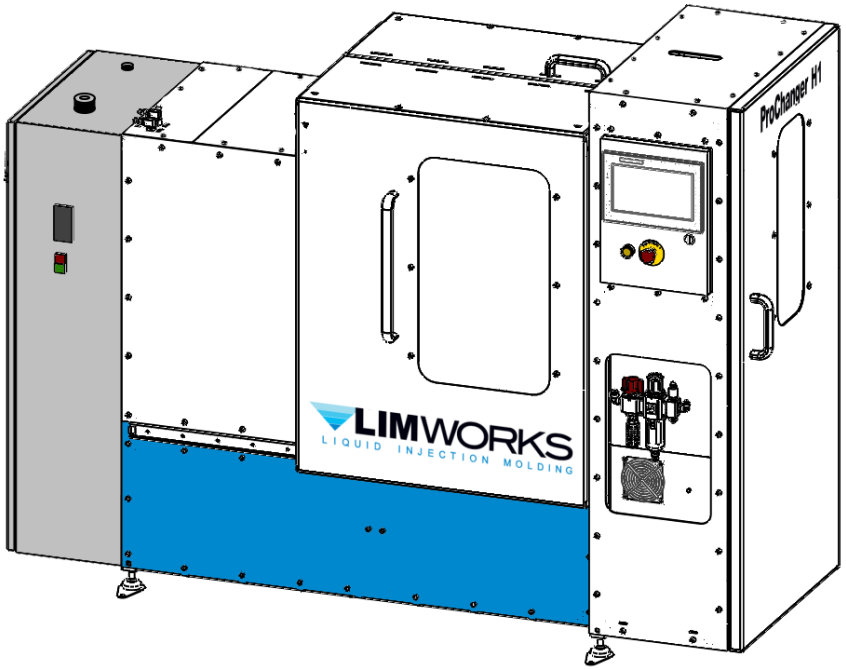
LIMWORKS
LIQUID INDUSTRIAL MANUFACTURING

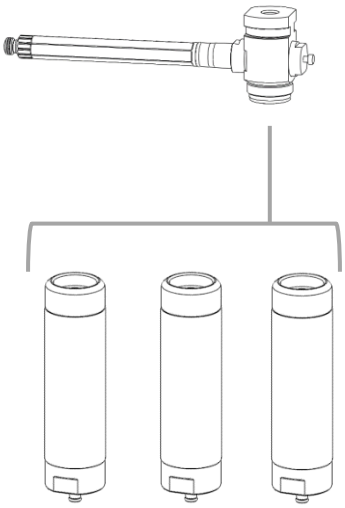
Advanced Manufacturing Equipment for Liquid Silicone Rubber

ProChanger H1 – Product Information

* Instant Material Change * Precision Servo Driven Injection * Integrated Mold Vacuum, Chiller, and Air Ejection *



Injection Module Head



Injection Module Cylinders

Horizontal Injection Molding Machine

- Injection module plunger sizes and shot volumes:
  - 10 mm Diameter, 11 cc [0.37oz] max
  - 17 mm Diameter, 30 cc [1.01oz] max
  - 28 mm Diameter, 80 cc [2.70oz] max
- Platen air/hydraulic clamp force:160 kN [18 tons] available @ 92 psi
- Servo injection force (plunger) 4.4 kN [1000 LBS] max
- Servo ejection force (platen) 4.4 kN [1000 LBS] max
- Mold heating power per platen - 3000 watts, 250VAC NEMA 6-20 receptacle
- Thermocouple feedback - type K miniature flat pin receptacle
- Power required - Single phase 200~255 VAC @ 47/63 Hz and 40 amp min
- Compressed air required - 80 psi and 10 CFM min recommended
- Daylight between platens : 18.1” max.
- Platen stroke: 11.0” max
- Distance between tie bars: 12.2” x 11.0”
- Vacuum source required to operate direct path vacuum system
- Machine Dimensions:
  - L = 2220 mm [87 3/8”] W = 844 mm [33 3/16”] H = 1578 mm [62 1/8”]

LIMWORKS, LLC
Phone +1 (833) 546-9675 - limworks.com

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Mold Liquid Silicone Rubber (LSR) with greater Precision, Ease, and Efficiency.

- **Multipurpose Machine**
  Near instant start and stop capability using premixed material and a quiet operation. Uniquely suited for single shift production, engineering product development, tool shops, R&D laboratories, LSR training, and education.
- **Accelerate Product Development**
  Fast and easy start and stop of short run injection molding tools can make parts or prove out critical details for high volume mold tool design.
- **Reduce Short Run Production Costs**
  Use a single machine to mold multiple products, materials, and colors in a shift through quick change tooling, quick change injection modules, and using premixed material cartridges.
- **Eliminate Machine Changeover Costs**
  All uncured material is contained in the injection module which can simply be removed, replaced, and cleaned off-line to eliminate the need to take machine off-line when changing materials.
- **Eliminate Machine Shut Down Costs**
  All uncured material is contained in the injection module and can be removed and stored in a freezer to eliminate the need to clean machine in-between runs.
- **Eliminate Tool Venting**
  Vacuum applied at nozzle seat extracts air through material injection path to cavity path prior to injection allowing the elimination of tool vents and related costs.
- **Precise and Repeatable Shot Control**
  Tapered seat rotary valve combined with a servo driven plunger system provides superior control and repeatability.
- **Greater Production Output & Faster Cycles**
  Integrated air ejection offers both automated part ejection strategies and can be used to assist and accelerate manual part ejection time.
- **Small Machine Footprint**
  Occupies minimal floor space, fits in laboratories, can be operated using single phase power.

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