

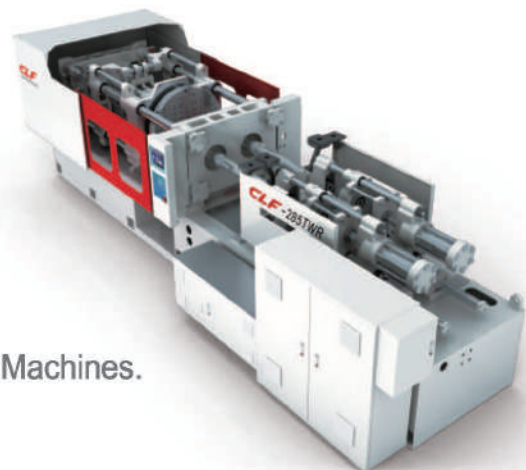
**CLF**



# TWR/TXIIR SERIES

Ratary Table / Separated Injection Multi-color  
Plastic Injection Molding Machines.

Co-injection Multi-color Plastic Injection Molding Machines.



## TWR/TXIR Series

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

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



**1** Increase Design Variations  
**DESIGN FLEXIBILITY**

**2** Avoid Secondary Processing  
**REDUCE THE COSTS**

**3** Diversified Uses of Colors and Materials  
**EMBELLISH THE APPEARANCE**

- **Increase The Flexibility Of Product Design** : Molding process can minimize the use of internal space simultaneously. In addition, it can have different applications to increase the flexibility and variations of product design. The button part is designed in a dual-material method, it can be completed simultaneously during molding, reducing the assembly processes and achieving waterproof effects.
- **Reducing Processes To Keep Costs Down** : Can be combined with two parts of different materials or colors at the same time, reducing the need for secondary processing
- **Embellish the Appearance** : With a variety of Colors and Materials, it can exquisitely enrich the core value and quality of the product.



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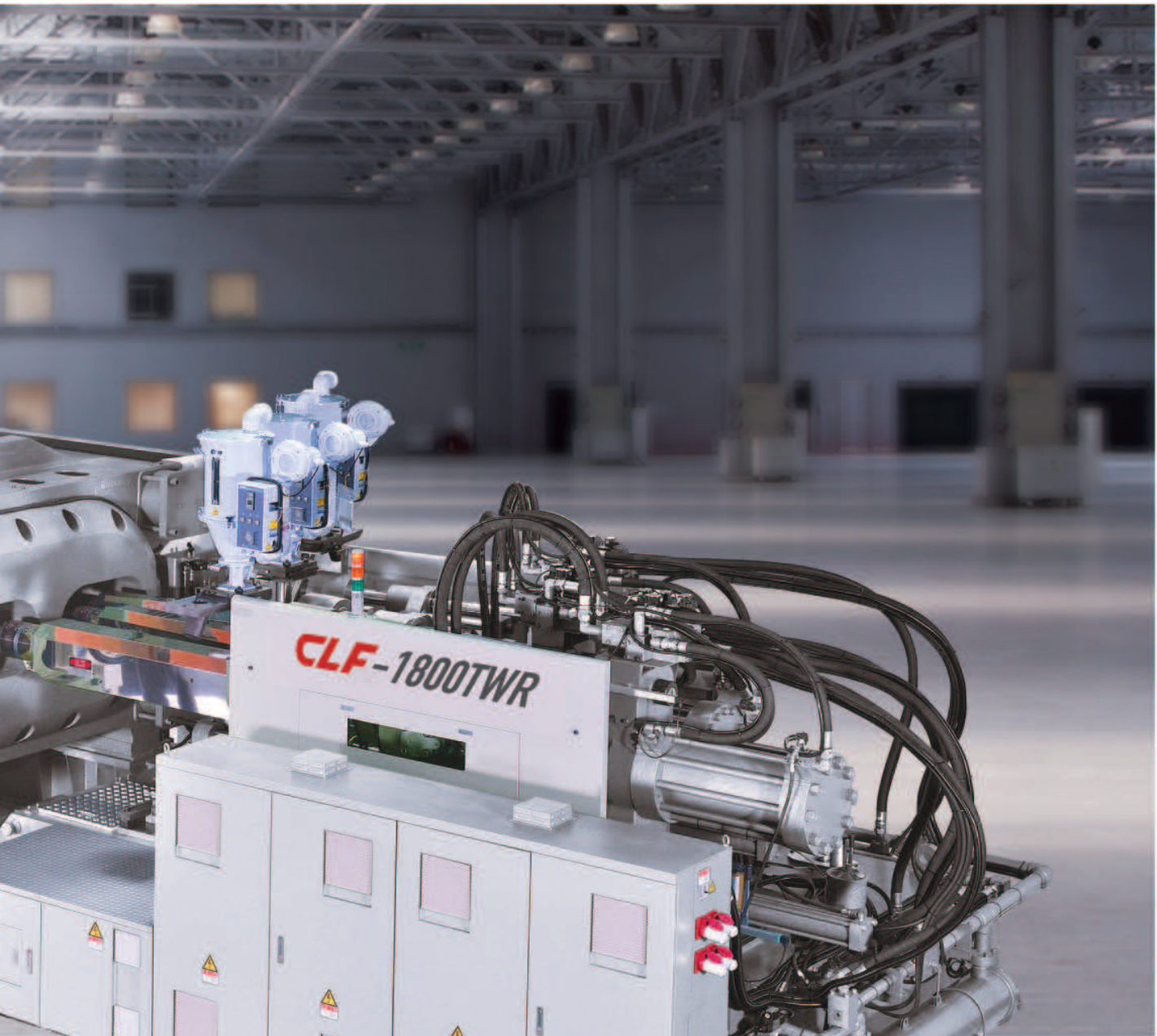


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Avoid Secondary Processing  
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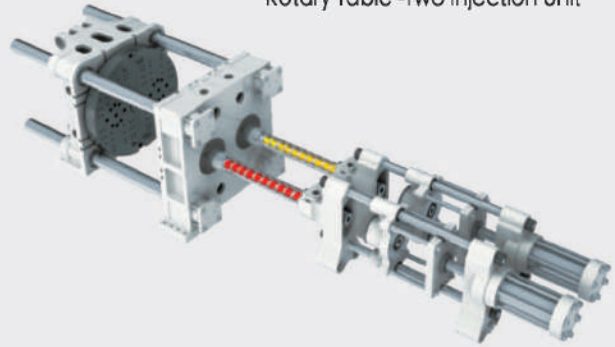
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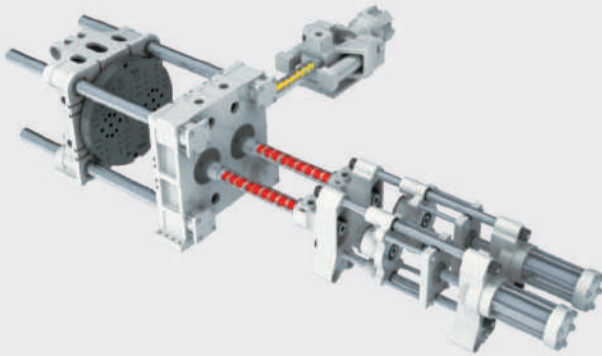
# TWR / TXIIR Series

## Rotary Table Multi-color

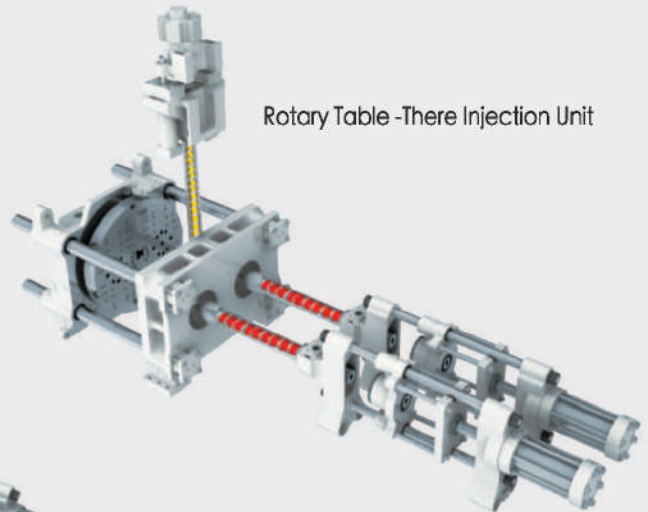
Rotary Table -Two Injection Unit



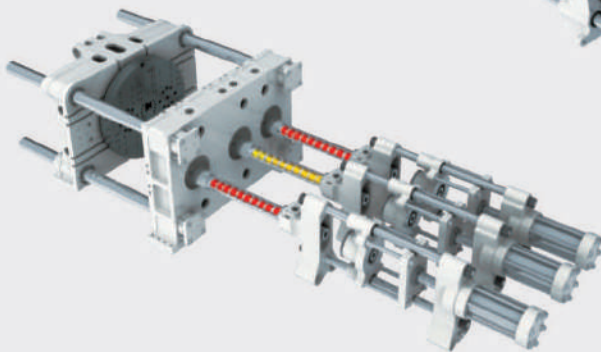
Rotary Table -Three Injection Unit



Rotary Table -Three Injection Unit

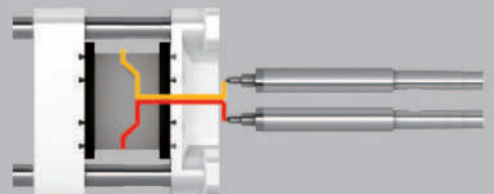


Rotary Table -Three Injection Unit



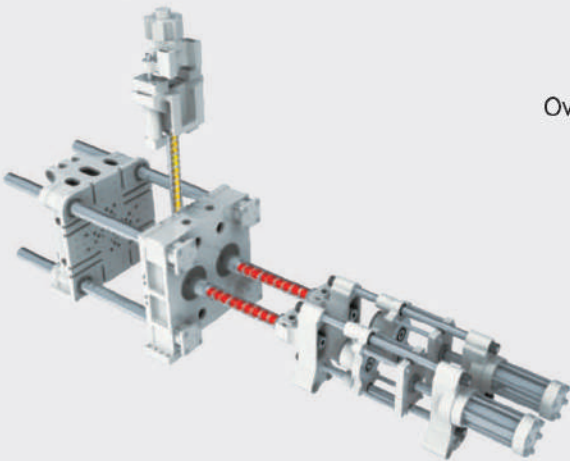
## Overmolding

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

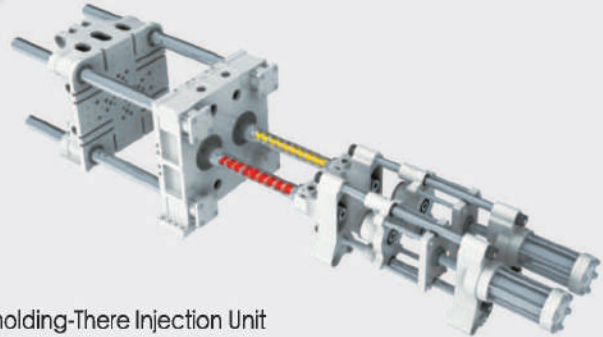


## TWR / TXIIR Series Separated Injection Multi-color

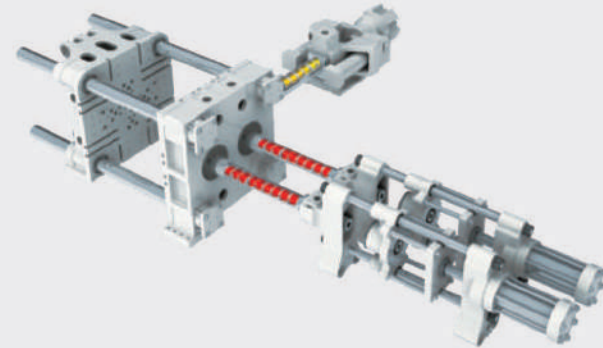
Overmolding-Two Injection Unit



Overmolding-Two Injection Unit

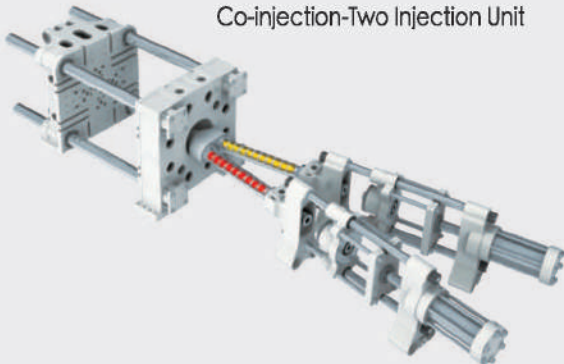


Overmolding-Three Injection Unit

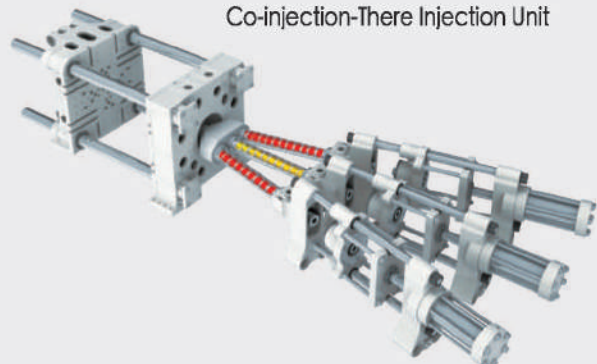


## TWR / TXIIR Series Co-injection Multi-color

Co-injection-Two Injection Unit

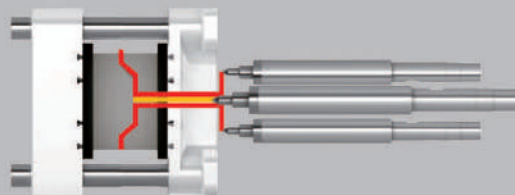


Co-injection-Three Injection Unit



### Co-injection

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



## TWR/TXIIR Series

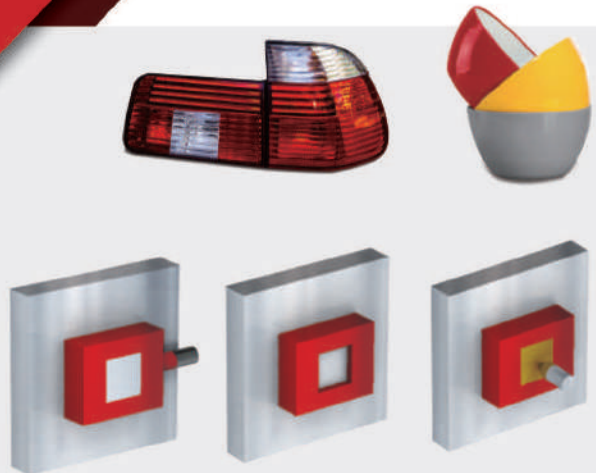
Rotary Table / Separated Injection Multi-color Plastic Injection Molding Machines.  
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# TWR / TXIIR Series Overmolding



### 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.



### 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.



### 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.



# TWR / TXIIR Series Co-Injection



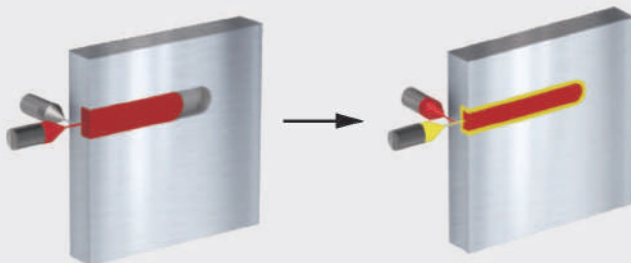
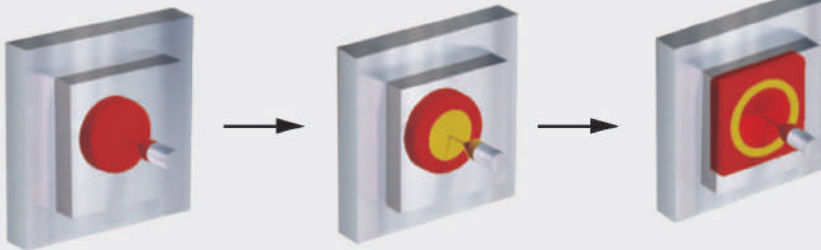
## MARBLE PATTERN INJECTION MOLDING

- This injection molding technology employs two injection units combined with a specially designed Mix 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.



## 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.



## SANDWICH INJECTION MOLDING

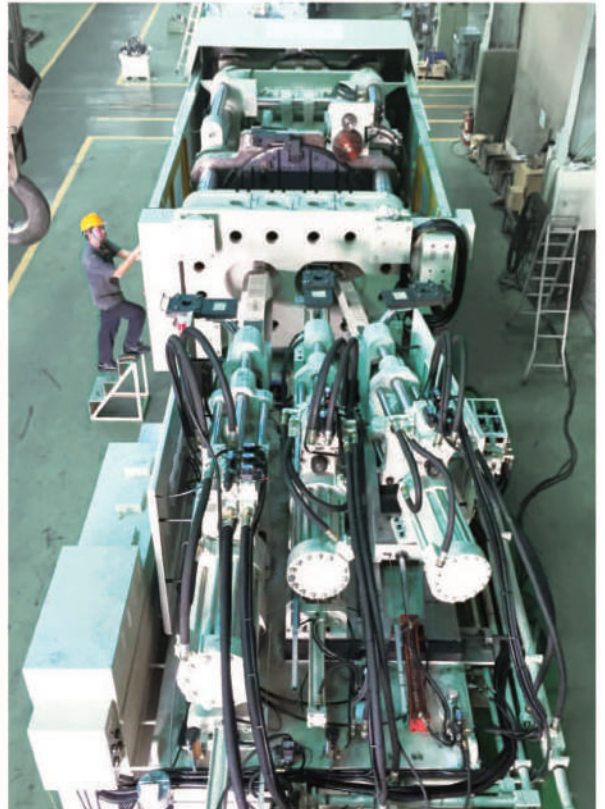
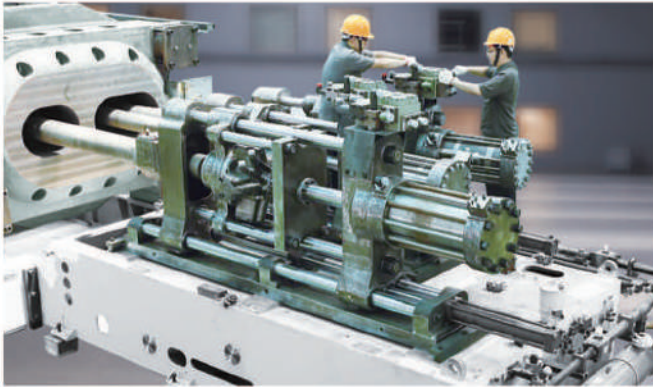
- The sandwich injection molding is a multi-layer injection molding. This injection molding technology employs two injection units combined with specially designed sandwich injection nozzle. The injection system shoots surface and core materials to achieve special layers of products. The applicable core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

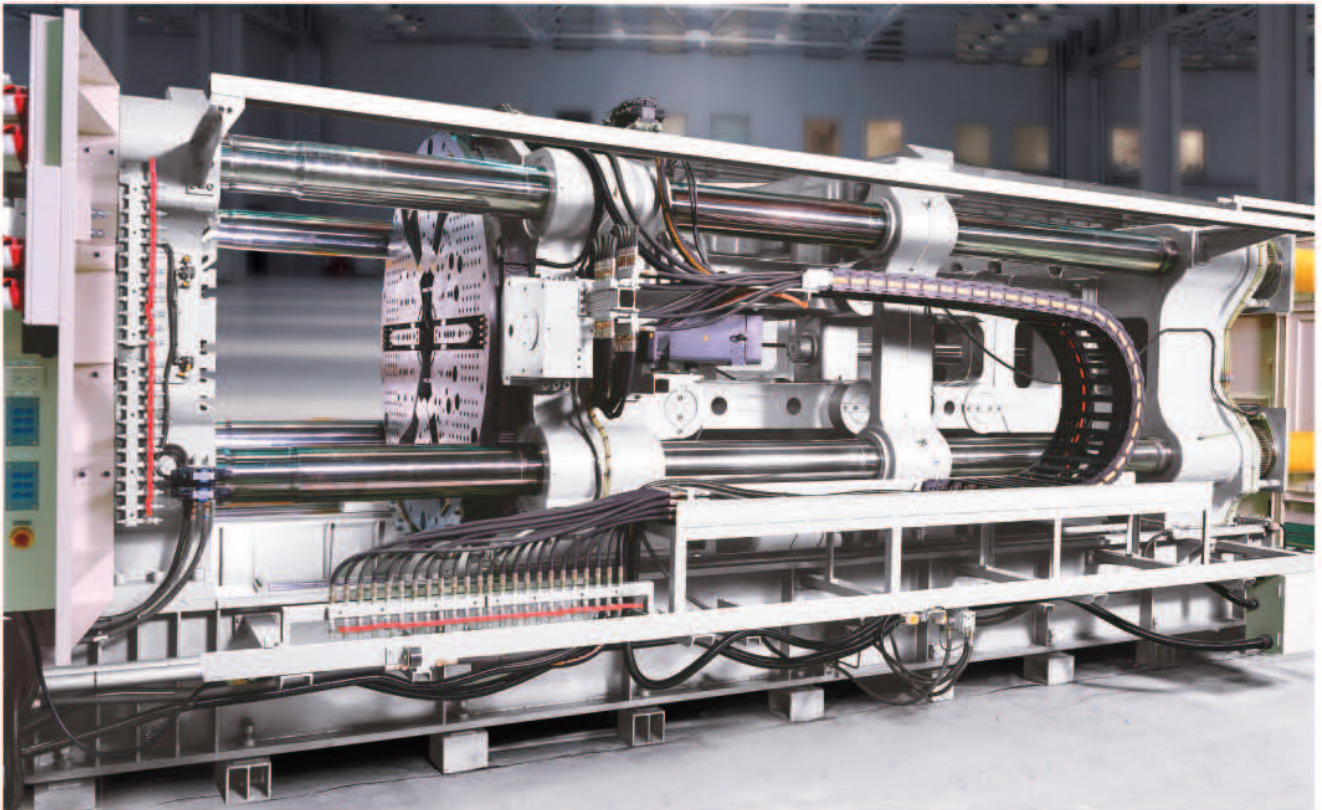
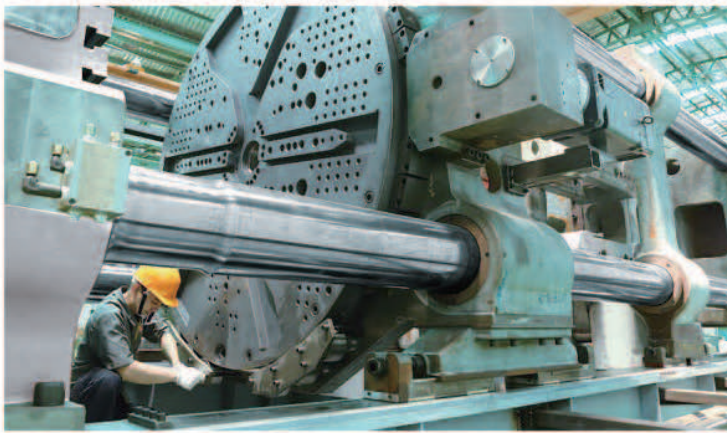
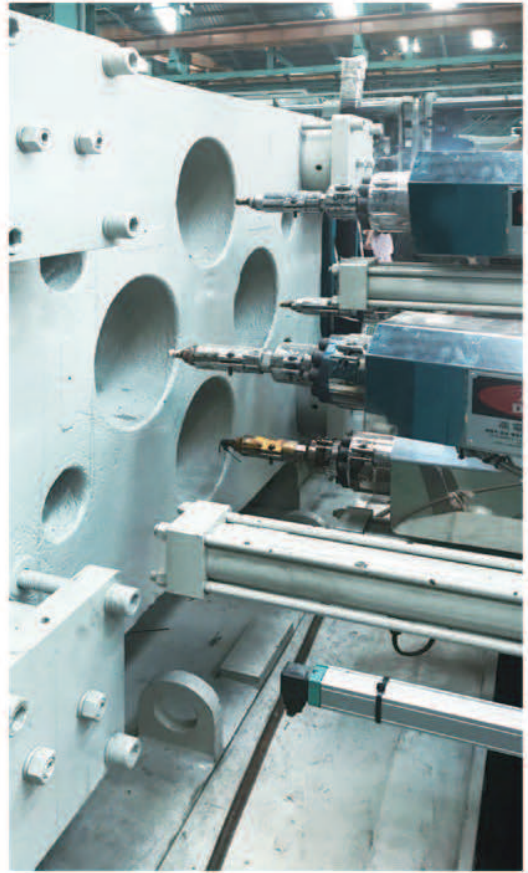
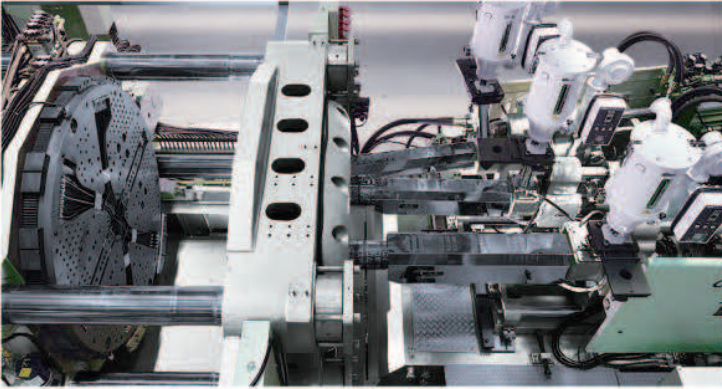
## TWR/TXIR Series

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# TECHNOLOGICAL LEADERSHIP QUALITY PRIORITY

CLF Pursues Excellence & Everlasting Innovation





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## CLF PLASTIC INJECTION MOLDING MACHINES, YOUR NO. 1 CHOICE FOR ANY INJECTION MOLDING APPLICATION

All critical parts of CLF machines such as mold platen are all machined in-house by Japanese-made and domestic high precision machine tools, such as Japan Toshiba floor type jig boring machines and Japan Kotobuki double column machining center. In addition, the hole accuracy of tie bar is also controlled in house to ensure the best running efficiency and product accuracy.





## TWR/TXIIR Series

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MACHINE MODEL		CLF-180TXIIR				CLF-230TXIIR		
International code		1800H-205/205				2300H-205/205		
INJECTION UNIT	Unit	1st. Inj. Unit		2nd. Inj. Unit		1st. Inj. Unit		
Screw diameter	mm	26	28	30	32	26	28	30
Theoretical injection volume	cm <sup>3</sup>	74	86	99	113	74	86	99
Injection pressure	kg/cm <sup>2</sup>	2817	2429	2116	1860	2817	2429	2116
Injection rate	cm <sup>3</sup> /sec	62	72	83	94	62	72	83
Shot weight (ps)	gram	68	78	90	102	68	78	90
Plasticization rate (PS)	kg/hr	18	23	30	34	18	23	30
Screw rotation	rpm	207				207		
No. of heating zones	zone	4				4		
Heating capacity	kw	3.4				3.4		
CLAMPING UNIT								
Distance between tie bars	mm	740 × 400				900 × 480		
Mold platen sizes	mm	900 × 620				1080 × 725		
Rotary table diameter	mm	780/810				950/980		
Mold opening stroke	mm	400				450		
Mold thickness	mm	120 - 550				150 - 600		
Dia. opening ring	mm	400				450		
Clamping force	ton (kn)	180				230		
Positioning ring diameter	mm	100				100		
Ejector stroke	mm	130				150		
GENERAL DATA								
Pump driving motor	kw	22				22		
Oil tank capacity	liter	310				310		
Machine size(L x W x H)	m	5.6 × 1.65 × 1.7				6.5 × 1.8 × 1.9		
Net weight	ton	7.5				11		

MACHINE MODEL		CLF-500TWR						CLF-650TWR			
International code		5000H-1470 / 1470						8500H-1470 / 1470			
INJECTION UNIT	Unit	1st. Inj. Unit			2nd. Inj. Unit			1st. Inj. Unit			
Screw diameter	mm	50	55	60	50	55	60	50	55	60	50
Theoretical injection volume	cm <sup>3</sup>	589	713	848	589	713	848	589	713	848	589
Injection pressure	kg/cm <sup>2</sup>	2469	2040	1715	2469	2040	1715	2469	2040	1715	2469
Injection rate	cm <sup>3</sup> /sec	187	226	269	187	226	269	187	226	269	187
Shot weight (ps)	gram	536	649	772	536	649	772	536	649	772	536
Screw rotation	rpm	199						199			
No. of heating zones	zone	6						6			
Heating capacity	kw	16.3						16.3			
CLAMPING UNIT											
Distance between tie bars	mm	1250 × 600						1520 × 720			
Mold platen sizes	mm	1600 × 1050						2040 × 1240			
Rotary table diameter	mm	1300						1550			
Center Distance of Injection Nozzle	mm	650						700			
Mold thickness	mm	300 - 900						350 - 1100			
Mold opening stroke	mm	1000						1100			
Clamping force	ton (kn)	500 (5000)						850 (8500)			
Positioning ring diameter	mm	125						160			
Ejector stroke	mm	190						300			
GENERAL DATA											
Pump driving motor	kw	75						75			
Oil tank capacity	liter	1250						1250			
Machine size [L x W x H]	m	9.2 × 2.5 × 2.2						9.7 × 2.7 × 2.4			
Net weight	ton	40						55			

\*All specification, dimensions and design characteristics shown in this catalogue are subject to change without notice.

		CLF-300TXIR					CLF-420TXIR							
		3000H-500/500					4200H-1345/1345							
2nd. Inj. Unit		1st. Inj. Unit			2nd. Inj. Unit		1st. Inj. Unit			2nd. Inj. Unit				
	32	30	35	40	45	45	50	55	60					
	113	141	192	251	318	477	589	713	848					
B	1860	3750	2755	2110	1687	2880	2333	1928	1620					
	94	76	103	134	170	157	194	235	280					
	102	128	175	229	289	434	536	649	772					
	34	34	46	67	100	69	90	109	129					
			236				162							
			5				6							
			7.9				15.1							
			960 × 540				1110 × 610							
			1160 × 820				1350 × 940							
			1030/1060				1180/1220							
			500				550							
			200 - 650				200 - 700							
			500				600							
			300				420							
			100				125							
			150				200							
			37				60							
			500				800							
			7 × 2 × 2				7.5 × 2.2 × 2.1							
			15				20.5							
		CLF-1200TWR					CLF-1800TWR							
		12000H-2436 / 2436					18000H-4183 / 4183							
2nd. Inj. Unit		1st. Inj. Unit			2nd. Inj. Unit		1st. Inj. Unit			2nd. Inj. Unit				
	55	60	65	70	75	65	70	75	75	80	85	75	80	85
	713	848	1095	1270	1458	1095	1270	1458	1878	2136	2412	1878	2136	2412
	2040	1715	2415	2082	1814	2415	2082	1814	2240	1968	1743	2240	1968	1743
	228	289	319	369	424	319	369	424	411	467	528	411	467	528
	649	772	996	1156	1327	996	1156	1327	1709	1944	2195	1709	1944	2195
				224							165			
				8							8			
				21.6							30			
				1720 × 820							2100 × 1000			
				2260 × 1460							2350 × 1670			
				1750							2120			
				800							1000			
				400 - 1300							500 - 1400			
				1300							1670			
				1200 [12000]							1600 [16000]			
				160							160			
				300							300			
				150							200			
				2000							2200			
				13.2 × 3.2 × 2.9							15.2 × 3.7 × 3.3			
				85							120			

[www.clf.com.tw](http://www.clf.com.tw)



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DESIGNED BY POLARIS 2020.08 / 1000PCS +886-4-24517070

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