

HTS SERIES · EXTRUSION BLOW MOLDING

# HTS-12L

Single-station extrusion blow molding for jerry cans and stackable containers.



Tongda designs and manufactures the main machine components and offers project-specific configurations. Share your bottle or part drawing to discuss the mold, head arrangement and handling requirements.

**27**

Years of industry experience

**100+**

Countries and regions served

**1,200+**

Machines and systems built per year

**10,000+**

Machines and systems supplied

The figures reproduce the published configuration of this model. Installed power is connected equipment power, not measured consumption; output depends on product, resin and cycle. Final configuration is confirmed in the quotation.

STATIONS

**Single**

MAX. VOLUME

**12 L**

CLAMPING FORCE

**158 kN**

TOTAL POWER

**73.1 kW**

## SPECIFICATIONS

| Stations                       | Single            |
|--------------------------------|-------------------|
| Max. product volume            | 12 L              |
| Dry cycle                      | 700 pc/h          |
| HDPE output                    | 110 kg/h          |
| Machine weight                 | 8,000 kg          |
| Machine dimensions (L × W × H) | 4.2 × 2.3 × 3.1 m |
| Clamping force                 | 158 kN            |
| Screw diameter                 | 80 mm             |
| Total installed power          | 73.1 kW           |
| Maximum mold size (W × H)      | 540 × 500 mm      |

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### REQUEST A QUOTATION

Send your product drawing or sample, resin, volume, weight and hourly output target.  
[tongdamachinery.com/contact](https://www.tongdamachinery.com/contact)  
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23/24

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CE

## 12L 挤出中空吹塑设备

EXTRUSION BLOW MOLDING MACHINE

| HT-12L & HTII-12L产品及模板尺寸 (mm) |                 |        |     |          |     |        |     |          |     |        |     |
|-------------------------------|-----------------|--------|-----|----------|-----|--------|-----|----------|-----|--------|-----|
| No. of cavity                 | Center distance | HT-12L |     | HTII-12L |     | HT-12L |     | HTII-12L |     | HT-12L |     |
|                               |                 | A      | B   | A        | B   | A      | B   | A        | B   | A      | B   |
| 1                             |                 | 250    | 180 | 300      | 250 | 180    | 300 | 240      | 300 | 240    | 300 |
| 2                             | 240             | 210    | 110 | 250      | 210 | 110    | 250 | 180      | 250 | 180    | 250 |
| 3                             | 160             |        |     | 130      | 90  | 220    | 120 | 220      | 120 | 220    | 120 |
| 4                             | 120             |        |     |          |     | 90     | 200 | 90       | 200 |        |     |



**HT-12L** (挤出中空吹塑设备)  
FULLY AUTOMATIC  
EXTRUSION BLOW MOLDING MACHINE



**HTS II-12L** (挤出中空吹塑设备)  
FULLY AUTOMATIC  
EXTRUSION BLOW MOLDING MACHINE

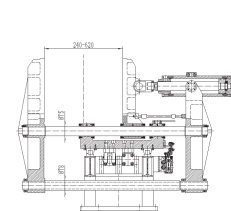


新料层 New material  
回料层 Recycled material  
粘合层 Adhesive  
阻隔层 Barrier

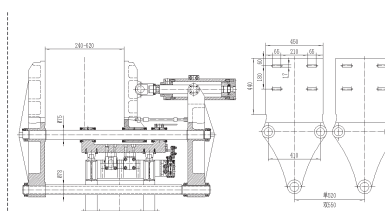


### 技术参数 TECHNICAL PARAMETER

| 项目/ITEM                                          | 单位/UNITS            | 机型/MODEL    |             |             |             |
|--------------------------------------------------|---------------------|-------------|-------------|-------------|-------------|
| 机型 Model                                         |                     | HT-12L      | HT II -12L  | HTS-12L     | HTS II -12L |
| 基本参数 Specification                               |                     |             |             |             |             |
| 工位数 Station                                      | /                   | 单Single     | 双Double     | 单Single     | 双Double     |
| 制品最大容积 Max. Product Volume                       | L                   | 12          | 12          | 12          | 12          |
| 空循环 Dry Cycle                                    | pc/h                | 700         | 700×2       | 700         | 700×2       |
| HDPE塑料挤出量 Output of HDPE                         | kg/h                | 85/110      | 130         | 110         | 130         |
| 机器重量 Weight of Machine                           | T                   | 7           | 9           | 8           | 12          |
| 机器外形尺寸 Size of Machine                           | m,L×W×H             | 4,2×2,2×3,1 | 4,5×3,0×3,2 | 4,2×2,3×3,1 | 4,3×3,0×3,2 |
| 模头 Die Head                                      |                     |             |             |             |             |
| 最大口模直径(单模头) Max. Die Diameter (Single-head)      | mm                  | 220         | 220         | 220         | 220         |
| 模头加热功率(单模头) Die Head Heating Power (Single-head) | kW                  | 9.1         | 9.1         | 9.1         | 9.1         |
| 模头加热段数(单模头) Die Head Heating Zone (Single-head)  | /                   | 3           | 3           | 3           | 3           |
| 双模头中心距 Central Distance of Double-head           | mm                  | 240/260     | 240/260     | 240/260     | 240/260     |
| 最大口模直径(双模头) Max. Die Diameter (Double-head)      | mm                  | 120         | 120         | 120         | 120         |
| 模头加热功率(双模头) Die Head Heating Power (Double-head) | kW                  | 15          | 15          | 15          | 15          |
| 模头加热段数(双模头) Die Head Heating Zone (Double-head)  | /                   | 7           | 7           | 7           | 7           |
| 开合模系统 Clamping Unit                              |                     |             |             |             |             |
| 开合模行程 Platen Distance                            | mm                  | 240-620     | 240-620     | 240-620     | 240-620     |
| 移模行程 Mold Moving Stroke                          | mm                  | 520         | 550         | 550         | 550         |
| 锁模力 Clamping Force                               | kN                  | 110         | 110         | 158         | 158         |
| 挤出系统 Extruder Unit                               |                     |             |             |             |             |
| 螺杆直径 Screw Diameter                              | mm                  | 70/80       | 90          | 80          | 90          |
| 螺杆长径比 Screw Length/Diameter Ratio                | /                   | 25:1        | 25:1        | 25:1        | 25:1        |
| 螺杆加热功率 Screw Heating Power                       | kW                  | 13.2/19     | 17.4        | 19          | 17.4        |
| 螺杆加热区段 No. of Heating Zone (Screw)               | /                   | 3/4         | 4           | 4           | 4           |
| 螺杆电机功率 Screw Motor Power                         | kW                  | 22/30       | 37          | 30          | 37          |
| 动力系统 Power Unit                                  |                     |             |             |             |             |
| 油泵电机功率 Hydraulic Pump Driving Power              | kW                  | 15          | 15          | 15          | 15          |
| 装机总功率 Total Power                                | kW                  | 59.3/73.1   | 78.5        | 73.1        | 78.5        |
| 备注 Remarks                                       |                     |             |             |             |             |
| 气体用量 Air Consumption                             | m <sup>3</sup> /min | 0.5         | 0.7         | 0.6         | 0.8         |
| 吹气压力 Blow Pressure                               | MPa                 | 0.6         | 0.6         | 0.6         | 0.6         |
| 冷却水压力 Cooling Water Pressure                     | MPa                 | 0.3         | 0.3         | 0.3         | 0.3         |
| 用水量 Water Consumption                            | L/min               | 100         | 120         | 100         | 120         |
| 模具最大尺寸 Max. Size of Mold                         | mm,W×H              | 510×500     | 540×500     | 540×500     | 540×500     |
| 模板图 Formwork Drawing                             |                     |             |             |             |             |



HTS II-12L (挤出中空吹塑设备)



HT-12L (挤出中空吹塑设备)

\*备注：以上参数仅供参考，可根据客户需求量身定制。  
Note: The parameters above are just for reference, which can be designed by your requirements.