

## JSW THE JAPAN STEEL WORKS, LTD.

URL <http://www.jsw.co.jp/>

Division Gate City Ohsaki-West Tower, 11-1, Osaki 1-chome, Shinagawa-ku,  
Head Quarter: Tokyo 141-0032, Japan  
Phone: +81-3-5745-2081 Fax: +81-3-5745-2083~84  
URL [http://www.jsw.co.jp/inj\\_f/inj\\_index.htm](http://www.jsw.co.jp/inj_f/inj_index.htm)

### JSW Plastics Machinery Inc.

Head Office: 555 South Promenade Ave., Unit 104, Corona, California 92879, U.S.A.  
Phone: +1-951-898-0934 Fax: +1-951-898-0944  
Chicago Office: 540 Capital Drive, Suite 130, Lake Zurich, Illinois 60047, U.S.A.  
Phone: +1-847-550-0704 Fax: +1-847-550-0725  
Detroit Office: 24301 Catherine Industrial Drive, Unit 118, Novi, Michigan 48375, U.S.A.  
Phone: +1-248-449-5422 Fax: +1-248-449-6018

### JSW Plastics Machinery (S) Pte Ltd

Head Office: 17, Gul Lane, Jurong Town, Singapore 629413, Republic of Singapore  
Phone: +65-68614511 Fax: +65-68623166  
Philippine Office: Chemdis Bldg., Don Jesus Blvd., Alabang Hills Village, Muntinlupa City,  
Philippines  
Phone: +63-2-809-8982 Fax: +63-2-809-6221  
Indonesia Office: Graha Cevril, Jl. Senopati Raya No.6A, Jakarta 12110, Indonesia  
Phone: +62-21-725-7486 Fax: +62-21-725-7865

### JSW Plastics Machinery (M) SDN. BHD.

D6-5-G,(Ground Floor), Block D6, Pusat Perdagangan Dana 1,  
Jalan Pju 1A/46, 47301, Petaling Jaya,  
Selangor Darul Ehsan, Malaysia  
Phone: +60-3-78426076 Fax: +60-3-78426078

### JSW Plastics Machinery (T) Co., Ltd.

78/6 JST Building 4th Fl., Moo 7 King Kaew Road, Rachatewa,  
Bangplee, Samutprakarn 10540 Thailand  
Phone: +66-2-738-5272 Fax: +66-2-738-5277

### JSW Plastics Machinery Vietnam Ltd.

Room103, Techno-Center Thang Long Industrial Park Dong Anh District,  
Hanoi, Viet Nam  
Phone: +84-4-3951-6383 Fax: +84-4-3951-6384

### JSW Plastics Machinery (H.K.) Co., Ltd.

Room 907, Corporation Park, 11 On Lai Street, Shatin N.T., Hong Kong  
Phone: +852-2648-0720 Fax: +852-2686-8204

### JSW Injection Machine Maintenance (Shenzhen) Co., Ltd.

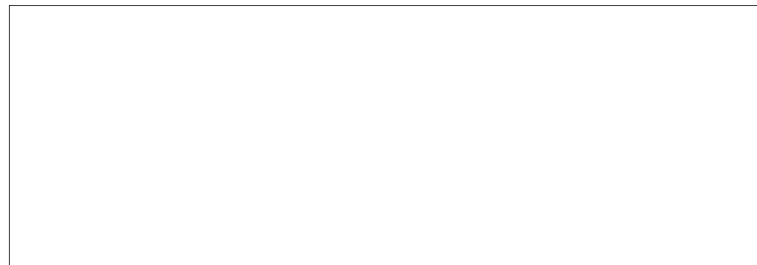
1/F, Block A, Sanhe Industrial Park, Yongxin Street, Yingrenshi Village,  
Shiyan Town, Baoan District, Shenzhen, 518108, People's Republic of China  
Phone: +86-755-8602-0930 Fax: +86-755-8602-0934

### JSW Plastics Machinery (Shanghai) Corp.

28A, Strength Plaza, No.600-4, Tianshan Road, Shanghai, 200051,  
People's Republic of China  
Phone: +86-21-5206-7031 Fax: +86-21-5206-7033

### JSW Plastics Machinery (TAIWAN) Corp.

Head Office: 1F, No.23, Da Hu 1st Rd., Guishan Shiang, Taoyuan, Taiwan, R.O.C.  
Phone: +886-3-396-2102 Fax: +886-3-396-2104  
Tainan Office: 15F-7, No.689-78, Shiao E. Rd., Yungkang City Tainan, Taiwan, R.O.C.  
Phone: +886-6-311-4192 Fax: +886-6-311-4193



# JAD SERIES

## Electric Servo Drive Injection Molding Machine



model	J550AD	J1000AD
	J650AD	J1300AD
	J850AD	J1800AD
	J850ADW	

# JSW



# Large Electric Servo Drive Injection Molding Machines Promotes Faster Cycles, Energy Savings, and High Performance

An industry pioneer, JSW has extensive experience in manufacturing large electric molding machines.

The newly released, second-generation large electric servo drive molding machine promises to deliver measurable improvements in productivity, quality, and economy.

This latest improvement retains our time proven toggle clamping unit, which for many years has delivered "faster cycle times" and "unparalleled energy savings."

## AD Series Large Size Electric Servo Drive Injection Molding Machine

## Providing Increased Productivity

### Productivity

- Increased Platen Speed
- Reduced Dry Cycle
- Improved Plasticizing Capability
- Extra Rigid Clamping Unit

### Environment

- Reduced Power Consumption
- Reduced CO<sub>2</sub> Emissions
- Power Supply Regenerating Function
- Reduced Cooling Water, Hydraulic Oil, and Lubrication Oil Consumption

### Stability

- SYSCOM3000
- Fast Servo Control Circuit
- HAVC Control
- Reverse Seal Control
- IWCS Control
- Clamp Force Feedback Control
- Injection Compression Molding
- Foaming Molding Control



Complying with safety regulations  
EU safety regulations (CE Marking)  
Industrial machinery  
Industry safety rules (JIMS K1001)

# Faster Cycle Performance

## Quicker dry cycle, substantially improving productivity

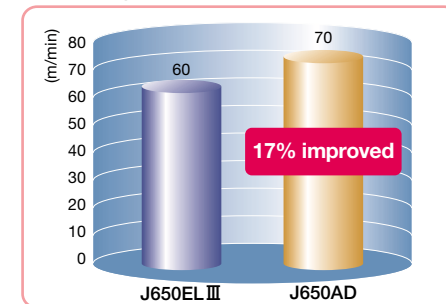
### ■ Rigid fast cycle toggle

JSW' original high-rigidity fast cycle toggle mechanism, provides quicker dry cycle time.

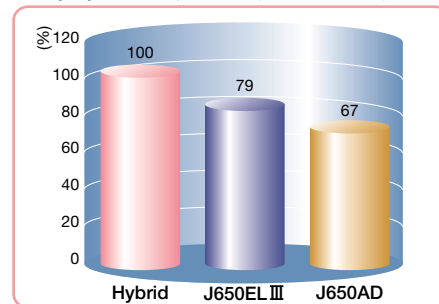
- ☆ Dry cycle time is further reduced by improving the platen speed by 20%.
- ☆ Ejector speed has been improved to reduce product removal time.
- ☆ The speed of mold height adjustment has been improved to allow reduced setup time.
- ☆ The high-rigidity clamping unit achieves high-precision stabilized molding.
- ☆ The flat press platen structure, which exerts a clamping force evenly distributed over the mold surface, minimizes the wall-thickness fluctuation of molded products. (Pat. # 4107509)



■ Platen speed



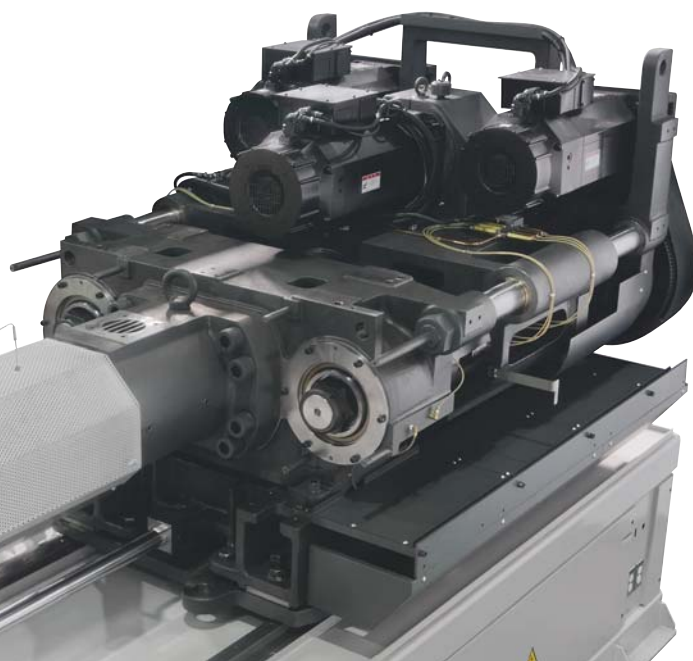
■ Dry cycle comparison (relative ratio)



## Substantial reduction in plasticizing time of new injection unit and new screw unit

### ■ New injection unit

The newly developed injection unit has been made smaller and lighter, improving injection acceleration and deceleration performance. Also, high injection power, heavy-duty drive provides robust injection and greater plasticizing capability.



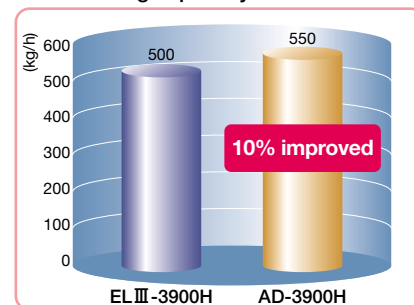
### ■ New design screw

Improved High Melter M III Screw with greater plasticizing and mixing performance is equipped as standard for 2300H or larger injection unit.



Already industry-leading plasticizing capability has been further improved by 10%. It reduces the plasticizing time that contributes to the cycle time.

■ Plasticizing capability



# Phenomenal Energy Savings

## Product improvement by 30%, power consumption reduced by 60%, and CO<sub>2</sub> reduced 92t/year\*

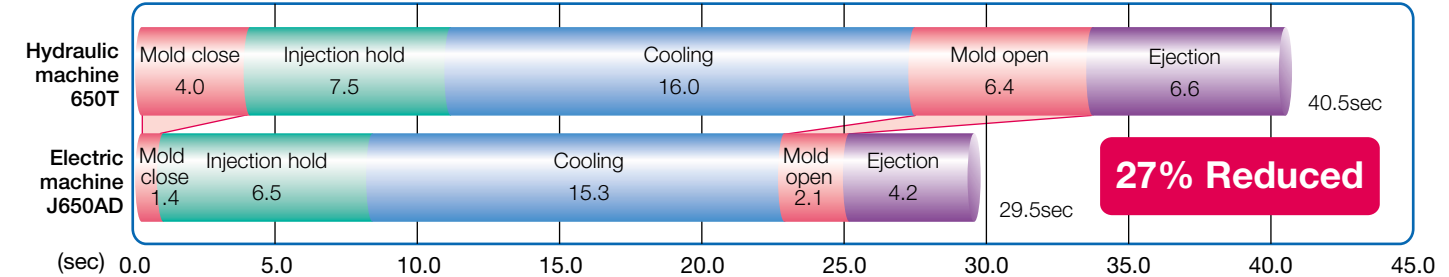
### Ex.1 Reduced cycle time and energy savings

AD Series provides industry-leading energy savings as well as substantial reduction in cycle time

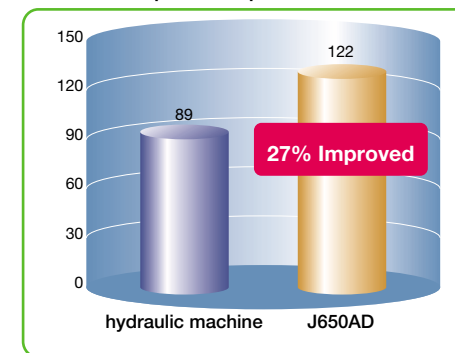
Product: Case  
Qty: 1  
Resin: PP  
Weight: 935g



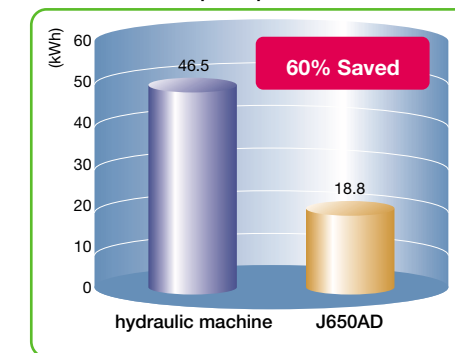
※ Mold open/close time has been substantially reduced



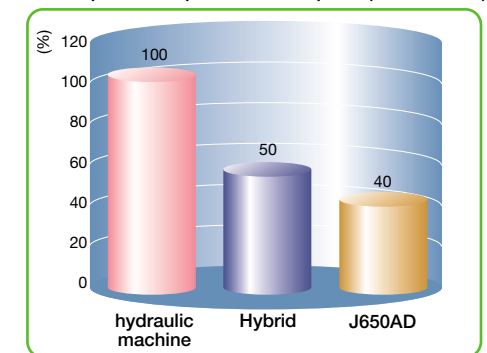
● Number of products per hour



● Power consumption per hour



● Comparison of power consumption (relative ratio)

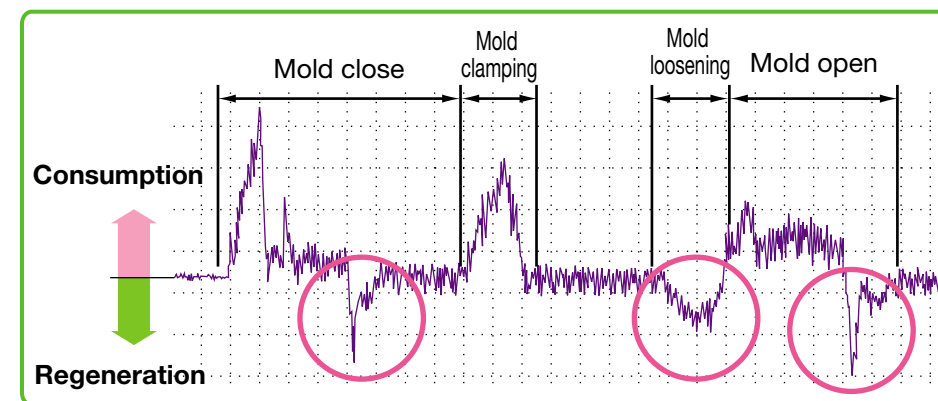


※ Comparison of our hydraulic machine (650T) and J650AD. When calculated with CO<sub>2</sub> conversion factor of 0.555kg/kWh for annual operation time of 6,000 hours (20 hours x 300 days).

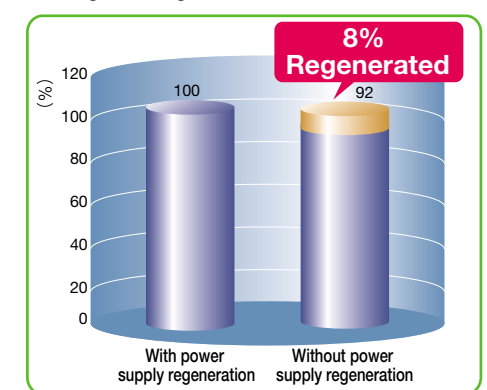
## Original Power Supply Regenerating Function (Energy Savings Technology)

The power supply regenerating function, which retrieves energy generated in injection or deceleration in mold open/close action as electric power, has been equipped from the previous series. Substantial energy savings are achieved through power supply regenerating function in all the processes.

### Ex.2 Regenerated power supply in mold open/close



Through power supply regenerating function, approximately 8% of power supply is regenerated in mold open/close process.



## Environmentally-friendly, substantially reducing cooling water, hydraulic oil, and lubrication oil

- ☆ Cooling water usage saving to 1/5 or less of the hydraulic machine
- ☆ Hydraulic oil usage saving to 1/30 or less of the hydraulic machine
- ☆ Lubricating grease usage reduced by 25% from the previous series by developing new JS1 Grease, superior in load bearing, adhesion property, and lubrication property

## Easy Operation, Multiple Functions New Controller SYSCOM3000

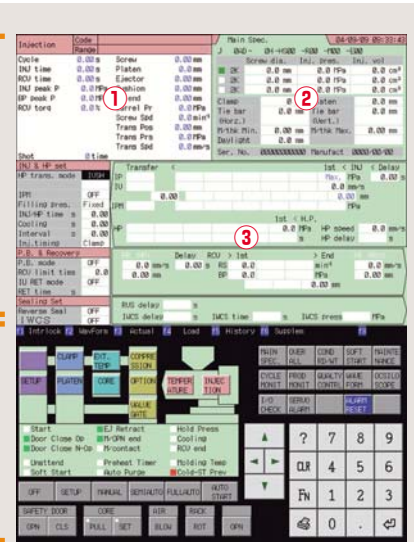
- ☆A vertically arranged large 15-inch TFT color LCD screen. The controller provides the operator with a clear view of molding parameters.
- ☆An illustration of the machine, in conjunction with operation mode keys and a touch screen ensures easy operation.
- ☆Languages are selectable from English, Chinese, and Japanese even during running. Other languages (Hagul, Spanish, and French) are optional.
- ☆Storage of molding conditions: 120 conditions can be stored in internal memory and 1,000 conditions in external USB memory.
- ☆Molding conditions, waveform data, or measurement data can be exported to USB memory, which makes editing and managing in a computer easy.
- ☆Password function has been added for security. Passwords can be set for each management level. (Option)



### SYSCOM3000 screen

Operation includes the condition setting screen, the touch panel screen, and the selector switches.

### Condition setting screen

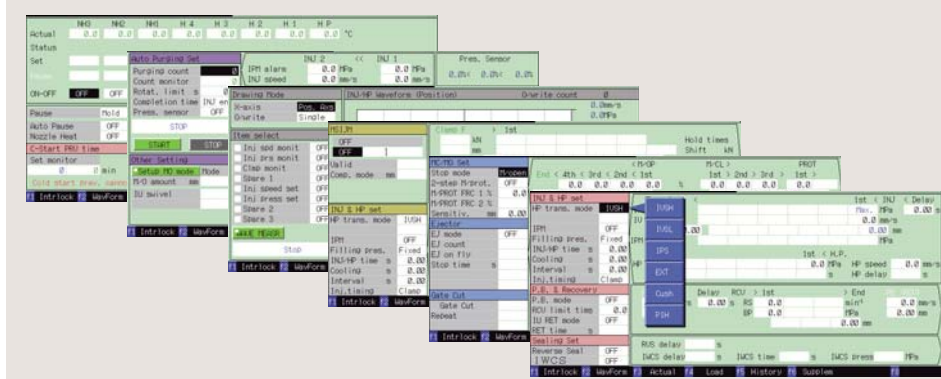


### Touch panel screen



### Selector switches

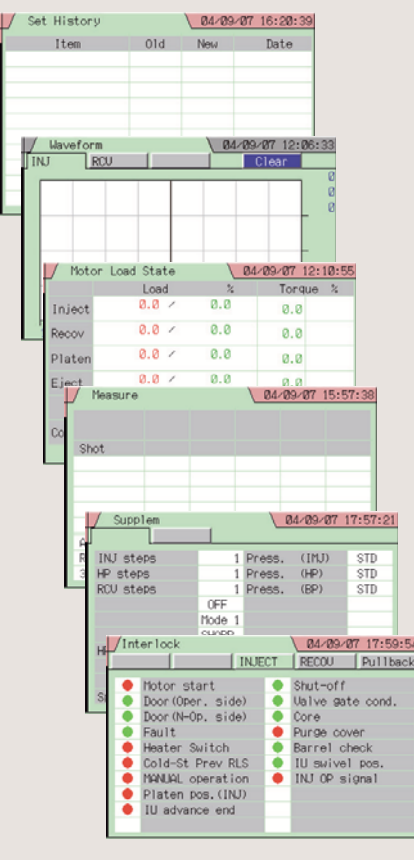
### Condition setting screens



### ① Cycle monitor screen

Injection	Code	Range		
Cycle	0.00 s	Screw	0.00 mm	
INU time	0.00 s	Platen	0.00 mm	
RCU time	0.00 s	Ejector	0.00 mm	
INU peak P	0.0 MPa	Cushion	0.00 mm	
BP peak P	0.0 MPa	HP end	0.00 mm	
RCU torq	0.0%	Barrel Pr	0.0 MPa	
		Screw Spd	0.0 min <sup>-1</sup>	
		Trans Pos	0.00 mm	
		Trans Prs	0.0 MPa	
		Trans Spd	0.0 mm/s	
Shot	0 time			

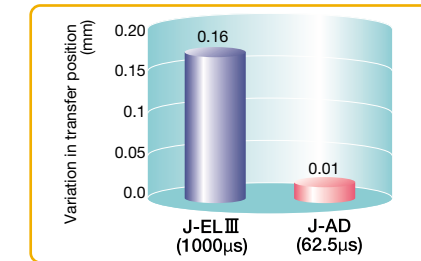
### ② Convenient monitoring screens



## The industry's fastest class 62 micro second servo control circuit attains a new high in accuracy and stable quality levels

Use of a high-speed servo control circuit in the AD Series reduces scanning time to 1/16<sup>th</sup> of conventional controls and achieves an outstanding 62 micro seconds of scan time. It promotes product quality through a reduction in performance variation, such as holding pressure transfer positions.

### ■ Comparisons of variations in the transfer position at 160 mm/s injection speed



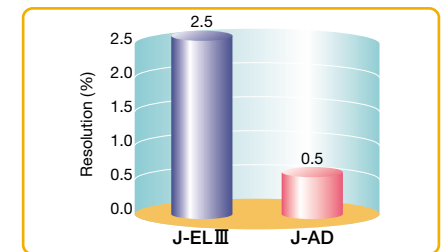
### JSW original high-speed servo control board



## Highly upgraded resolution of the injection pressure detector

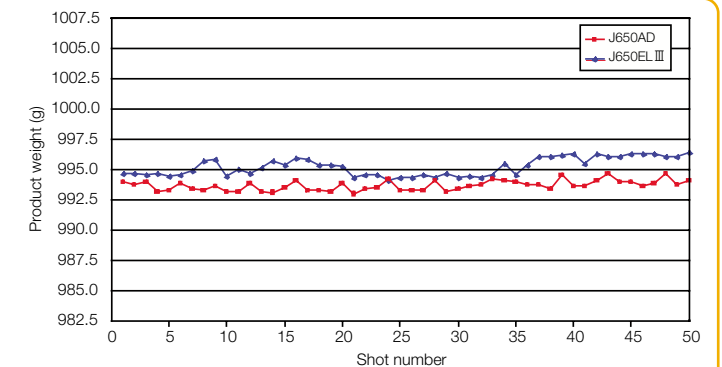
The resolution of the load cell amplifier for the injection pressure has been intensified five fold for more accurate back pressure control which helps ensure stabilized precision molding.

### ■ Resolution of pressure detection (assumed to be 10 Mpa of back pressure)



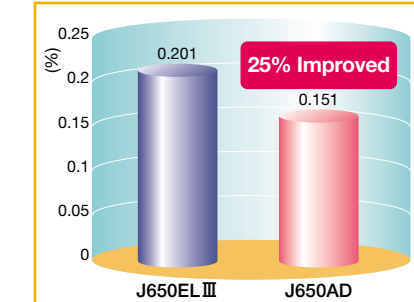
### Ex.3 Molding stability (Standard molding)

Product: Tray  
Qty : 1  
Resin : PP

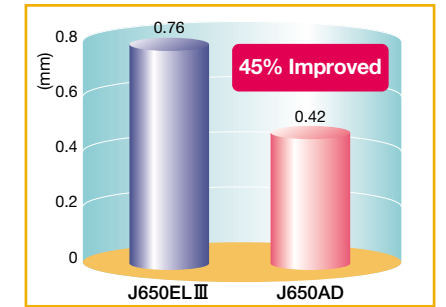


	Product weight (g)	
	J650EL III	J650AD
MAX	997.8	996.3
MIN	995.8	994.8
AVG	996.8	995.4
R	2.0	1.5
<b>R/AVG (%)</b>	<b>0.201</b>	<b>0.151</b>
σ	0.641	0.365
σ/AVG (%)	0.064	0.037

### ■ Variation in product weight



### ■ Variation in cushion



## Dual Integrated Control system (D.I.C. system) for molding machine and product takeout robot

Optional equipment

The product takeout robot can be operated from SYSCOM3000, and also the molding machine can be operated from the controller of the product takeout robot. Effective for reducing setup time.



## HAVC (High Accuracy Volume Control)

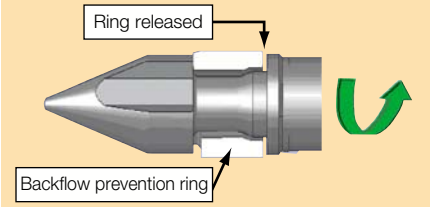
NEW

Standard equipment

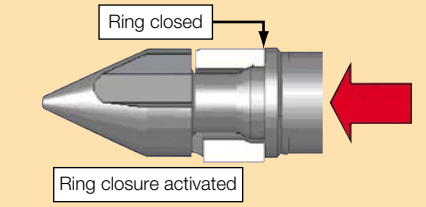
Technology to stabilize injection pressure for every shot and product weights by reverse sealing after completion of weighting and performing high precision control of screw position. Effective for molding that requires higher level of precision stability than traditional stability control.

### Control action

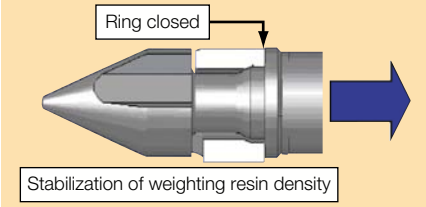
#### Rolling action when reverse sealing



#### Re-back pressure action



#### Depressurizing action



## Reverse Seal Control

Standard equipment

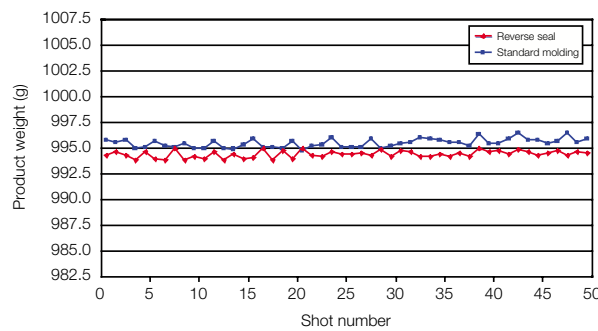
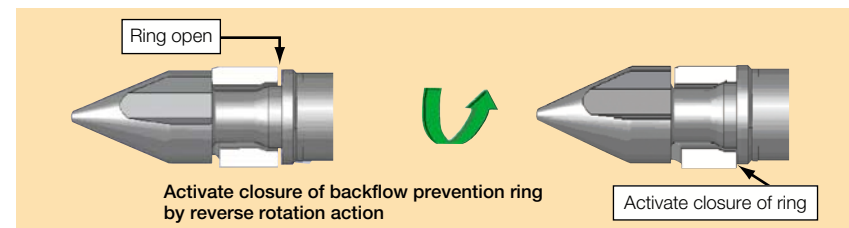
Closure of the backflow prevention ring by rotating the screw in reverse direction for a certain amount to lower the pressure in the screw and at the tip. It is especially effective for low speed injection molding.

### Ex. 4 Product stability (Reverse seal)

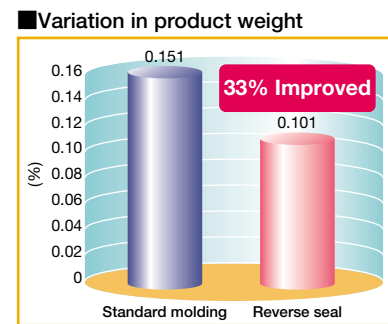
Molding machine: J650AD  
Product: Tray  
Qty: 1  
Material: PP



### Control action



	Product weight (g)	
	Standard molding	Reverse seal
MAX	996.3	995.0
MIN	994.8	994.0
AVG	995.4	994.5
R	1.5	1.0
<b>R/AVG (%)</b>	<b>0.151</b>	<b>0.101</b>
$\sigma$	0.365	0.298
$\sigma$ /AVG (%)	0.037	0.030

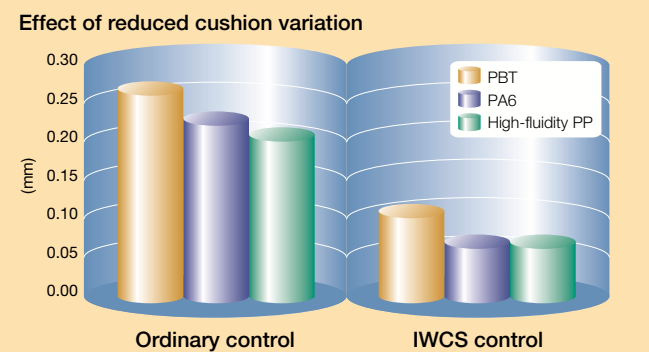
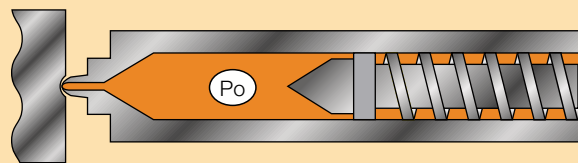


## IWCS (Injection Weight and Cushion Stability) Control

Standard equipment

A patented control that stabilizes the density of the molten resin stored at the tip of the screw on every shot. This technology is effective in minimizing the variance in product weight. (Pat. # 3529771)

This is the control method to re-stabilize the measured density of melted resin of each shot after plasticizing which is prepared at screw head section. This is the unique control technology of JSW that exerts great effect to correct unbalance between product mass and cushion.



## Clamp Force Feedback Control

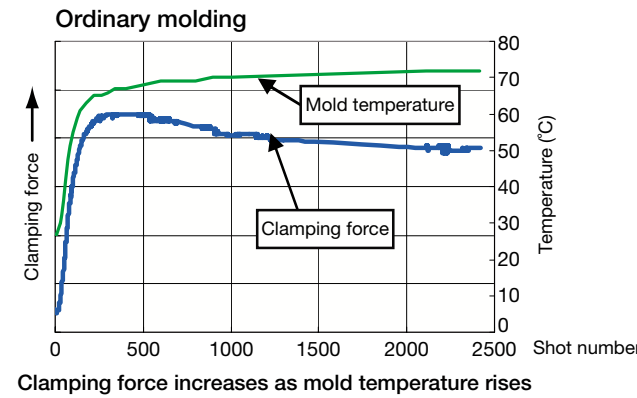
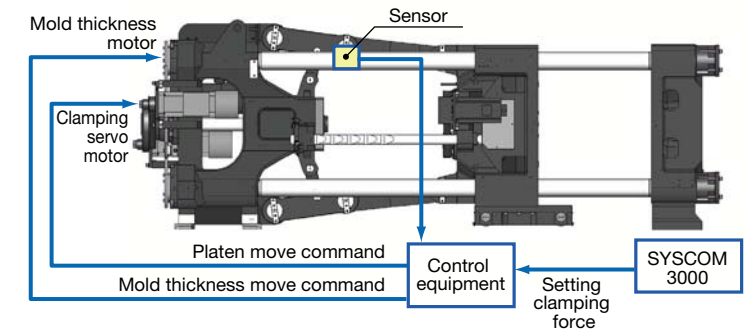
NEW

Standard equipment

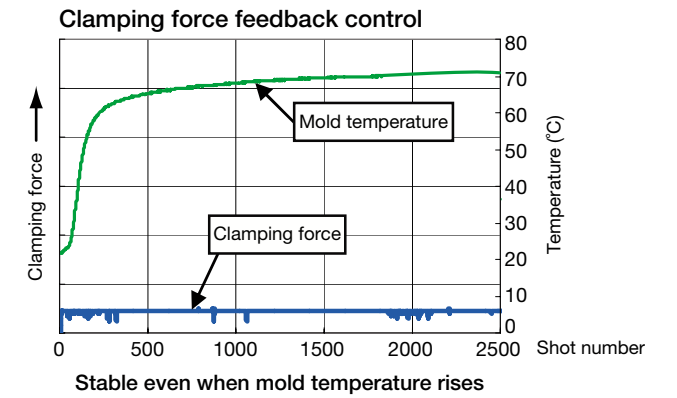
### Clamping force feedback effect (patent pending)

Clamping force is always monitored with a sensor while molding and automatically corrected to the set value. Also, clamping force can be changed while molding observing the actual molding.

- ☆“Visualization” of the actual clamping force in toggling machine
- ☆“Improved product quality” by stabilizing gas venting
- ☆“Longer mold life” with optimum clamping force
- ☆“Reduction of mold maintenance” by stabilizing gas venting



Clamping force increases as mold temperature rises



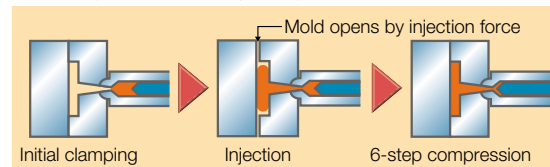
Stable even when mold temperature rises

## Injection Compression Molding

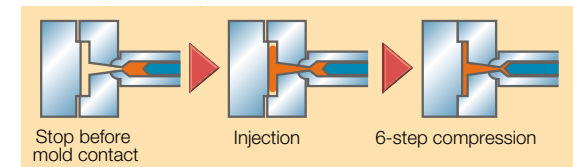
Standard equipment

JSW injection compression molding feature enables the mold position to be controlled to accuracies over 10 times that of direct-pressure molding.

A-mode (A1 - A6, A7 <option>)



B-mode (B1 and B3)



### Effects of injection compression molding

- ☆Reduction in product distortion
- ☆Improvement in transcription
- ☆Easier mold release
- ☆Cycle time reduction
- ☆Lowering the clamping force (Low-pressure molding)
- ☆Gas venting
- ☆Skin adhesion molding

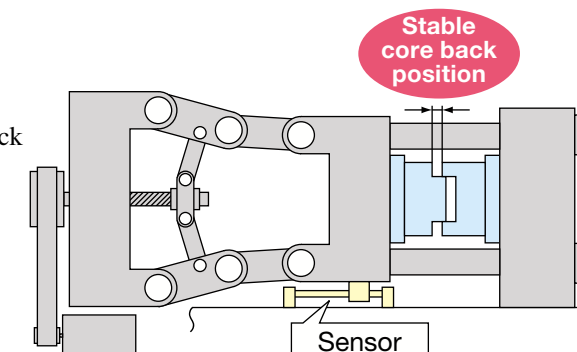
## Foaming Molding Control

Optional equipment

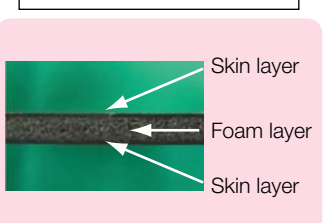
JSW's unique high precision platen position control enables expanding foam molding incomparably stable compared with traditional method. The dedicated position sensor stabilizes product dimensions by directly detecting the position of the platen and performing feedback control.

### Features

- ☆Excellent stability in repeated core back position control
- ☆Relatively inexpensive equipment
- ☆Post installable to existing machine



### Product cross section



## Standard Equipment List

Item	
Open nozzle	
N2000F barrel	
Chrome plated screw	Note 1
Purge cover (with limit switch)	
Injection unit swiveling device (with limit switch)	Note 2
Screw cold start prevention	
Molding/Pause temperature select	
Auto purging circuit	
Nozzle retract select	
Pull-back select	
Auto grease lubrication	
Injection/Metering programmed control	Injection/Holding pressure : 1~6 Steps (Variable) Metering/Back pressure : 1~3 Steps (Variable)
Holding pressure transfer select	
Holding pressure control select	Step mode Slope mode
Barrel temperature control (PID)	Note 3
Nozzle temperature control (PID/SSR)	
Synchronous temperature rise control	
Hopper flange temperature control	
Soft pack servo control	
HAVC (High Accuracy Volume Control)	
IWCS (Injection Weight and Cushion Stability) control	
Reverse seal control	
Grease-free toggle bushing	
Auto grease lubrication	
High-performance platen support	
Flat press platen mechanism (Stationary side/Movable side)	
Mold open/close and Ejector programmed control	Mold open/close : 4 Steps (Fixed) Ejector : 1~3 Steps (Variable)
Mold protection	1~3 Steps (Variable)
Ejector braking system	Note 4
Electric-driven mold thickness adjusting device	
Auto clamp force setting	
Clamp force display	
Clamp force feed back control	
Toggle type clamp injection compression Function	A -mode B -mode Compression : 1~6 Steps (Variable)
Clamping safety device (Electrical/Mechanical)	
Robot mounting holes	
Compound action	Screw rotation during mold open/close Eject during mold open Injection during clamp up
Safety mat	Operator side step safety mat Under mold area safety mat Note 5

- Note 1. GP21 screw for Injection unit 1400H.  
High-Melter Mill screw for Injection unit 2300H and higher.
- Note 2. Manual operation type for Injection unit 1400H.
- Note 3. Injection unit 1400H is controlled by SSR (non-contact).  
Injection unit 2300H and higher are controlled by MC (contact).
- Note 4. Equipped as standard for J650AD and higher, optional for J550AD.
- Note 5. Safety mat on the top of the step is equipped as standard for J650AD and higher, optional for J550AD.  
Safety mat on the top of the inter-platens bed is equipped as standard for J850ADW and higher (models with 1200mm or wider gap between tie-bars), optional for J850AD.

Item	
Touch panel 15" TFT color LCD controller	
120 Mold condition storage (Internal memory)	Note 6
Soft start molding	
Self diagnostics function	
Help function	
Pop-up display	
Clock	
Multi-language select (English, Chinese, Japanese)	
Print screen by USB memory	
USB printer port	Note 7
Overall setting screen	
Pre-heat timer	
Product takeout robot circuit	
Attended/Unattended operation select	
Emergency stop button	
Safety key	
Actual value display	
Mold temperature display	Note 8
Injection/Metering waveform monitor	
Oscilloscope waveform monitor	
Injection/Metering waveform storage	
Barrel temperature monitor	
Injection pressure monitor	
Statistical graph	
Production monitor	
Cumulative operating hour display	
Cycle monitor	
Molding condition upper/lower limit monitor	Note 9
Inspection and Maintenance guide	Note 10
Heater system fault alarm	
Injection pressure overshoot alarm	
Grease lubrication fault alarm	
Servo fault alarm	
Unreleased clamp alarm	
Position calibration request	
Alarm buzzer	
Alarm history	
Set value history	
Safety compliance to JIMS K1001	
Cooling water closed circuit for feed throat	
Mold cooling water circuit (Machine bed)	
Accessories (Maintenance tools, Ejector rods, etc.)	

- Note 6. The external memory is capable of storing conditions for 1,000 molds.  
Prepare commercial USB data storage media.
- Note 7. The printer and printer cables are options.
- Note 8. Temperature sensors and electric wiring are not included.
- Note 9. Maximum of 16 items and alarms can be selected out of the following monitor items.  
①Cycle time ②Injection time ③Metering time ④Cushion position  
⑤Holding pressure end position ⑥Injection pressure  
⑦Holding pressure transfer pressure ⑧Screw back pressure  
⑨Metering end position ⑩Injection start position ⑪Holding pressure transfer position  
⑫Mold open time ⑬Mold close time ⑭Metering torque  
⑮Holding pressure transfer speed ⑯Mold inner pressure (option)  
⑰Clamp force ⑱Shift amount (HAVC) ⑲End speed (HAVC)
- Note 10. Indicates inspection times and items.

## Options List

Item	
Long nozzle	
Shut-off nozzles (Pneumatic type and Hydraulic type)	
LSP-2 screw (Abrasion-resistant type)	
Wide selection of screws & barrels	Screw & Barrel for high plasticization Screw & Barrel for optical application High dispersion screw High viscosity resin screw Long-fiber resin screw Special screw Note 1
Barrel Insulation cover	
Barrel blower cooling unit	
Hopper (Option for all the region)	
High holding pressure molding (for long-time holding pressure molding)	Note 2
Electric motor driven IU advance/retract	
Vented barrel	
Daylight extension	
T-slot platen	
Locating ring	
Air jet	
Core pull device (Pneumatic type and Hydraulic type)	Note 3
Valve gate device (Pneumatic type and Hydraulic type)	Note 3
Auto safety gate open	
Auto safety gate open/close	
Safety mat	Note 4
Safety footplate	
Mold clamber	
Mold setup device	
Magnet mold Clamper	Note 5
Cooling water manifold on platen	
Hydraulic power pack	
Ejector braking system	Note 6

- Note 1. Regarding special screws, contact us separately.
- Note 2. Enables a long holding time and high holding pressure molding.  
The injection speed may become lower.
- Note 3. For the hydraulic type, a separate hydraulic unit is needed.
- Note 4. Safety mat on the top of the step is equipped as standard for J650AD and higher.  
Safety mat on the top of the inter-platens bed is equipped as standard for J850ADW and higher (models with 1200mm or wider gap between tie-bars).
- Note 5. When applied, extended nozzle is required.  
Note that the usable mold thickness range will change.
- Note 6. Equipped as standard for J650AD and higher.

### Examples of standard equipment



Safety mat



Mold cooling water closed circuit (bed installing type)

### Examples of optional equipment



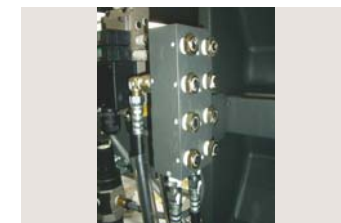
Leveling pad for installation



Mold cooling water closed circuit (platen installing type)



Hydraulic unit



Core circuit (hydraulic) unloading slot



Spare receptacle



Screws for various molding applications

- The appearance and the specifications of the machine may be altered for improvement without notice. ○Unauthorized reprint from this leaflet is prohibited.

Item	
Multi-language select (French, Spanish or Hangul)	Note 7
Simple centralized monitor system Link10	Note 8
Centralized control system NET100	Note 9
Heater burnout alarm	
Mold temperature display (with mold temperature upper/lower limit alarm)	
Mold temperature control (with mold temperature upper/lower limit alarm)	
Printer (with printer cable)	
Password Function	
Hot runner control circuit	
Unscrewing motor circuit	
Ejector gate cutting circuit	
Ejector plate return confirmation circuit	
Injection speed: 10 Steps control	
Injection speed slope control	
Foaming molding control	
Skin adhesion molding control	
D.I.C. (Dual Integrated Control) with Yushin Robot	
Hopper stage	
Cooling water failure warning	
Leveling pad for installation	Note 10
Rotary warning light	
Export specification	Note 11
Designated color	Note 12

●For details of each option, confirm in the specifications for the options.

- Note 7. Regarding the other languages, contact us separately.  
English and Chinese are equipped as standard.
- Note 8. The LINK10 has actual data collection, molding condition control and remote control functions.
- Note 9. The NET100 has quality control and production control function in addition to the functions that the LINK10 has.
- Note 10. May not be applicable depending on the model.
- Note 11. Regarding the export specifications, separate discussion is needed in some cases, depending upon the export destination.
- Note 12. Designate colors, referring to color samples or Munsell codes.