temperature difference which can effectively prevent material degradation. It is easy to process, clean and maintain.



平面锥度叠加7层共挤吹膜模头
7-layer horizontally coextrusion blown film dies

7%

共挤层的均匀性在7%以内

The uniformity of the each layer
is within 7%

30°C

各层温度差异最大可达30°C

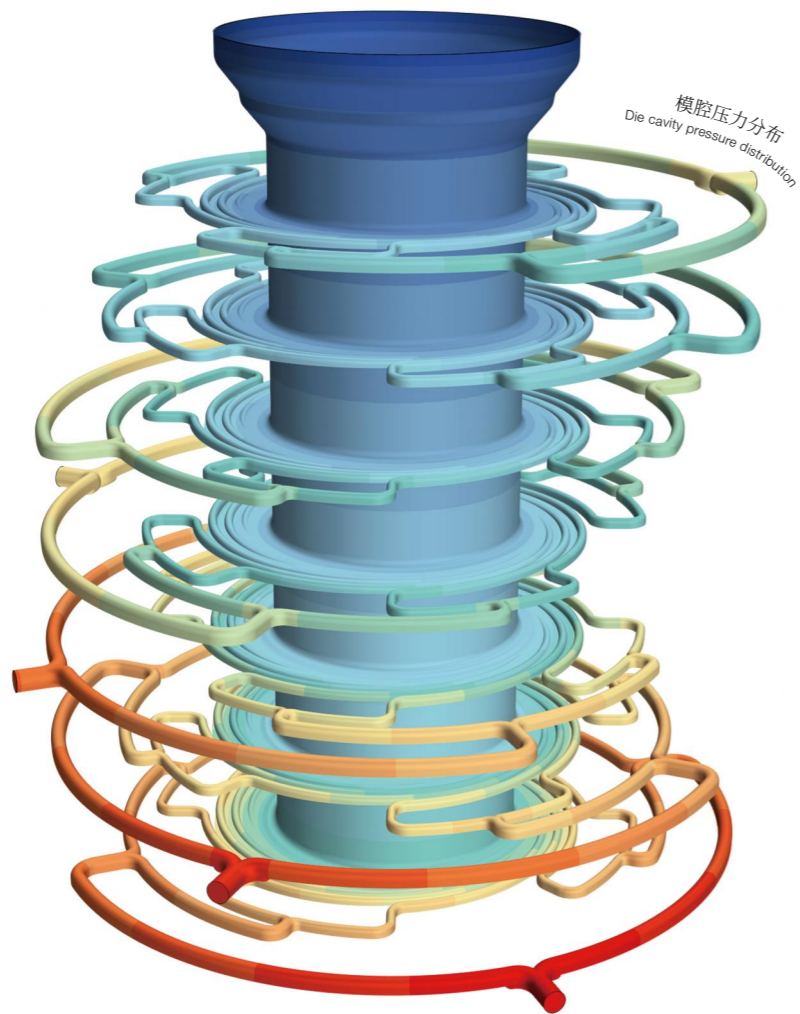
The temperature difference of each
layer can be up to 30°C

多层共挤

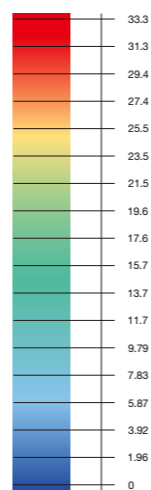
多层模内共挤复合模头, 层数可以任意组合, 每层温度可以单独控制, 满足工艺温度的高温差, 有效防止物料降解。易于加工、清理及保养。

08 Analysis System

流道分析系统



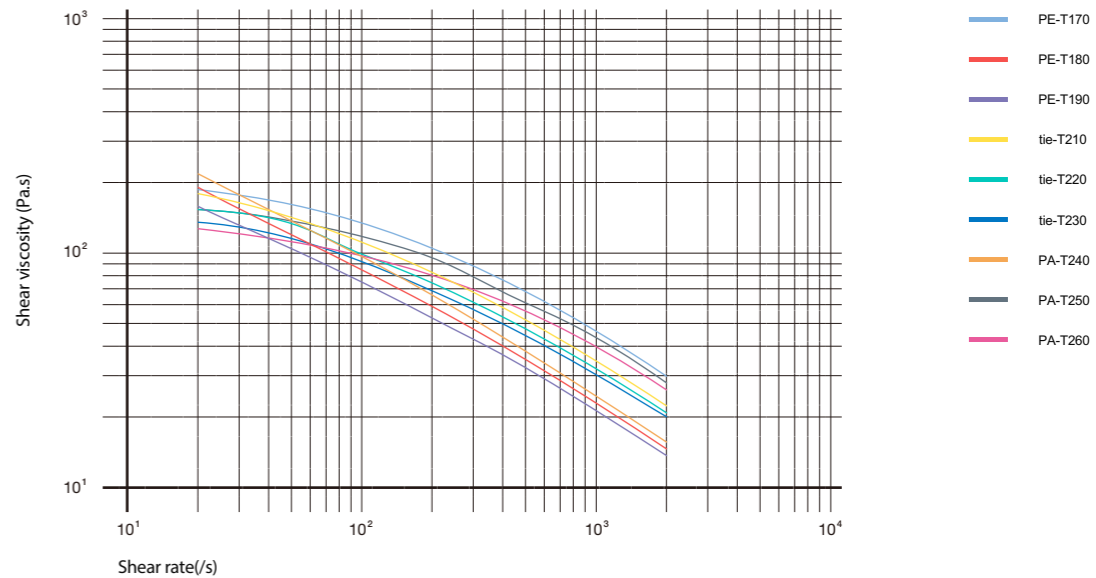
Pressure (MPa)



剪切速率和剪切粘度的关系曲线

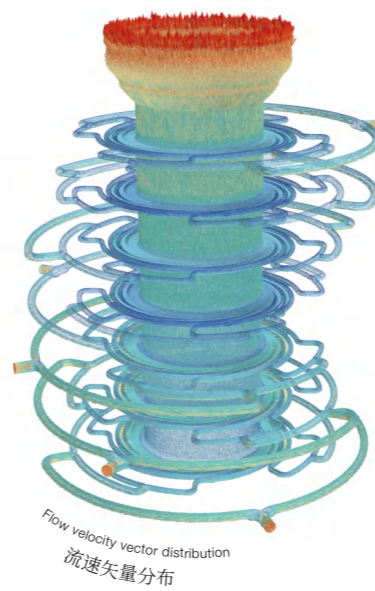
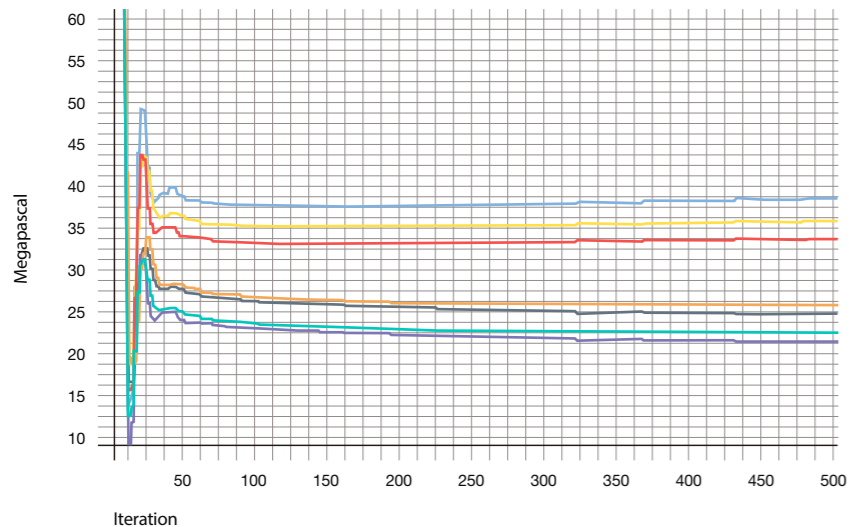
The relationship between shear rate and shear viscosity

Rosand Precision Rheometer

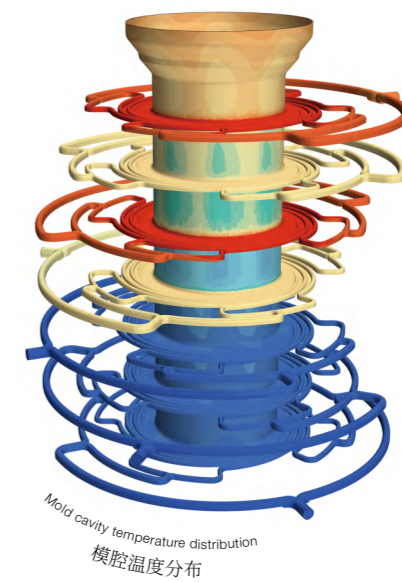
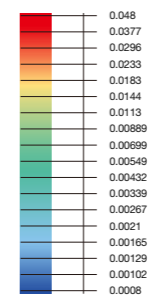


模头各层入口压力

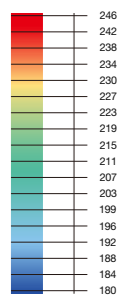
Die inlet pressure for each layer



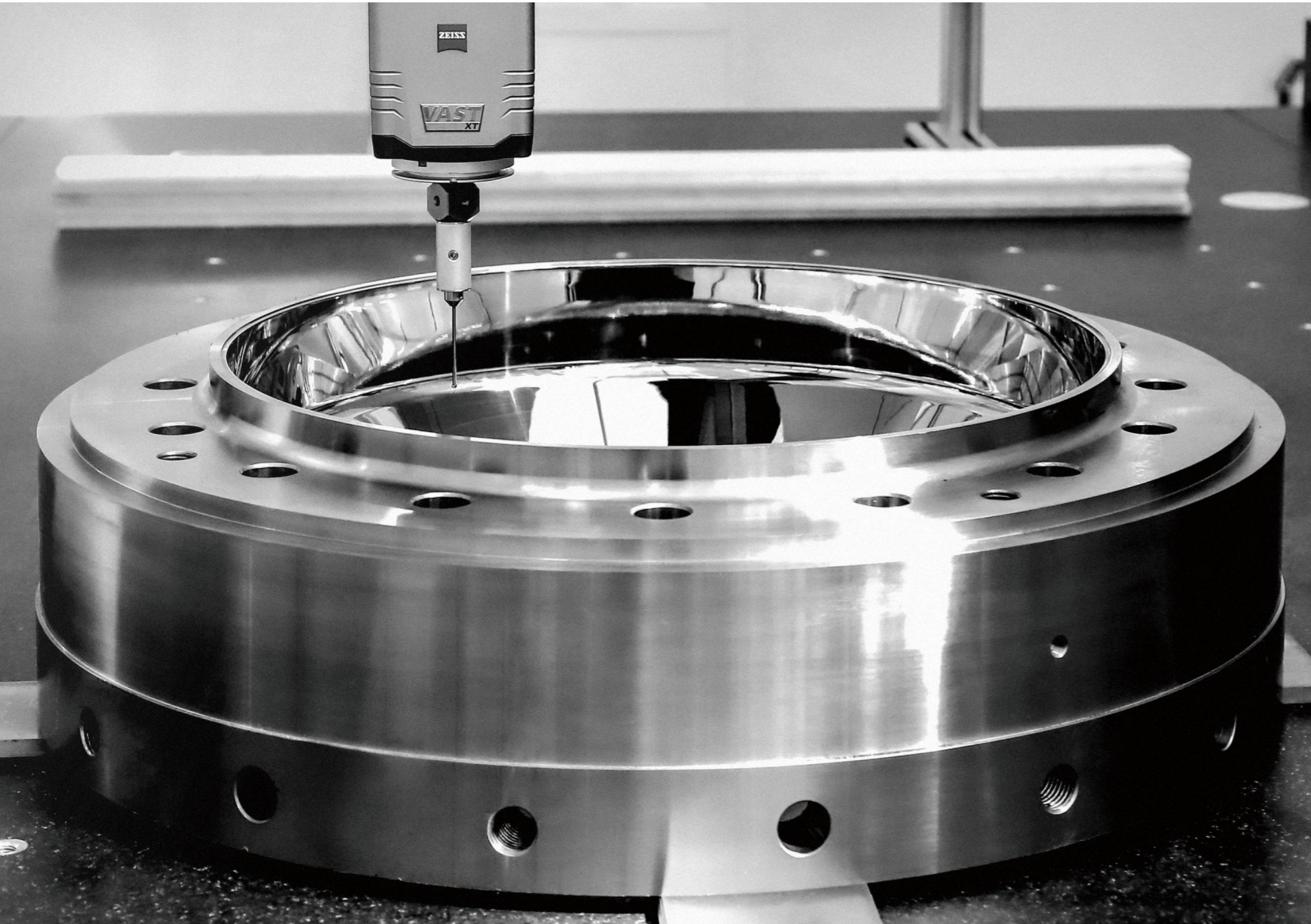
Velocity (m/s)



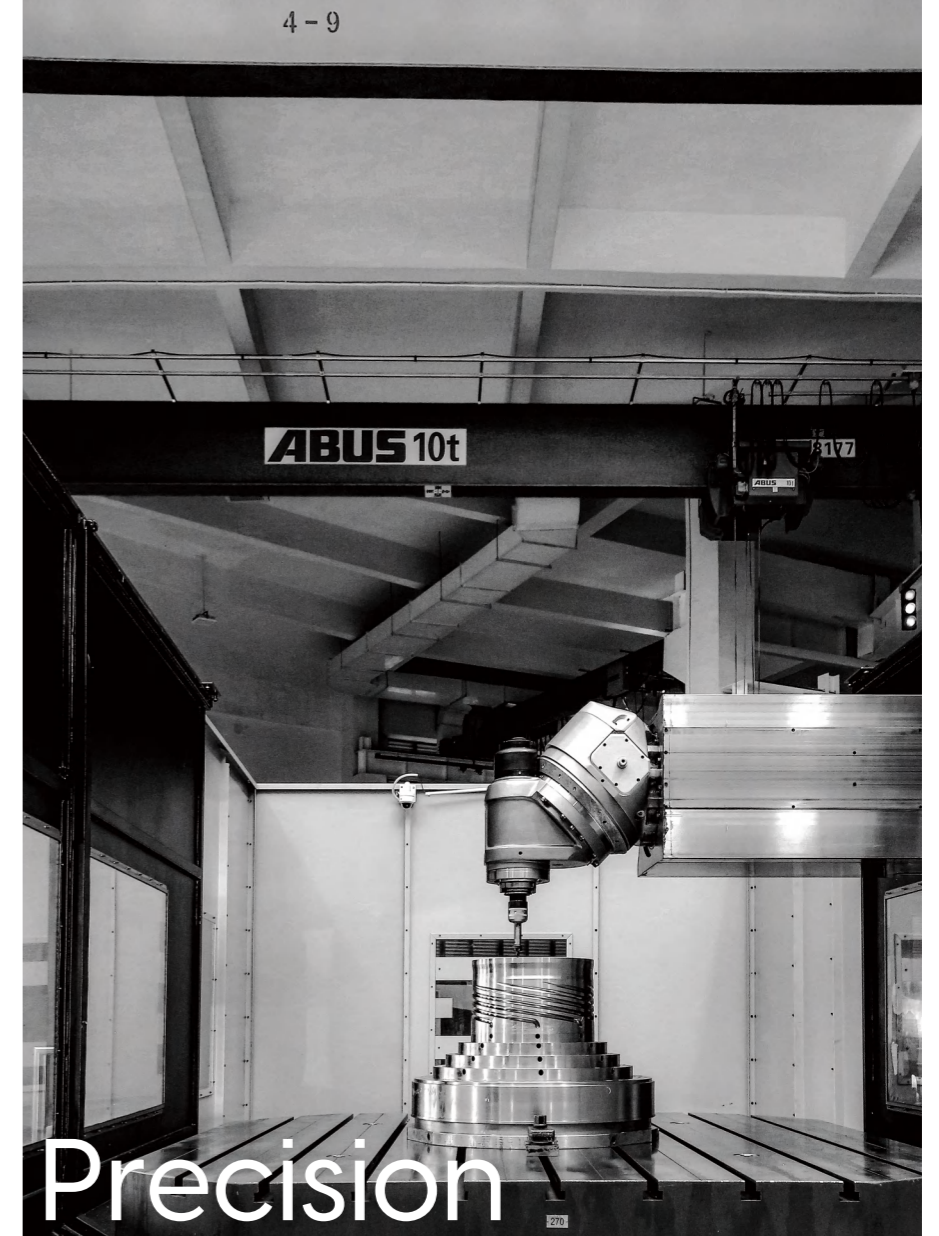
Temperature (°C)



Constant temperature and humidity
intelligent workshop,



More than thirty complex processes in six-axis high-speed machining center. Ensure the precision of each part.
Meet the needs of high production capacity while ensuring rigorous professionalism.



Precision Manufacturing

在恒温恒湿的智能化车间，
经过六轴高速加工中心、精密磨床等三十余道复杂工序。
确保了每一个零件加工的精密密度，
满足高产能需求的同时保证了严谨的专业度。



Multilayer coextrusion blown film have the advantage of high transparency, puncture resistance, high toughness. It can be used as protective films, shrink films, laminated films, shopping bags, etc. It has advantage in the field of heavy package, soft package, agriculture, etc.



多层共挤吹膜制品具有高透明、耐穿刺、高韧性等优点，可作为保护膜、收缩膜、复合膜、饮料袋、购物袋等，在重包、软包、农业等领域优势尽显。

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