



Chen Hsong Europe



# JETMASTER MK6 SERIES

88 - 668 TON TOGGLE - Injection moulding machine



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Injection moulding machine



**EUROMAP STANDARD**

Hole pattern and ejector pattern according to Euomap standards\*.  
T-slot or other pattern possible on request.

**SUPER HIGH PRECISION**

Exclusive for this MK6 range is the new proprietary servo pressure regulation technology. This unique technology ensures fast pressure relief while never reversing the pump. High precision linear transducers are used for the clamping, injection and ejector axes. All results in low-pressure mould protection.

**EUROPEAN COMPONENTS**

Standard European components:

Hydraulic valves: Bosch Rexroth

Hydraulic pump: Eckerle

Linear transducers: Gefran or Novotechnik

Electrical components: Siemens, Schneider, Telemechanique, PILZ

\*Hole pattern/ejector pattern may differ from standard due to platen design.



### PPC2200 CONTROLLER APPLICATION

The PPC2200 controller from B&R offers an integrated solution for the automation of the Chen Hsong injection moulding machines. High-speed applications and complete production cells can be implemented with B&R. The integrated Extremely Fast Control technology enables the sampling of rapidly changing input signals, allowing the injection process to be controlled with high precision. The 15.6" screen area with touch function enables a clear process visualization.

### HIGH PERFORMANCE AND VERSATILE SCREW DESIGN

More than 20 years of Japanese expertise is used for the development of the screws for this MK6 series. They are available for several process requirements (i.e. PVC screw, PC barrier screw) and for high demand mixing requirements (high mixing barrier screw).



### HIGH SPEED, SHORT CYCLE TIME

The Chen Hsong MK6 series has the fastest clamping, injection and ejection movements among competition. This results in increased production efficiency with smoother and more stable movements.



### INOVANCE SERVO DRIVE SYSTEM

The Inovance servo drive system is designed dedicated for injection moulding machines. This system provides high performance, precision, low noise and easy maintenance. For machines using this servo drive, energy saving up to 80% can be achieved

## ENERGY SAVING

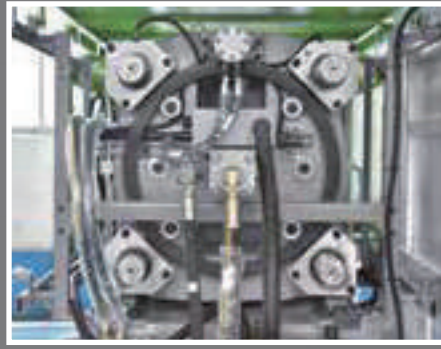
The Chen Hsong machines are equipped with speed controlled servomotors. The system pressure is measured real-time by a pressure sensor. In this way, it can provide the flow according to requirement and non-functioning consumption is eliminated. This leads to lower energy consumption, high precision, low noise and low inertia.

## STANDARD AND OPTIONAL FEATURES

CLAMPING UNIT	STANDARD	OPTION
Automatic mould height adjust	•	
Hydraulic safety device	•	
Core puller on moving platen	2	
Additional core pullers (up to 6 core pullers)		•
Airblow on fixed and moving platen	1 + 1	
Parallel core movement		•
Parallel ejector movement		•
Euromap 2 platen design *	•	
Euromap 13 for core and ejector	•	
Euromap 18 for robot mounting	•	
Euromap 67 for robot communication	•	
Euromap 70 and 70.1		•
Larger maximum mould height		•
Automatic toggle lubrication	•	
Automatic lubrication on mould height adjust		•
Anti-skid plates on horizontal surfaces	•	
Differential boost for high-speed clamping	•	
Safety door with hydraulic and electrical safety interlock protection	•	
High tensile chrome-plated tie bars	•	
Oil-less bushings for toggle system		•
Ejection-on-fly / core-pull-on-fly		•
<b>OTHERS</b>		
Up to 16 zones integrated hotrunner System (Euromap 14 standard)		•
Power sockets 3-phase 400V 32A and 16A	One each	
Power sockets 2-phase 240V 16A	2	
Waterflow regulators (more available upon request)	6 circuits	

\*Hole pattern/ejector pattern may differ from standard due to platen design.





INJECTION UNIT	STANDARD	OPTION
Ceramic heater bands	•	
Nitrated screw and barrel	•	
Bi-metallic screw and barrel		•
PET or PVC screw features		•
PVC and UPVC-specialized injection units		•
Back pressure control	•	
Barrel shut-off nozzle		•
Hydraulic/pneumatic sequential injection(up to12 valves)		•
Linear transducer on injection stroke	•	
Linear transducer on injection unit stroke	•	
Screw speed indicator	•	
Controlled feeding zone cooling	•	
Automatic PID temperature control	•	
Barrel isolation		•
Central lubrication points	•	
Anti-skid plates on horizontal surfaces	•	
Parallel plasticizing		•
Broken thermocouple detection alarm	•	
Blocked nozzle and overflow detection	•	
(Locking type) screw tip set	•	
<b>CONTROLLER</b>		
B&R PPC2200 controller	•	
15.6" HD TFT display with touch function	•	
LED backlight	•	
Free programmable cores	•	
Free I/O Configuration	•	
Sequence editor	•	
High-precision mould safety	•	
PowerLink -based Extremely Fast Control technology	•	
Ethernet interface for teleservice via internet	•	
USB interface	•	
Euromap 67 interface	•	
Industry 4.0		•
OPC-UA		•

Injection unit	Unit	JM88-MK6			JM128-MK6		
Swept Volume	cm <sup>3</sup>	136	183	238	209	271	341
Injection Weight (PS)	g	124	167	216	190	246	310
Screw Diameter	mm	31	36	41	36	41	46
Screw L/D Ratio	L/D	24.4	21.0	18.4	23.9	21.0	18.7
Injection Pressure (Max)	kgf/cm <sup>2</sup>	2,549	1,890	1,457	2,451	1,890	1,501
Injection Rate (PS)	g/s	80	108	140	104	135	170
Screw Rotation Speed(Max)	rpm	210			210		
Screw Stroke	mm	180			205		
Nozzle contact force	t	4.2			4.2		
Nozzle Stroke	mm	275			290		
<b>Clamping unit</b>							
Clamping Force (Max)	t	88			128		
Opening Stroke	mm	340			380		
Maximum Daylight	mm	720			830		
Space Between Tie Bars (HxV)	mm	360 x 360			410 x 410		
Max. Mould Thickness	mm	380			450		
Min. Mould Thickness	mm	125			150		
Ejector Stroke	mm	120			120		
Ejector Force	t	3.4			3.4		
Mould centerring diameter	mm	100			125		
Dry cycle time	s	1.7			1.8		
<b>Others</b>							
System Pressure	MPa	17.5			17.5		
Pump Motor	kW	14			17		
Electrical Heating	kW	8			10.3		
Temperature Control Zones	Zones	3 + Nozzle			3 + Nozzle		
Oil Tank Capacity	L	160			200		
Machine dimensions (LxWxH)	m	4.5 x 1.2 x 1.8			4.9 x 1.3 x 1.8		
Machine weight	t	3.3			4		

All technical data and features are subjected to change without notice.

JM168-MK6			JM208-MK6			JM258-MK6		
304	382	488	432	552	735	432	552	735
276	348	444	393	502	669	393	502	669
41	46	52	46	52	60	46	52	60
23.6	21.0	18.6	23.7	21.0	18.2	23.7	21.0	18.2
2,368	1,881	1,472	2,419	1,893	1,422	2,419	1,893	1,422
138	174	222	169	216	287	169	216	287
	185			175			175	
	230			260			260	
	6.2			6.2			6.2	
	330			380			380	
	168			208			258	
	450			510			560	
	970			1060			1140	
	470 x 470			530 x 530			580 x 580	
	520			550			580	
	170			180			190	
	140			150			150	
	4.2			6.7			6.7	
	125			160			160	
	1.9			2.1			2.4	
	175			175			175	
	22			30			30	
	12.9			16.6			16.6	
	3 + Nozzle			3 + Nozzle			3 + Nozzle	
	250			330			330	
	5.5 x 1.3 x 1.9			6.1 x 1.5 x 2.0			6.3 x 1.6 x 2.0	
	4.9			6.8			7.8	

Injection unit	Unit	JM328-MK6			JM398-MK6		
Swept Volume	cm <sup>3</sup>	947	1,181	1,480	1,322	1,657	2,029
Injection Weight (PS)	g	862	1,075	1,347	1,203	1,508	1,846
Screw Diameter	mm	60	67	75	67	75	83
Screw L/D Ratio	L/D	23.5	21.0	18.8	23.5	21.0	19.0
Injection Pressure (Max)	kgf/cm <sup>2</sup>	2,355	1,889	1,507	2,333	1,862	1,520
Injection Rate (PS)	g/s	302	376	472	351	440	539
Screw Rotation Speed (Max)	rpm	175			175		
Screw Stroke	mm	335			375		
Nozzle contact force	t	9.1			11.1		
Nozzle Stroke	mm	440			470		
<b>Clamping unit</b>							
Clamping Force (Max)	t	328			398		
Opening Stroke	mm	660			720		
Maximum Daylight	mm	1340			1450		
Space Between Tie Bars (HxV)	mm	680 x 680			730 x 730		
Max. Mould Thickness	mm	680			730		
Min. Mould Thickness	mm	225			250		
Ejector Stroke	mm	180			215		
Ejector Force	t	11.1			11.1		
Mould centerring diameter	mm	160			160		
Dry cycle time	s	2.7			3.2		
<b>Others</b>							
System Pressure	MPa	17.5			17.5		
Pump Motor	kW	48			60		
Electrical Heating	kW	26			31.1		
Temperature Control Zones	Zones	4 + Nozzle			5 + Nozzle		
Oil Tank Capacity	L	580			760		
Machine dimensions (LxWxH)	m	7.4 x 1.8 x 2.1			8.0 x 1.9 x 2.3		
Machine weight	t	13.2			16.7		

All technical data and features are subjected to change without notice.



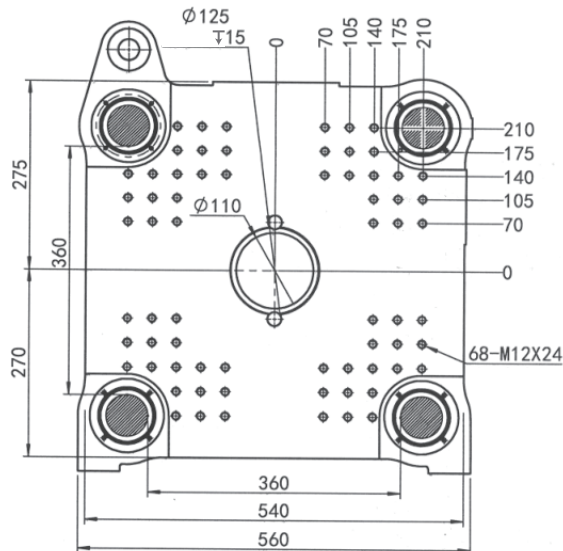
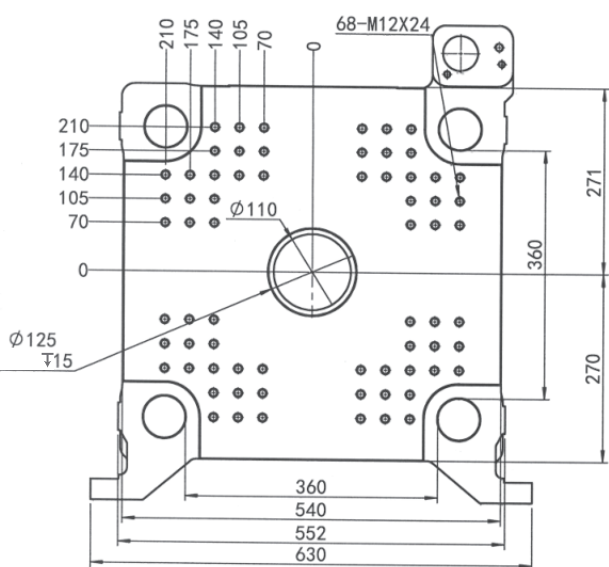
JM468-MK6			JM568-MK6			JM668-MK6		
1,833	2,245	2,640	1,833	2,245	2,640	2,300	2,704	3,206
1,668	2,043	2,403	1,668	2,043	2,403	2,093	2,460	2,917
75	83	90	75	83	90	83	90	98
23.2	21.0	19.4	23.2	21.0	19.4	23.9	22.0	20.2
2,253	1,840	1,564	2,253	1,840	1,564	2,163	1,840	1,552
442	541	636	442	541	636	540	635	753
175			175			165		
415			415			425		
11.1			12			12		
540			420			450		
468			568			668		
820			870			920		
1670			1750			1840		
830 x 830			860 x 860			920 x 920		
850			880			920		
300			350			380		
220			250			265		
16.6			16.6			18.2		
200			200			200		
3.6			3.7			4.0		
175			175			175		
72			72			96		
35.5			35.5			42		
5 + Nozzle			5 + Nozzle			5 + Nozzle		
850			850			950		
8.8 x 2.0 x 2.3			9.0 x 2.0 x 2.3			9.3 x 2.0 x 2.3		
19.8			21.5			23		

# JETMASTER-MK6

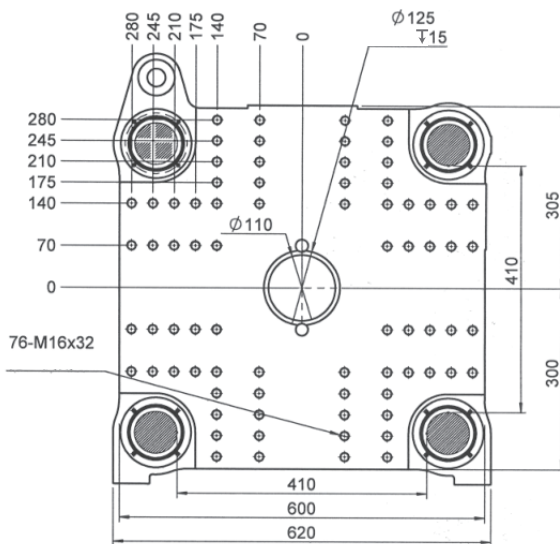
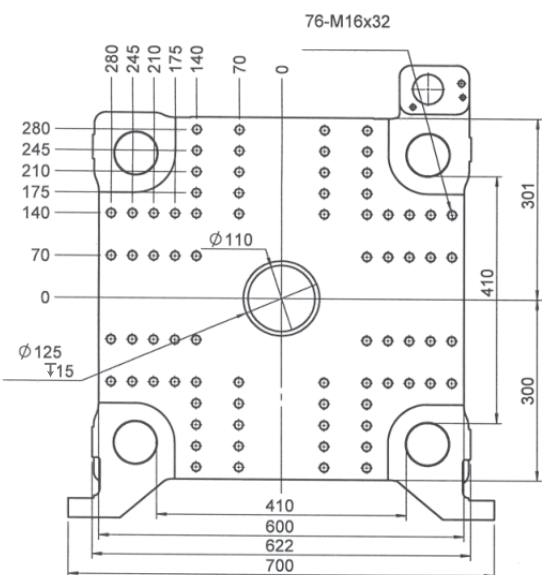
## SERIES | 88-258

### Injection moulding machine

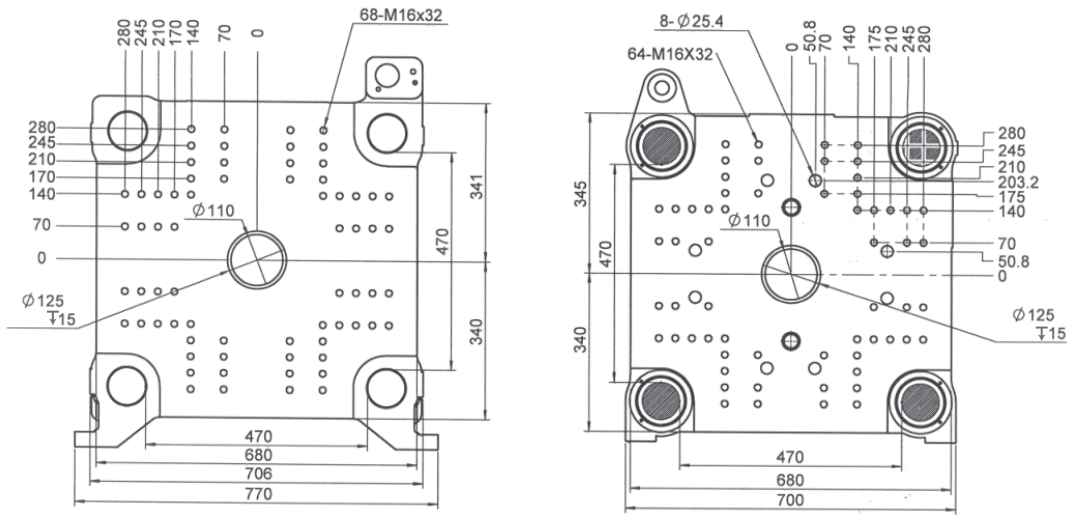
#### JM88-MK6



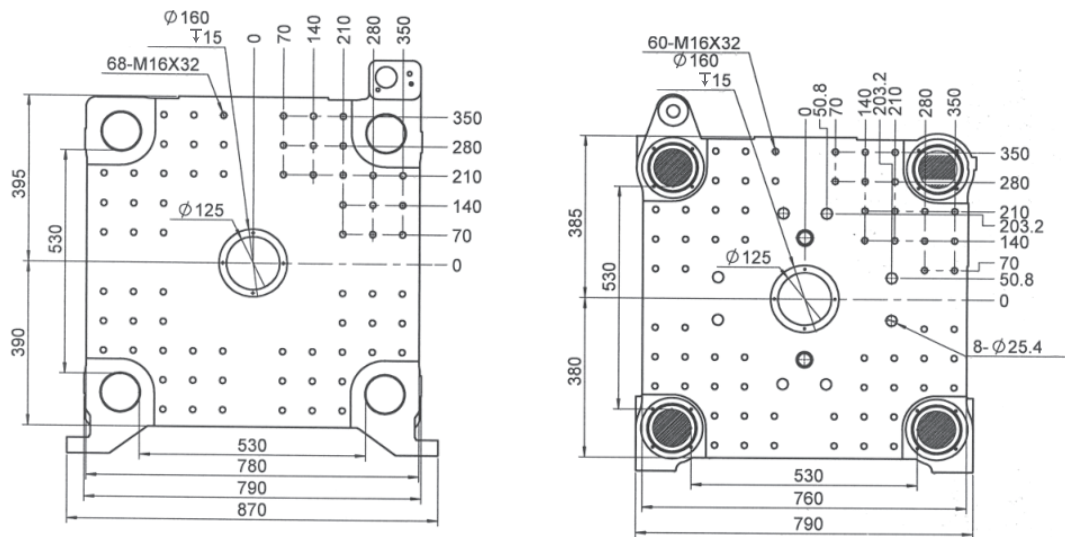
#### JM128-MK6



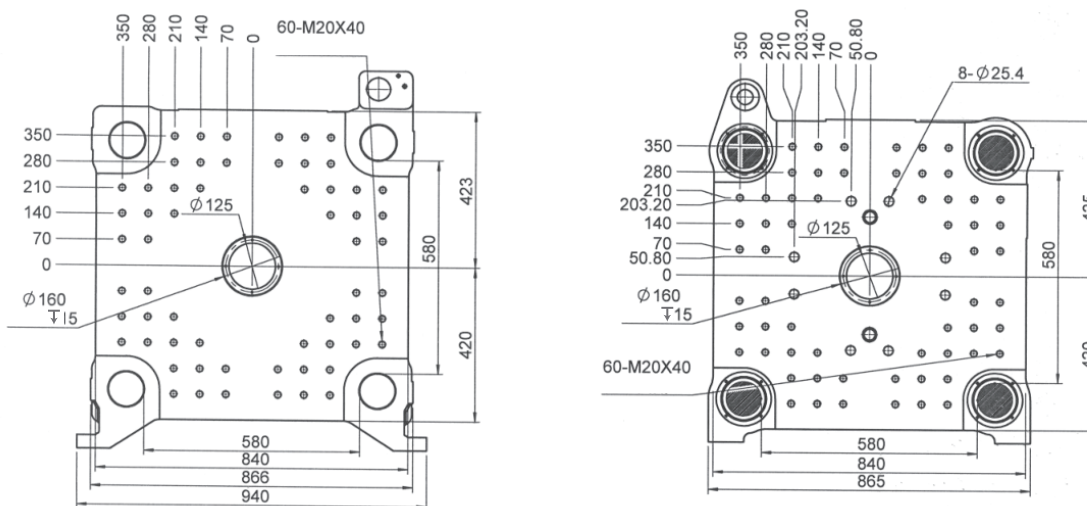
### JM168-MK6



### JM208-MK6



### JM258-MK6

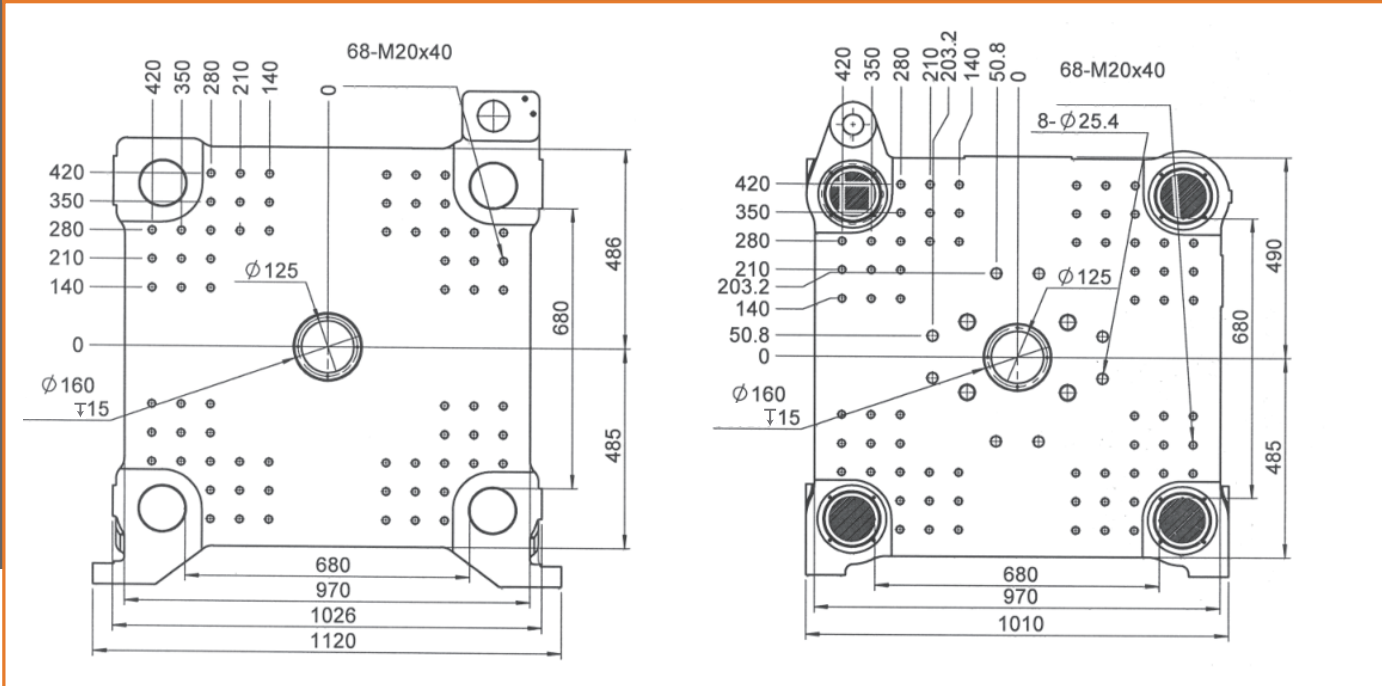


# JETMASTER-MK6

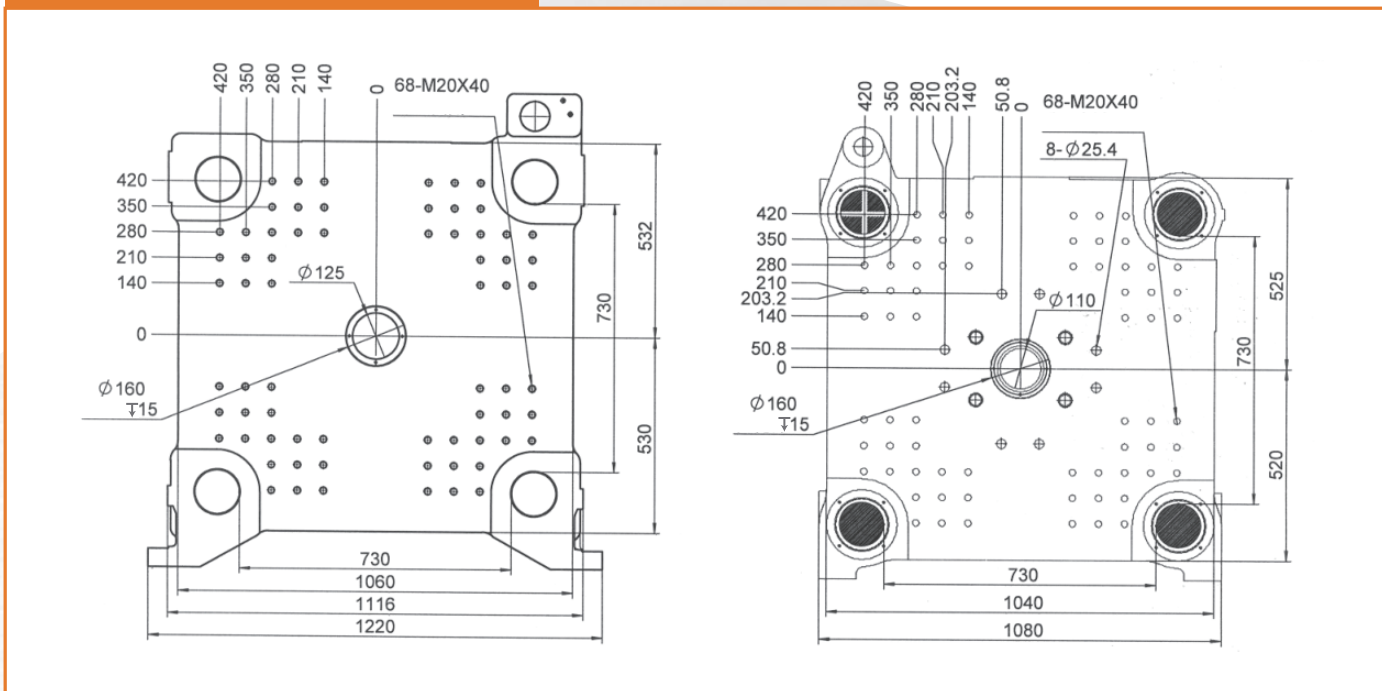
## SERIES | 328-668

Injection moulding machine

### JM328-MK6

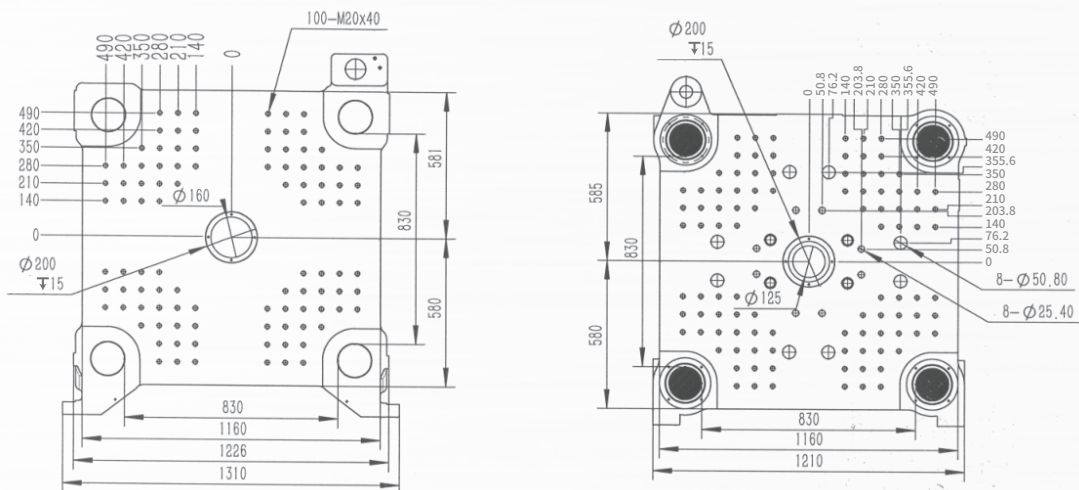


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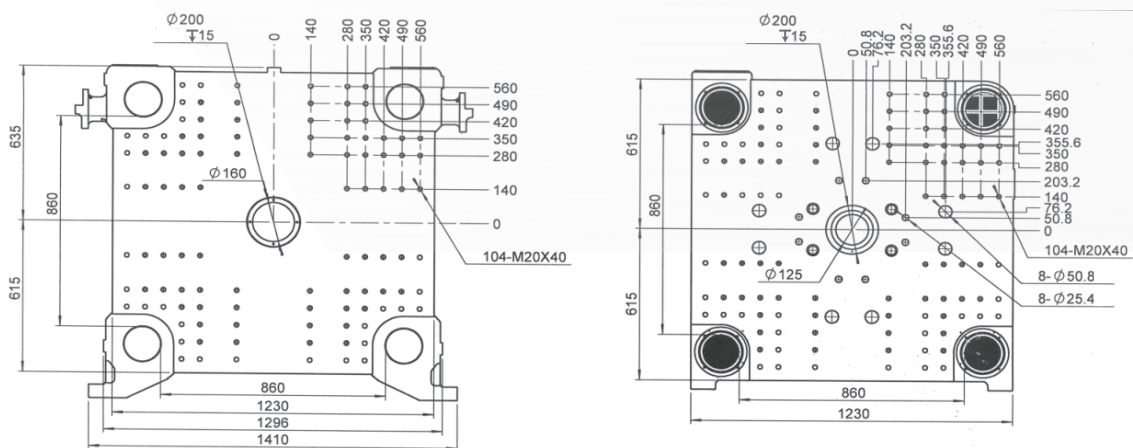




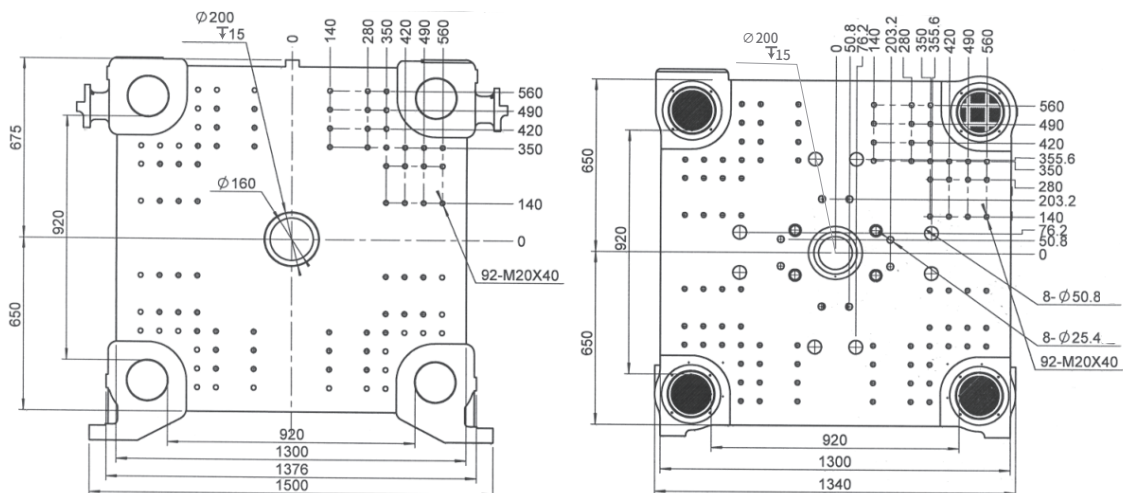
### JM468-MK6



### JM568-MK6



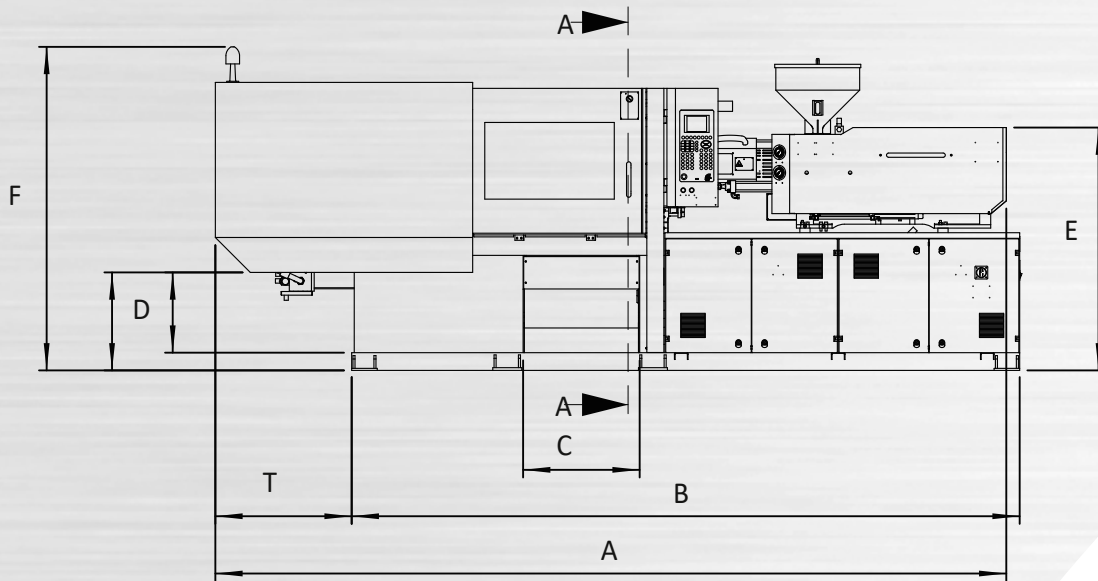
### JM668-MK6



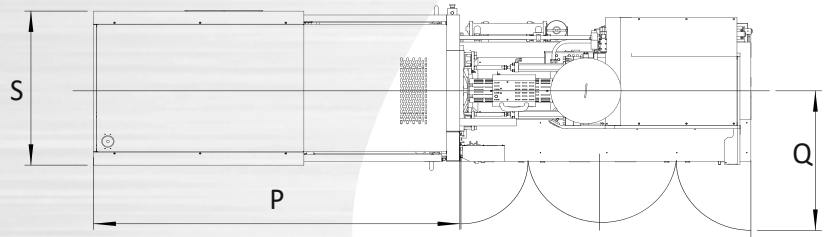
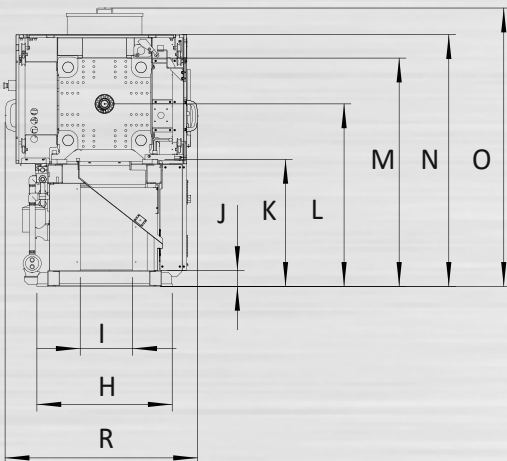


# JETMASTER-MK6 | SERIES | 88-328

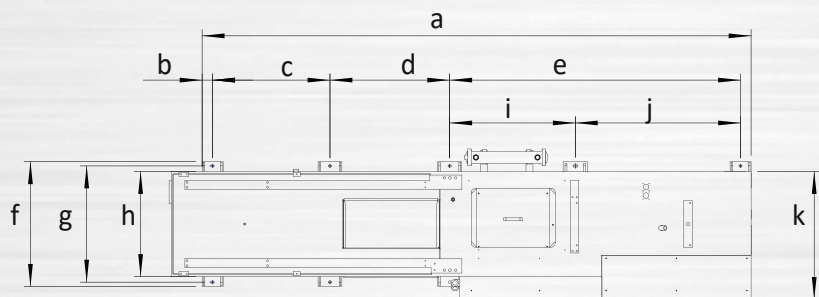
## Injection moulding machine



A-A



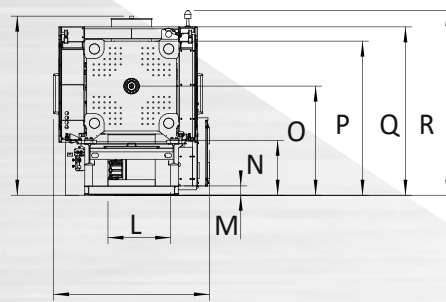
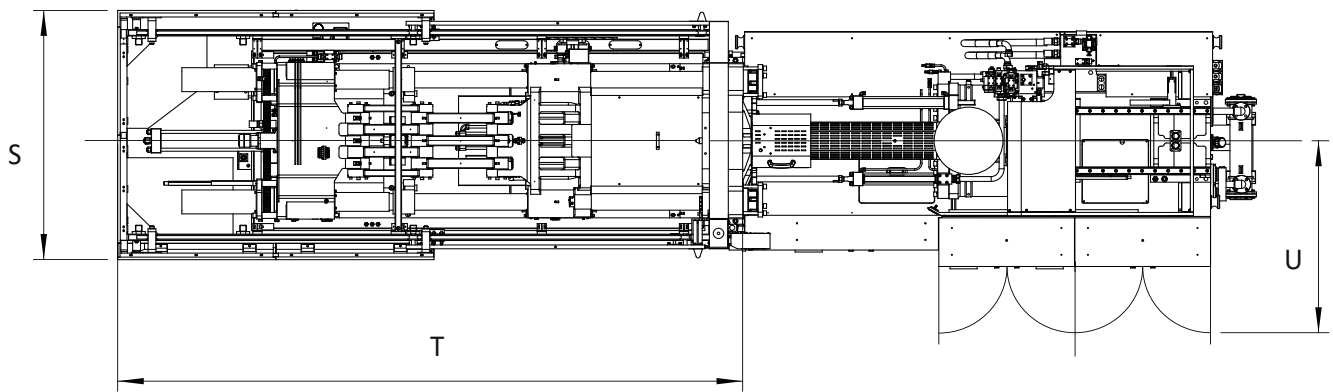
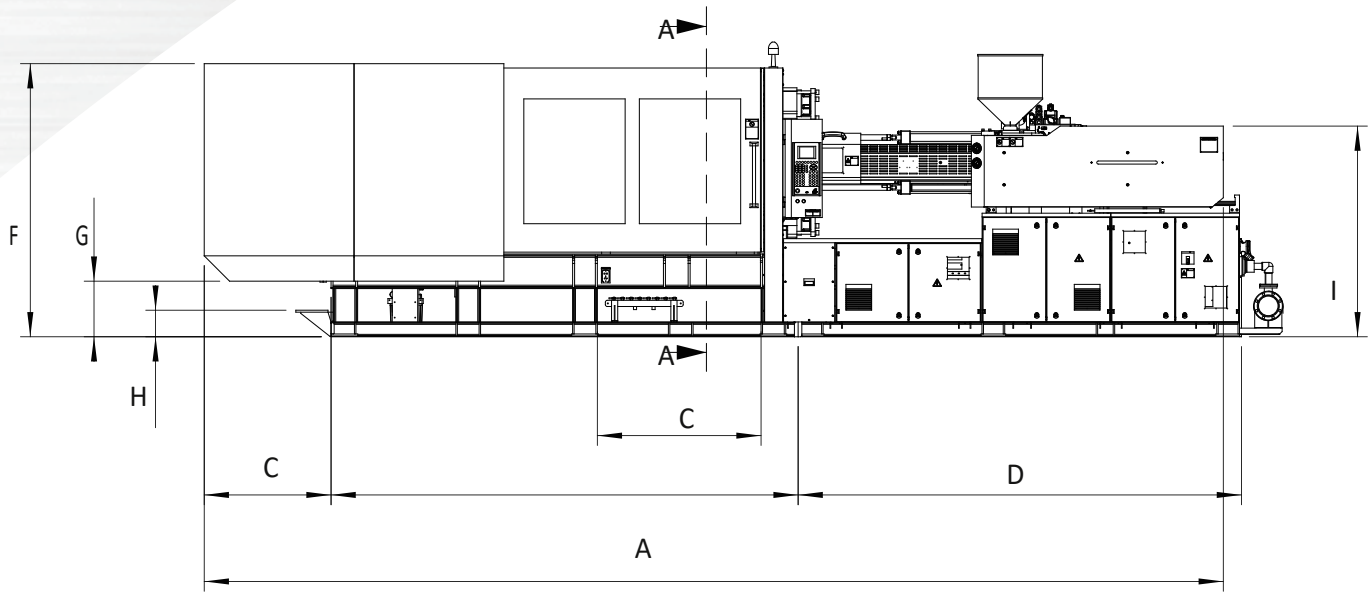
SYMBOL MODEL	JM88-MK6	JM128-MK6	JM168-MK6	JM208-MK6	JM258-MK6	JM328-MK6
A	4495.5	4972	5566.5	6221.5	6411.5	7726.5
B	3635	3920	4200	4787	4917	5940
C	547	684	770	859	859	1075
D	471	471	461	481	471	510.5
E	1385	1425	1485	1567	1612	1720
F	1833.5	1898.5	1978.5	2105.5	2198	2315
G	575	575	565	592	577	630.5
H	870	890	940	1070	1140	1370
I	360	345	395	525	595	850
J	104	104	104	106	106	120
K	835	835	835	862	862	820
L	1165	1200	1240	1317	1362	1400
M	1436	1501	1581	1712	1785	1868
N	1590	1655	1735	1862	1955	2060
O	1795	1830	1885	1967	2012	2280
P	2371	2630	2864.5	3197.5	3388	3948.5
Q	1032	1073.5	1122	1253.5	1287	1503
R	1186	1266	1301	1500	1576	1780
S	1104	1184	1219	1418	1494	1780
T	685	800	846	907	964	1098.5



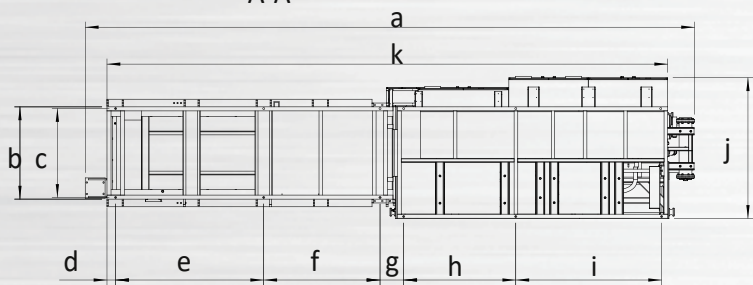
SYMBOL MODEL	a	b	c	d	e	f	g	h	i	j	k
JM88-MK6	3635	75	839	710	1936	870	810	730			906
JM128-MK6	3920	75	838	855	2077	890	830	750			916
JM168-MK6	4200	75	977.5	905	2167.5	940	880	794			966
JM208-MK6	4787	85	1111	1025		1070	1010	930	1181	1300	1096
JM258-MK6	4917	85	1265.5	1025		1140	1080	1000	1156.5	1300	1163
JM328-MK6	5940	100	1425	1250		1370	1310	1230	1635	1430	1396

# JETMASTER-MK6 | SERIES | 398-668

## Injection moulding machine



A-A



SYMBOL	JM398-MK6	JM468-MK6	JM568-MK6	JM668-MK6
A	7419	8248	7668	8682.5
B	916.5	1027	1172	1215
C	3430	3780	3515	4000
D	3272	3588	3576	3576
E	1155	1325	990.5	945
F	2144.5	2210	1981	2013
G	510.5	450	336	323
H	216	215	125	106
I	1694	1705	1624.5	1633.5
J	2280.5	2279	2116.5	2126
K	1929	2030	1918	1997.5
L	1013	810	795	840
M	120	120	125	125
N	770	710	595	595
O	1400	1410	1300	1300
P	1932	1991	1915	1950
Q	2110	2175	1948	1965
R	2335	2385	—	—
S	1857	1957	1846	1921
T	4241.5	4681.5	4955	5205
U	1435	1504	1478	1518

MODEL	a	b	c	d	e	f	g	h	i	j	k
JM398-MK6	7342	1120	1076	113	1777	1355	295	1492	1592	1825	6720
JM468-MK6	7989	1210	1166	113	1942	1525	310	1470	1912	1845	7368
JM568-MK6	7356	1284	1115	100	2325	1165	674	1527	1485	1814.5	7695
JM668-MK6	8261	1384	1250	220	1830	1782.5	791.5	1370	1502	1885.5	7576



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