

### About Us

Changzhou Longsheng Machinery Co.LTD. located in Science-tech industrial Park, Zhonglou District, Changzhou City, Specializes in making and marketing injection molding machine and its parts, with strong technical base, reliable quality. Our products are sold all over the world.

Our business principle is to offer better price based on the same quality, better quality based on the same price, better service based on the same quality and price. We consistently integrate the whole process of designing high-level quality products and creating excellent marketing closely. We offer net-working marketing with all-weather service 24 hours per day, plus lifelong afterservice. Smiling service is our characteristic service.

Ways to success, start from Longsheng, with powerful capability and prestigious brand of Longsheng Machinery Series. We produce injection molding machine with clamping force ranged from 600 to 16800KN, injection weight from 68g to 10000g. Now our products includes ordinary series, servo energy-saving series, synchronized ejection series, variable pump series, high speed series, bakelite series etc, applied extensively to auto, mechanic, chemical, electronic, daily necessities, toys and so on.

With good quality, professional service, credible credit, Longsheng will persistently work together with our customers to create our bright future through mutual benefit and win-win situation for development.

### Concept

With the keynote of creativity, the capacity of ocean's absorbing rivers, and the mind of containing the whole world, Longsheng enterprise's development is the process for constant innovation and self-surpassing.

Regarding learning as keeping us evergreen. Longsheng Enterprise advocates learning, and provides comprehensive training programme for the employees who need career development to help out them promote their ability in knowledge, knowhow as well as awareness in all aspects. Longsheng enterprise's running idea is to focus on doing everything as well as possible, which is also a request to every employee, because we believe that concentration and adherence is the prerequisite for the development of enterprise and progress of the staff.

### Company honors

Every progress of Longsheng was, is and will be linked with the care, support and love of our customers, people from different fields. Please allow me to express my cordial gratitude!

With strong strength, perfect brand of Longsheng Machinery Series, Longsheng Enterprise can produce good quality injection molding machine with clamping force ranging from 600 to 16800KN, injection weight ranging from 63g to 10000g, based on the principle of survival on the basis of quality, development on the basis of science and technology.

As long as you demand, no matter if it is large spare parts or small process units, LS series can provide you with great economic benefits starting from our first suggestion and advice.

### GB/T 19001-2008-ISO9001:2008 Standard



*Witness Great Resplendence Increase Infinite Energy*



*Customer to be topmost  
Quality to be first class  
On the basis of credit  
Constant innovation  
Practical and oriented goal*

*Aiming at the international level.  
Manufacturing credible products.  
Providing satisfactory service.  
Keeping ahead all along.*



### Optional device

#### Standard Device

Double-cylinder balance injection system  
Multi-stage pressure&speed injection  
Back pressure adjustment device  
High speed clamping  
Low pressure mold protection  
Single hydraulic core pulling and inserting  
Multiple hydraulic ejector knock-out  
Mechanical, electrical safety device  
Auto lubrication system  
Hydraulic pressure full proportional control  
All computer control system  
Molding data memory system

#### Optional Device

Double hydraulic core pulling and inserting  
Air blow  
Hydraulic unscrew device  
Hydraulic safety device  
Bimetal screw& barrel  
T slot  
Air conditioner for electric cabinet  
Servo motor energy saving system  
Variable pump energy saving system  
High speed system

#### Standard Accessory

Mechanical leveling pad  
Spare parts kit  
Tool Box  
Extended nozzle  
Mold clamps

#### Optional Accessory

Robot arm  
Hopper dryer  
Auto loader  
Plastic dehumidizer  
Mold temperature controller  
Oil temperature controller  
Oil bypass filter  
Magnetic separator  
Chiller  
Crusher

#### Remarks

Theoretical shot volume=(screw cylinder cross section) × (screw stroke)  
The injection shot weight should be 91% of the theoretical shot volume for polystyrene(ps).

#### Note

When PC(polycarbonate),PVC and other plastic material used for engineering are planned for molding ,it is necessary to inform us for special designation.  
Due to continual improvement ,specifications are subject to change without notification  
There is more detailed documentation for your availability in addition to above specification.  
The machine pictures are for your visual reference ,may have trivial difference from the actual machines.



#### CONTROL PART

It adopts imported computer for plastic injection machine, with large screen ,high definition crystal display and human-computer interface in different languages, such as Arabic, Spanish, English, Farsi, etc. Through CPU independent control and individual treatment, it has raised the running speed of the control system and alarming of successive oil temperature, thus improving the operating speed of the machine.

#### CONTROL PART

It utilizes closed-loop temperature control system to ensure the accuracy and reliability of the barrel temperature. It is also equipped with the functions of cold-proof boot, alarming and parameter memory for the molding, with password protection. The injection and switch are controlled by imported locating ruler.



The excellent chrome, molybdenum and aluminum alloy screw and barrel have undergone the nitrizing process, applicable to various plastic materials.

#### INJECTION PART

The injection cylinder (258T advanced) is parallel or balance for both sides of the barrel, so as to ensure the non-deviation of the nozzle, good sealing and non-leakage. It is equipped with double guide pillar supporting system which can inject under multifarious pressures at various speeds. It also uses one-stop hydraulic pre-injection device.



#### Screw Speed Testing Device

Rotation speed could display on the screen directly, users could consult and adjust the technical parameters.



#### HYDRAULIC PART

It adopts the imported top quality hydraulic components, proportional control for pressure and flow.

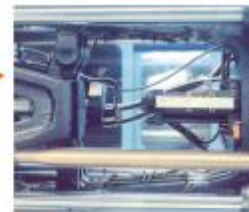


#### Moulding-adjustment part

Mold is adjusted by gear controlled by oil motor, the mold can be adjusted automatically in accordance with the setting pressure, which is both convenient and reliable.

#### MOLD PART

Five-fulcrum crankshaft structure, the mold and the bracket structured together, with good rigidity and high-fitting precision, adopting the computerized optimized design. The mold employs finite element analysis, with double pulling and inserting device. Performs the functions of super sensitive low pressure protection. The mechanical, hydraulic and electrical protections have ensured the human safety. The dismountable fill-out hopper can be installed conveniently and automatically. The moveable platen adopts a fixed durable vertical brace that is adjustable. With little friction and balanced dependable moving. Clamp opening is synchro with ejecting.



## Servo Energy-Saving Injection Molding Machine Series



High performance servo driver

Internal gear pump+servo motor



Plunger pump+servo motor

### Features

LSF-S Series injection molding machine, controlled by oil&electric compound system, is our newly developed style, it is economic, energy saving, high response and low noise. structure principle is, in real work, the system feedbacks signal of pressure and flow to high speed servo driver via rotary speed meters and pressure transducer. Servo driver then send signals to drive servo motor and oil pump, and make the pressure and flow change to realize the closed-loop for pressure and flow.

### Advantage

1. energy saving: low electricity consumption, it could save 30% electricity compared to Variable Displacement Piston Pump, Proportional Electro-Hydraulic Load Sensing Type. It is almost equivalent to all electric injection machine.
2. low noise: noises caused by the pressure controlling are reduced by great degree.
3. it could reduce cost in the long run, due to energy-saving, it brings down the running cost, it reduces the investment and maintenance cost greatly.
4. easy for operating: parameters settings. System speed adjusting is simple digit function, user just needs to operate on the control interface like on the ordinary machine.
5. high performance: high response(30ms-130ms), high stability, repetition, save energy.
6. Feature: suitable for high speed, high precision molded product, e.g: magnifier.

## Injection Molding Machine with Variable Pump Series



### Features

This series injection machine adopt high response proportional variable pump, by making output power of the hydraulic system matched with the energy consumption of machine function. It could save electricity by 30% up to 50% compared to ordinary machine. Besides, it could reduce the noise, prolong working life. Energy saving is much more significant for long molding cycle thick wall product.



## High Speed Injection Molding Machine Series Clamp opening is synchronized with ejecting



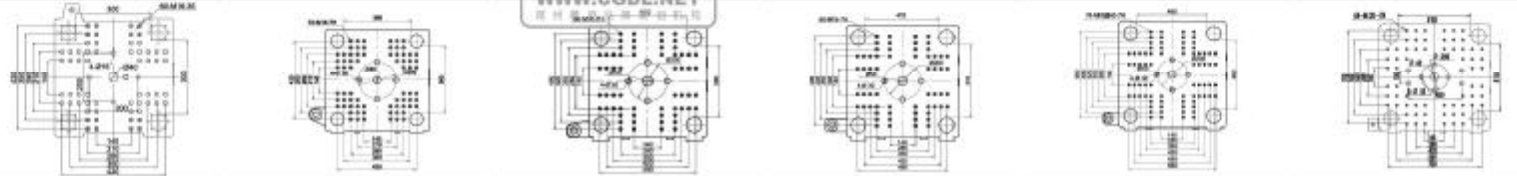
### Features

1. HP Nitrogen assisted injection system.
2. the injection speed is 2-5times faster than normal.
3. machine, specially for producing the thin wall products, such as air plane cup, food knife, spoon, fork, ice cream box, etc.
4. fast response hydraulic circuit system strong injection unit suits fast injection.

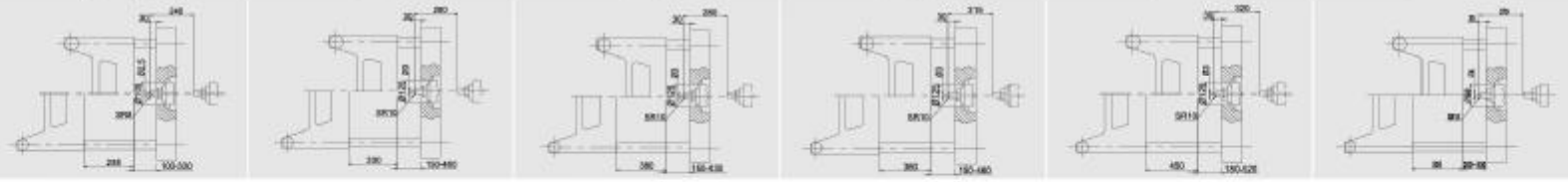
Name of item	LSF-66			LSF-96			LSF-126			LSF-146			LSF-166			LSF-206		
	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C
<b>INJECTION UNIT</b>																		
Screw Diameter (mm)	26	30	34	34	37	40	38	40	45	38	42	45	40	45	50	45	50	55
Screw L/D Ratio (L/D)	24	21	19	22.3	20.5	19	22.1	21	18.7	23.6	21.4	20	22.3	20	18.1	22.2	20	18.2
Shot size (Theoretical) (cm <sup>3</sup> )	69	92	118	154	177	207	209	232	294	221	270	310	301	381	471	381	471	569
Injection Weight (g)	62	83	107	140	161	188	191	211	267	201	246	282	274	347	428	347	428	518
Injection Rate (g/s)	60	80	103	78	92	116	105	132	160	105	132	151	124	157	194	170	210	254
Plasticizing Capacity (g/s)	6.3	8.4	10.3	12	15	17	16	20	28	16	20	24	13.6	17.8	22.7	19	23.2	28.7
Injection Pressure (Mpa)	236	177	138	232	196	168	205	185	147	235	190	167	247	196	158	229	186	154
Screw Speed (rpm)	0-220			0-210			0-200			0-200			0-190			0-190		
<b>CLAMPING UNIT</b>																		
Clamp Force (KN)	680			980			1280			1480			1680			2080		
Space Between Tie Bars (mm)	310x310			360x360			410x380			410x410			460x460			510x510		
Toggle stroke (mm)	285			330			380			380			450			500		
Max.Mold Height (mm)	330			400			430			460			520			530		
Min.Mold Height (mm)	100			150			150			150			180			200		
Ejector Stroke (mm)	70			110			130			130			140			150		
Ejector tonnage (KN)	22			33			39.6			39.6			39.6			62		
Ejector Number (P)	1			5			5			5			5			5		
<b>OTHERS</b>																		
Max.Pump Pressure (Mpa)	16			16			16			16			16			16		
Pump motor power (Kw)	7.5			11			13			13			15			18.5		
Heater Power (Kw)	5.1			6.2			7.4			7.6			9.75			14.25		
Machine Dimension (LxWxH) (m)	3.7x1.02x1.81			3.92x1.1x1.9			4.5x1.19x1.85			4.5x1.34x1.85			4.9x1.5x1.9			5.3x1.4x1.95		
Oil Tank Capacity (L)	180			200			210			230			280			380		
Machine Weight (T)	2.7			3.5			4.2			4.7			5.9			6.9		



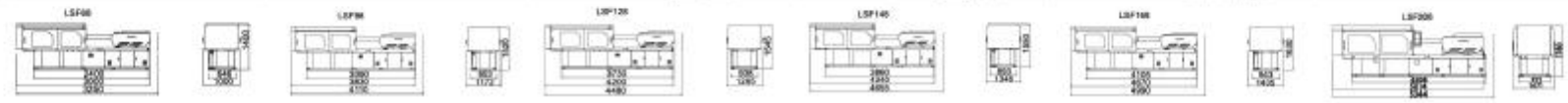
Platen Dimensions(Facing)



Platen Dimensions



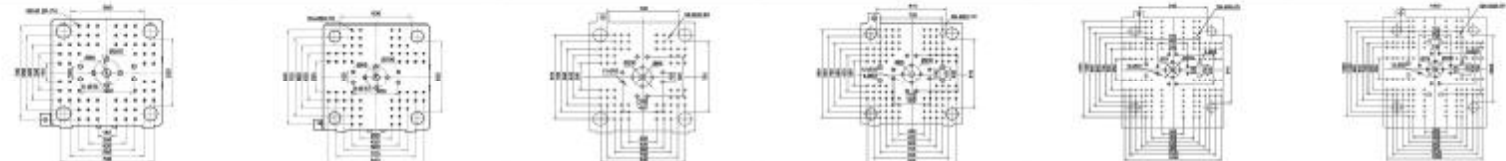
Machine Dimensions



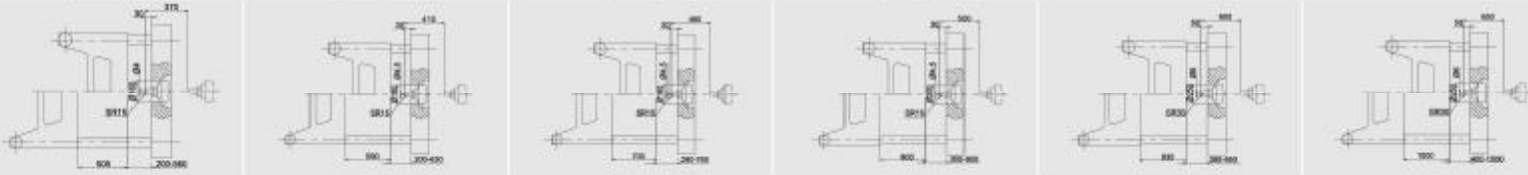
Name of item	LSF-258			LSF-308			LSF-398			LSF-528				LSF-718				LSF-880			
	A	B	C	A	B	C	A	B	C	A	B	C	D	A	B	C	D	A	B	C	D
<b>INJECTION UNIT</b>																					
Screw Diameter (mm)	50	55	60	60	65	70	70	75	80	75	80	85	90	80	90	100	110	95	105	110	120
Screw L/D Ratio (L/D)	24	21.8	20	21.6	20	18.6	21.4	20	18.8	23	21.2	20	18.9	24.8	22	19.8	18	24.3	22	21	19.2
Shot size [Theoretical] (cm <sup>3</sup> )	504	610	726	811	952	1104	1385	1590	1809	1854	2110	2382	2670	2161	2736	3377	4086	3598	4396	4825	5742
Injection Weight (g)	459	555	661	738	866	1004	1260	1447	1646	1687	1920	2167	2430	1967	2489	3073	3719	3275	4000	4390	5225
Injection Rate (g/s)	121	146	174	177	206	239	310	356	405	426	456	484	514	447	565	698	845	550	679	821	929
Plasticizing Capacity (g/s)	32	41	49	41	49	57	60	65	70	68	74	80	100	62	74.1	91.5	111	73	90.5	102.5	114
Injection Pressure (Mpa)	223	184	155	193	164	142	195	158	139	191	168	149	133	224	177	143	118	228	184	152	104
Screw Speed (rpm)	0-190			0-185			0-165			0-150				0-130				0-110			
<b>CLAMPING UNIT</b>																					
Clamp Force (KN)	2580			3080			3980			5280				7180				8800			
Space Between Tie Bars (mm)	560x530			630x630			720x720			810x810				910x910				1000x1000			
Toggle stroke (mm)	505			590			700			800				930				1000			
Max.Mold Height (mm)	560			630			760			850				950				1000			
Min.Mold Height (mm)	200			200			280			350				380				400			
Ejector Stroke (mm)	150			160			200			210				260				325			
Ejector tonnage (KN)	62			62			200			158				181				200			
Ejector Number (P)	9			9			110			17				17				21			
<b>OTHERS</b>																					
Max.Pump Pressure (Mpa)	16			16			16			16				16				16			
Pump motor power (Kw)	22			30			37			55				30+30				37+45			
Heater Power (Kw)	16			18			24.8			27.4				47.5				58.6			
Machine Dimensions (mm)	5.5x1.6x2.1			6.15x1.57x2			7.3x2.0x2.2			8.1x2.2x2.6				9.5x2.45x3.75				11.2x2.6x3.8			
Oil Tank Capacity (L)	420			640			850			1000				1400				1600			
Machine Weight (T)	7.1			10.2			16			22				38				45			



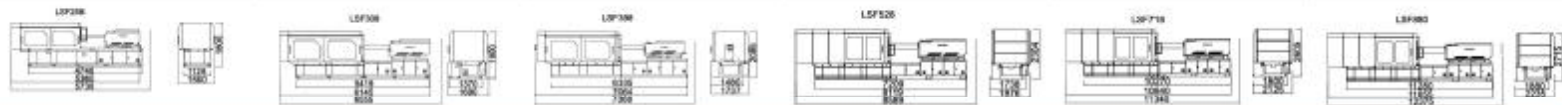
Platen Dimensions [Facing]



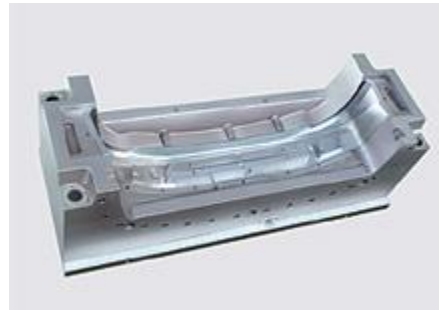
Platen Dimensions



Machine Dimensions



## Mould Products >> Various Plastic Products Molds



Auto Mold



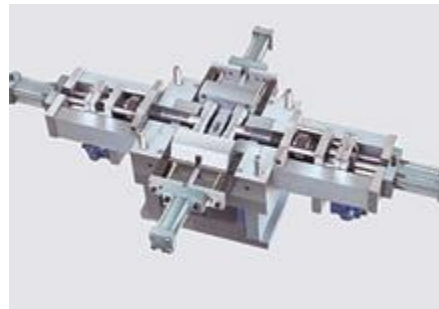
Auto Mould



Plastic Chair Molds



Chair Mould



Pipe Fittings Mold



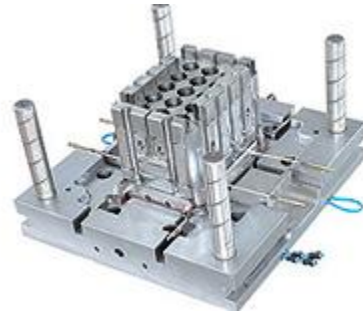
Pipe Fitting Mould



Plastic molds



Plastic moulds



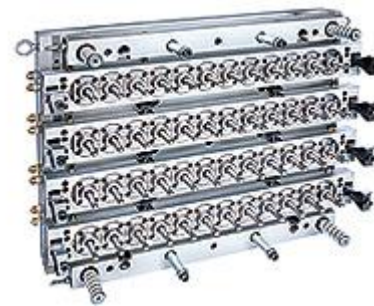
Plastic injection Mold



Plastic injection Mould



PET Preform Mold (4--48 Cavities)



PET Preform Mould (4--48 Cavities)



5 gallon bottle mould



## Products - Various plastic products



