



RHCM CONTROLLER STEAM JET

Quick **Heat** & **Cool** Mold Controller



RAPID HEAT CYCLE MOLDING

Molding systems called Rapid Heat Cycle Molding (RHCM) or Heat & Cool molding have been attracting attention from many industries as an epoch-making environmentally friendly technology that enable us to solve various problems around injection molding and to improve productivity.

The mold surface temperature is rapidly raised by compressing steam through the multiple water pipes designed near to surface of the cavity. It is then cooled down rapidly by cooling water. By using specially designed high thermal conductive rapid heat cycle mold (3D weldless mold), it is not only possible to prevent weld lines or sink marks in any configuration of molded parts, but also to offer innovative solutions to difficult problems that used to be impossible to overcome.

For more information, please visit

Model : RHCM-100G



<http://3d-weldless.com/>



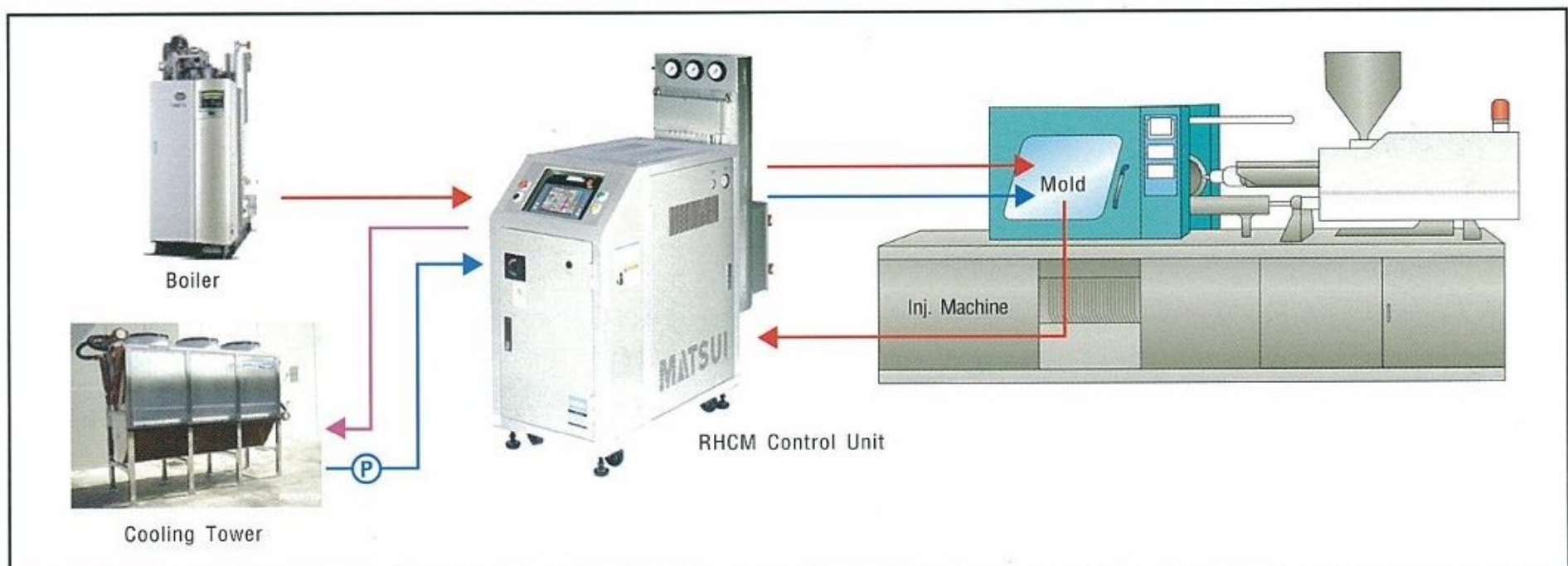
<http://www.onosg.co.jp/>

New structure pursuit of high-response, high-cycle completely



- Adopt new control valve
- Unify manifold with control valve
- From the possibility of divided set up manifold unit (option), even divided set up after variance of layout rise, it will have no effect on heating cycle.
- Mold will be heated by high efficiency because steam will be supplied to manifold directly.

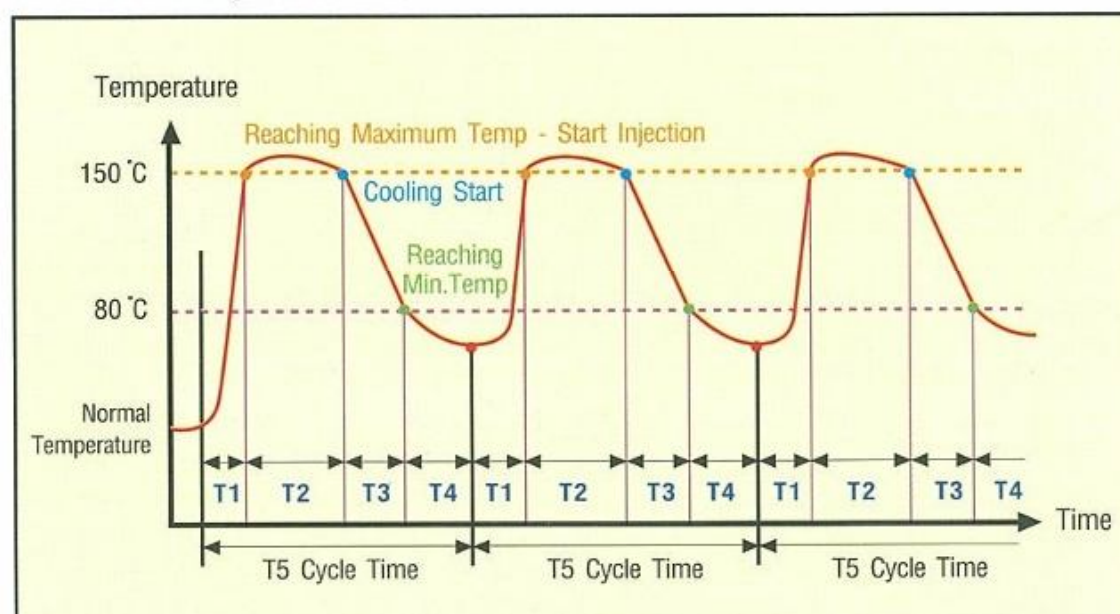
Steam JET System Flow Sheet



Heat source for heating is steam which will be supplied from boiler and use to rise mold temperature until temperature higher than the softening point of resin in short time. After mold heating complete, resin will be injected to mold. After injection complete, mold will be cooled down quickly by water from cooling tower. Then, product will be took out. Please find out the application of the special mold for weldless injection molding.

Steam JET System Time Chart

Heat&Cool Cycle Chart



- T1 = Heating time
- T2 = Injection holding pressure time (FILL/PACK)
- T3 = Cooling time (COOLING)
- T4 = Take out time (EJECT)
- T5 = Cycle time

▲ Standard running sequence of the device

Controller



Touch panel (Buil-in)

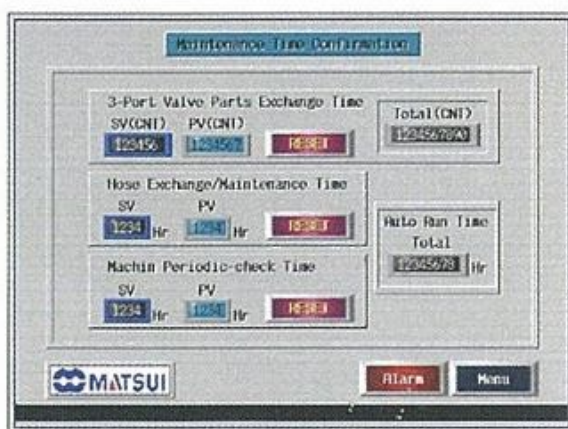
- Model 7.5 Using TFT Panel VGA Display.



Support remote-mobi control panel (Option)

- The operation ability is unaffected on body install area.
- Compact and would be able to installed everywhere.
- Dedicated adapter.

Operation screen

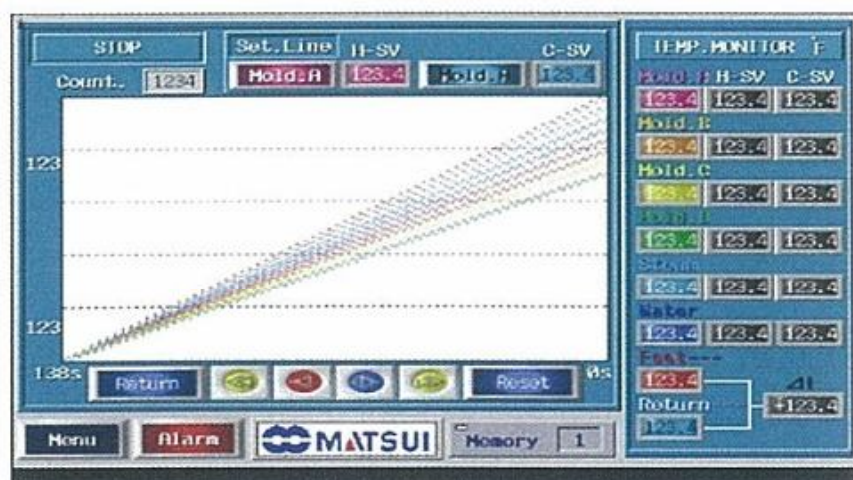
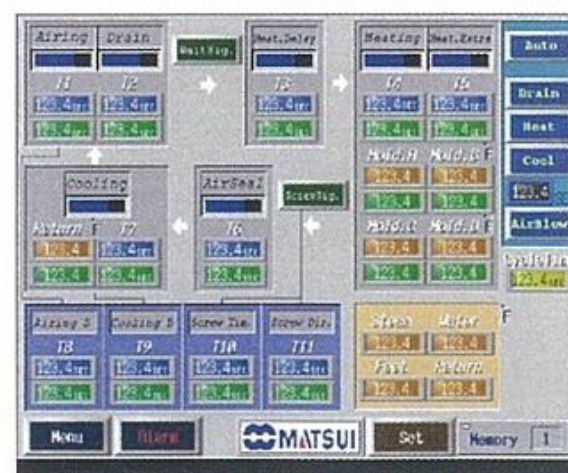
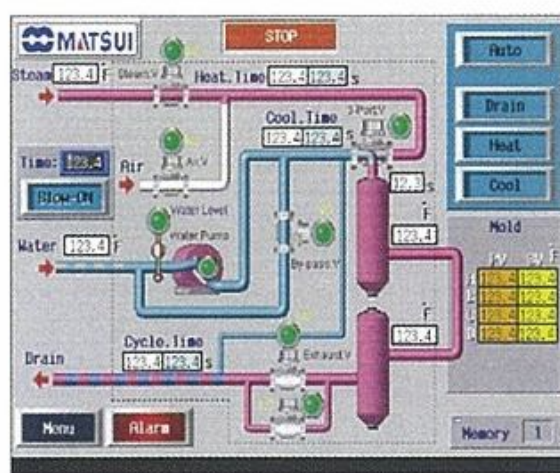


Setting screen

- Setup working of machine such as heating, cooling etc.
- Heating and cooling conversion is possible to set at both of temperature and timer.
- Memory can be made maximum at the condition of 10 mold.
- Show maintenance timing setting.

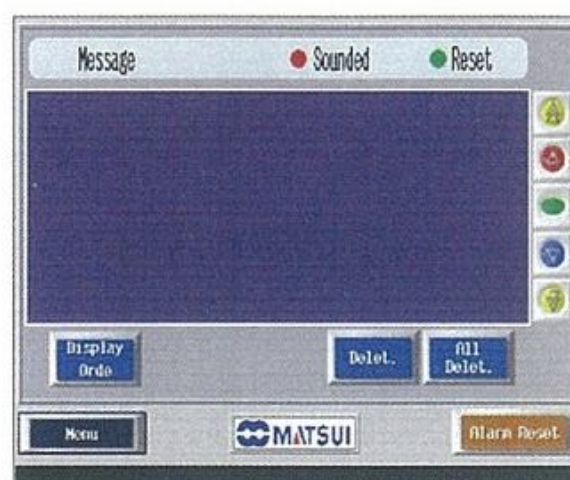
Operating monitor screen

- Main setting temperature Actual temperature Display.
- Present working conditions such as heating, cooling etc confirmation.
- Temperature display switching °C to °F is possible.



Temperature monitor screen

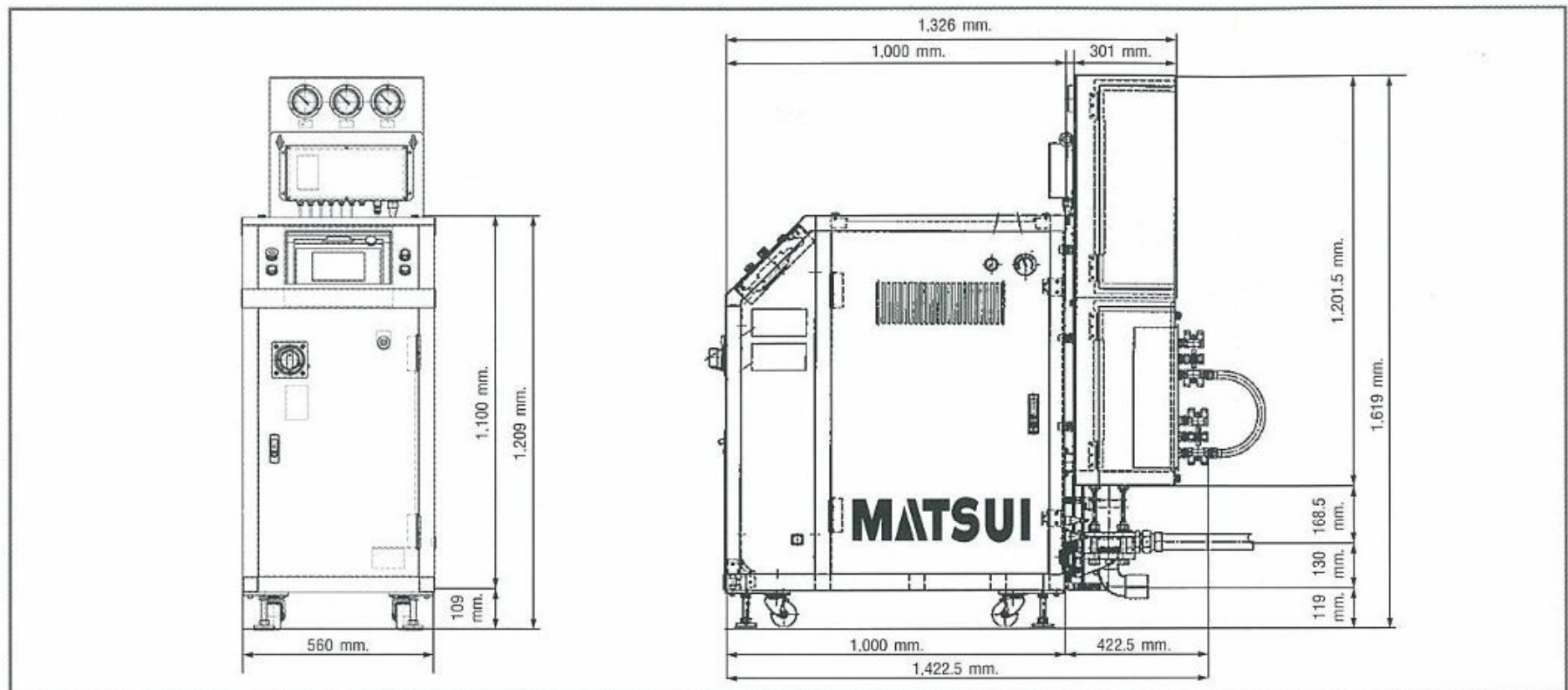
- Detected temperature of each sensor running and display graph on monitor screen.



Alarm display screen

- Alarm display at the lowest step of each screen.
- On the alarm screen, call occurrence time and content of record for confirmation are possible.

Outer Dimension



Standard Specification

MODEL		RHCM-100G	
Utilities	Electric Power	AC 380V 3P	AC 200V 3P
	Breaker	20A	40A
	Steam	180°C MAX	
	Cooling Water	lower than 35°C	
	Air	0.5~0.7Mpa	
Pump	Output	4Kw	
	Flow rate	200ℓ/min at 0.4Mpa	
Size	Body	W 560 x D1000 x H1209 mm.	
	Manifold	W 560 x D395 x H1619 mm.	
Connection Diameter	Medium Feed	15A (1/2B) 12 Ports	
	Medium Return	15A (1/2B) 12 Ports	
	Steam Inlet	25A	
	Cooling Inlet, Outlet	40A	
	Weight	335kg	

New Cooling Water Circulation System "ecobrid System"



New Cooling water circulation system

- Cooling method dried cooling method.
- Characteristics Heat Exchanger, prevent scale sticking on to piping circulation of clean water economize on water for cooling at the lowest consumption maintain the stable cooling efficiency.

DISTRIBUTOR

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