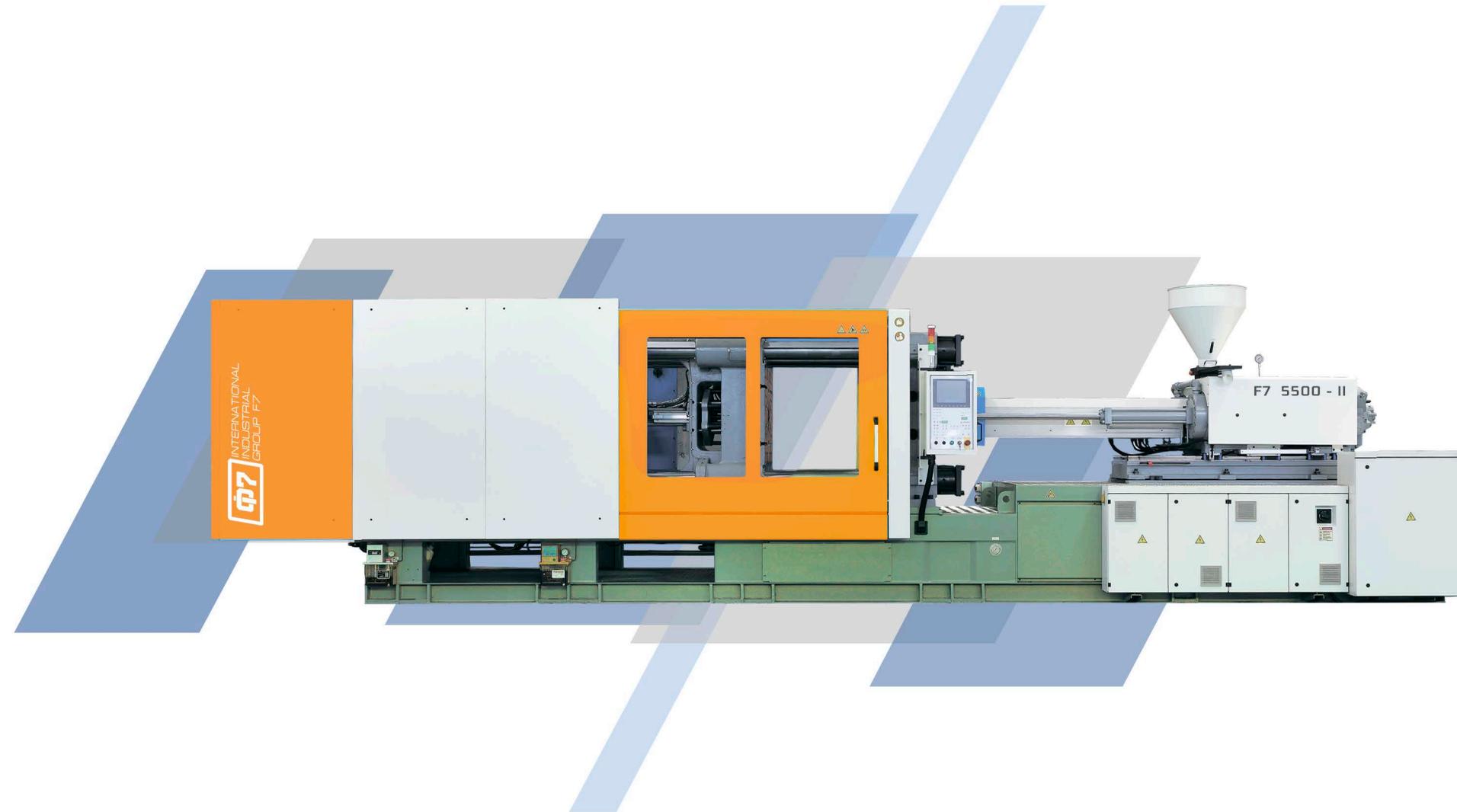


F7 - II Series

Our corner stone — custom—made



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IIG F7 Machinery Technology

IIG MACHINERY



Accurate & Reliable Machinery

We control the quality not only check each single piece of spare part, but also simulate machine's actual working to check each spare part's fit precision during our installation, ensure our machines' best precision; thanks to the cooperation with the TUV Rheinland, ensure our machines' reliability.

Developmental Innovation & Research

With the increasing demands of plastic quality and quantity, injection molding factories required machines higher and higher, IIG F7 keeps the developmental innovation and research on predslon, efficiency safety and special material injection molding.

World-wide 7 x 24 Service

Since found our independent brand, IIG F7 established more than 20 international service network, we not only have the service network in Asia, South America, Africa, but also have the sales and service center in Europe, ensure the fastest local service for our customers.

Affordable Price

IIG F7 always insist to provide customers high quality equipment under the reasonable price, we have no intention to pursue unhealthy price competition to win the market, to ensure the company's benign and sustainable development; and provide the comprehensive service for customers.

Your Solution & Custom—made Partner

With the constant development of economy and society, customers demand more and more special and individual service; IIG F7 provide the "CUSTOM-MADE" service to help customers to be successful on high efficiency, high precision and cost saving, to reduce the investment risks.

Leading Technology

From 2006 to 2010, IIG F7 was an OEM team for EUROPEAN machines; years of OEM experience made IIG F7 controlled the core technology on high quality, high safety machine manufacturing, thus made our advantage on leading technology.

Experienced & Efficient Team

From OEM to independent brand business, IIG F7 deeply realized the importance of the team for a brand; the IIG F7 team is composed of experienced staff, whose average experience more than 15 years in this field; and all of departments keep timely and friendly communication for customers suggestions, discuss the improvement of design and installation.

OUR ADVANTAGES

> Near performance with world high level machine, with an easy affordable price, it's the key of success for IIG F7 series machine.

> We are almost harsh for quality, on IIG F7 machine, we required each bolt should be high strength , and this is the main reason of IIG F7 machine's outstanding performance.

> Only energy saving? IIG F7 is not so simple! For its outstanding performance, no matter labor, material or energy it will make you surprise. At the same time, it will help you highly improve your product quality, production efficiency, plant space using efficient and marketing competition.

> Energy Saving
Precision and energy saving servo system with optimized designed hydraulic circuit, the energy saving capacity is near with full-electric machine.

> Modularity
You can always come back for seconds, thanks to IIG F7 modular design upgrades and retrofits are a piece of cake.

> Individuality
We will custom-made your IIG F7 according to your menu and necessary, and our wide range options nearly covered all of your necessary.

> Cost—performance
IIG F7 not only has the near performance With world high level IMM, but price is easy affordable.

> User—friendly
Easy for operation, convenient for maintenance, IIG F7 makes everything easy.



> Stability

More than 20 years experience in this field, and several years OEM experience for world famous brands IMM, IIG F7 series can serve you perfect performance and stability.

> High speed

Fast response hydraulic system, sensitive controller system, and the best optimized mechanical system, highly improved machine's Cycle time.

> Clean

Maintenance free lubrication material used on adjustment system, linear guide rail for injective system, grease lubrication for movable platen, ensure a clean production environment for you.

> Reliability

All of hydraulic and electric parts adopt world top brands, the whole mechanical system's rigidity is much higher ' Chinese normal IMM, the key mechanical parts' suppliers same as world first-class IMM brands.



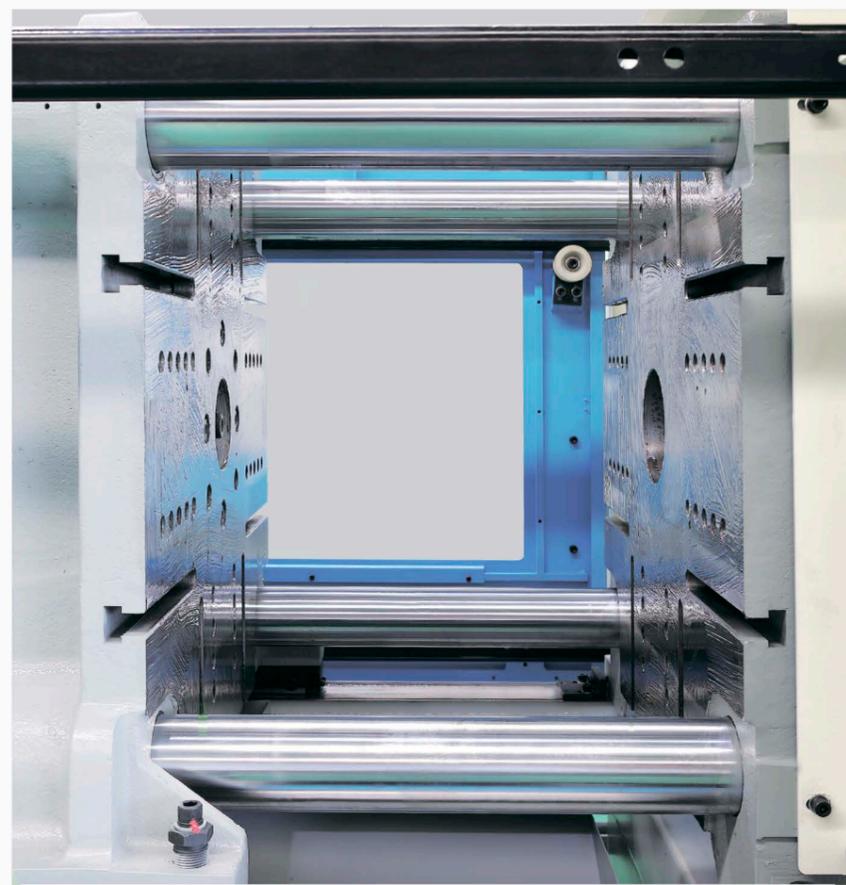
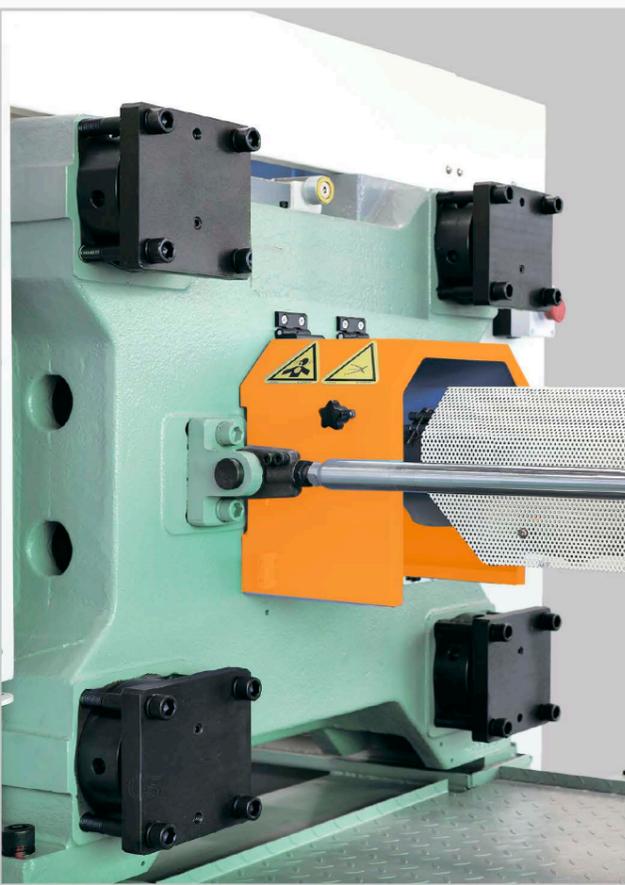


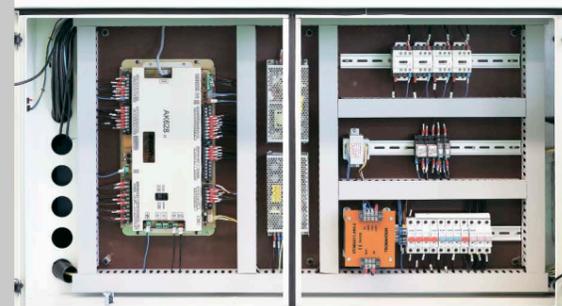
CLAMPING UNIT

- > Larger space between tie-bars. suitable for larger molds and multi-cavity necessary.
- > Longer and wider guide length, higher repeatability precision, improve product quality and mold working-life.
- > Upgraded parts, Graphite-copper bushes and slider used on tie-bar, ejector and movable platen, ensure fast and precise mold close and open.
- > Better designed mechanical structure and toggle system, faster cycle time, and improve production efficiency.
- > European type ejector structure, larger space, convenient for maintenance.
- > Prepared enough space for upgrade and retrofits.
- > Much higher rigidity mechanical system than normal Chinese IMM, not only improve machine's using-life, but also can protect mold.

INJECTION UNIT

- > Full supported injection unit with dual precise linear guide rails, ensure the best precision and fast start speed.
- > Dual carriage cylinders improve a better injection precision.
- > Injection unit steel pipes adopt pipe fitting to connect, no welding design ensure maintenance and after—service to be easier.
- > Upturning designed nozzle cover, production and maintenance to be easier.
- > Imported high quality SKD61 material screw tip, check ring and thrust ring; a lot kinds of screws design can meet different plastic material and special processing injection molding needs.

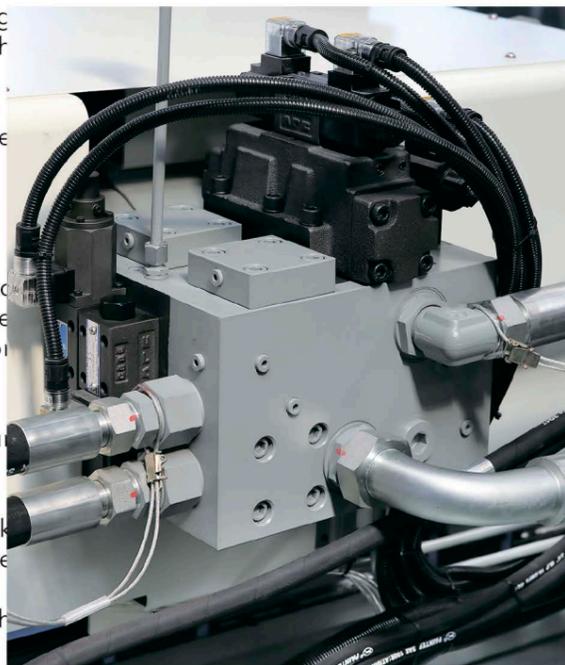




HYDRAULIC UNIT

ELECTRIC UNIT

- > Standard equipped with precise and energy saving servomotor system, energy saving capacity can reach to 20%~80% then traditional injection machine.
- > World famous brands hydraulic parts ensure machine's reliability and fast.
- > Response speed
- > Visible and dischargeable oil tank, easy for hydraulic circuit maintenance. Adopt modular adaptor valve blocks, hydraulic circuit and functions easy for available up—grade and maintenance.
- > Self-sealed magnetic suction filter, make your maintenance more convenient.
- > Logical distribution of pump oil suction port, oil tank oil outlet and hydraulic pipe fits, easy for maintenance
- > Germany DIN standard hydraulic pipe fitting with seal, G screw thread style plug, avoid oil pollution.



- > World well-known brands electric parts.
- > High quality large color screen controller, multi-language available
- > Standard equipped LED three-color tower light with alarm, machine working situation is clear.
- > Modernized network management function available.
- > Water proof rubber seal used on electric cabinet ensure high safety.
- > Machine program according to CE safety standard.



FUNCTION LIST

INJECTION UNIT	110-180	220-350	450-700	900-1300
Standard B screw	●	●	●	●
Other size screw	○	○	○	○
Needle valve nozzle (SVN)	○	○	○	○
Hydraulic / Pneumatic shut off nozzle	○	○	○	○
Double cylinder injection structure	●	●	●	●
Electrical pre-plasticizing	○	○	○	○
Injection transducer control	●	●	●	●
Nozzle transducer	○	○	○	○
Screw rotation speed display	○	○	○	○
Feed zone temp automatic control	○	○	○	○
Normal heat bands	○	○	○	○
Ceramic heat bands	●	●	●	●
Electromagnetic heater	○	○	○	○
Injection unit centralized lubrication	○	○	○	●
Proportional backpressure	○	●	●	●
Accumulator fast injection	○	○	○	○
CLAMPING UNIT				
T-slot mold platen	●	●	●	●
Screw hole platen	○	○	○	○
Extend mold height	○	○	○	○
Auto-adjustment movable platen support device	—	—	—	●
Mechanical & electric interlock device	●	●	●	●
Mold open & close and ejector transducer control	●	●	●	●
Product dropdown chute with sensor	○	○	○	○
Good / bad parts selector	○	○	○	○
Mold height auto-adjustment function	●	●	●	●

CLAMPING UNIT	110-180	220-350	450-700	900-1300
Clamping force indication	○	○	○	○
Widened safety door	○	○	○	○
Automatic safety door	○	○	○	●
Safety pedal in mold area	—	—	—	○
Quantitative automatic centralized lubrication	●	●	●	●
Progressive (PRG) lubrication system	—	—	—	○
Fast connector water regulation	○	○	○	○
Glass water regulator	○	○	○	○
Hydraulic / Electric rotation demould	○	○	○	○
Air blast	○	○	○	○
1 PCS Core pull	●	●	●	●
Hydraulic unscrew device	○	○	○	○
Proportional valve for mold open & close	○	○	○	○
Hydraulic shut off control for hot runner nozzle	○	○	○	○
Heat insulating plate	○	○	○	○
HYDRAULIC UNIT				
Servo motor system	●	●	●	●
Increase pump motor capacity	○	○	○	○
Simultaneous movement (use PQ2)	○	○	○	○
Simultaneous movement (use single pump)	○	○	○	○
Hydraulic safety interlock	○	○	○	●
Oil temperature indication	●	●	●	●
Oil temperature Auto control	○	○	○	○
Oil level alarm	○	○	○	○
Hydraulic oil pre-heating	○	○	○	○
By-pass filter	○	○	○	○
High pressure in-line filter	○	○	○	○
Low pressure return oil filter	○	○	○	○
External filter interface	●	●	●	●

FUNCTION LIST

ELECTRIC UNIT	110-180	220-350	450-700	900-1300
Techmation controller	●	●	●	●
KEBA controller	○	○	○	○
Euromap 12 robot interface	○	○	○	○
Euromap 67 robot interface	○	○	○	○
Three color tower lighter with alarm	●	●	●	●
SSR	○	○	○	○
Power socket 3P+N+PE(16A)	●	●	—	—
Power socket 3P+N+PE(32A)	○	○	●	●
Single phase power socket (10A)	●	●	●	●
Hot runner control and interface	○	○	○	○
Leadway network management system	○	○	○	○
OTHERS				
Leveling pads, Manual	●	●	●	●
Tool box, Easy broken parts	●	●	●	●
Mold clamp	●	●	●	●
Steel hopper	●	●	●	●
Special color (Pantone No. necessary)	○	○	○	○
Higher machine base	○	○	○	○
Robot	○	○	○	○
Chiller	○	○	○	○
Mold temperature controller	○	○	○	○
Dehumidifier	○	○	○	○
Auto-loader	○	○	○	○
Fumigated wooden case	○	○	○	○
Platform for ready products	○	○	○	○

SHOT WEIGHT CONVERSION TABLE

Material	Factor
HD-PE	0.75
LD-PE	0.73
PP	0.73
PP+20%Talcum	0.85
PP+40%Talcum	0.98
PP+20%GF	0.85
PS	0.91
SB	0.88
ABS	0.88
SAN	0.88
PA	0.91
PA6+30%	1.14
PC	0.97
PE	0.71
PC/ABS	0.94
PMMA	0.94
POM	1.15
PET	1.08
PBT	1.08
CA	1.02
CAB	0.97
PVC-rigid	1.02
PVC-flexible	1.12
PF(thermosets)	1.3
UP(thermosets)	1.6

The maximum shotweights(g)are calculated by multiplying the theorstical shot volume(cm³)by the above factor

TECHNICAL PARAMETERS



DESCRIPTION	UNIT	F7 1100 - II			F7 1500 - II			F7 1800 - II		
International Size Rating		340			480			640		
Injection Unit		A	B	C	A	B	C	A	B	C
Screw Diameter	mm	30	35	40	38	42	45	42	45	50
Screw L/D Ratio	L/D	22	20	17.5	22	20	18.5	22	20	18.5
Shot Size (Theoretical)	cm ³	106	164	214	216	277	318	291	358	442
Shot Weight(Ps)	g	96	149	194	196	252	289	265	326	402
Injection Rate	g/s	60.2	82.0	107.1	100.4	122.6	140.8	129.4	148.5	183.3
Injection Pressure	Bar	2836	2083	1595	2127	1741	1517	2063	1798	1456
Screw Speed	r/min	244			232			224		
Clamping Unit										
Clamping Force	kN	1100			1500			1800		
Opening Stroke	mm	340			375			430		
Space Between Tie-bars(HxV)	mm	420 x 370			470 x 420			520 x 470		
Max. Mold Height	mm	390			500			530		
Min. Mold Height	mm	150			160			180		
Ejector Stroke	mm	100			120			140		
Ejector Force	kN	45			45			45		
Others										
Pump Motor Power	kW	18.2			18.2			20.4		
Heater Power	kW	6.8			7.4			9.9		
Machine Dimensions(LxWxH)	m	4.4 x 1.2 x 1.6			4.6 x 1.3 x 1.7			5.2 x 1.4 x 1.8		
Machine Weight	t	3.7			4.2			5.3		
Hopper Capacity	kg	25			25			25		
Oil Tank Capacity	L	150			200			250		

Due to continuous improvements, we reserve the right to amend any aspect of the above specifications without notice.

TECHNICAL PARAMETERS

DESCRIPTION	UNIT	F7 2200 - II			F7 2800 - II			F7 3500 - II		
International Size Rating		890			1560			2350		
Injection Unit		A	B	C	A	B	C	A	B	C
Screw Diameter	mm	45	50	55	55	60	65	65	70	75
Screw L/D Ratio	L/D	22	20	18.5	22	20	18.5	22	20	19
Shot Size (Theoretical)	cm ³	367	491	594	642	848	996	1078	1347	1546
Shot Weight(Ps)	g	333	447	541	584	772	906	981	1226	1407
Injection Rate	g/s	135.7	167.6	202.7	177.3	211.0	247.6	239.3	277.6	318.6
Injection Pressure	Bar	2253	1825	1508	2190	1840	1568	2028	1749	1523
Screw Speed	r/min	167			180			154		
Clamping Unit										
Clamping Force	kN	2200			2800			3500		
Opening Stroke	mm	490			560			670		
Space Between Tie-bars(HxV)	mm	580 x 530			630 x 580			730 x 680		
Max. Mold Height	mm	580			600			700		
Min. Mold Height	mm	200			220			280		
Ejector Stroke	mm	150			160			180		
Ejector Force	kN	62			62			110		
Others										
Pump Motor Power	kW	23			28.7			36.7		
Heater Power	kW	11.5			13.12			22.04		
Machine Dimensions(LxWxH)	m	5.9 x 1.6 x 2.0			6.7 x 1.8 x 2.0			7.7 x 2.0 x 2.1		
Machine Weight	t	7.5			9.2			13.05		
Hopper Capacity	kg	50			50			50		
Oil Tank Capacity	L	300			380			550		

TECHNICAL PARAMETERS

DESCRIPTION	UNIT	F7 4500 - II			F7 5500 - II			F7 7000 - II			
International Size Rating		2980			4250			5380			
Injection Unit		A	B	C	A	B	C	A	B	C	D
Screw Diameter	mm	70	75	80	75	85	95	80	90	100	110
Screw L/D Ratio	L/D	22	20	19	23.8	21	18.7	24.5	22	19.8	18
Shot Size (Theoretical)	cm ³	1347	1657	1885	1856	2383	2977	2262	2863	3534	4276
Shot Weight(Ps)	g	1226	1508	1715	1689	2169	2709	2058	2605	3216	3891
Injection Rate	g/s	293.7	337.2	383.7	345.1	443.2	553.6	407.8	516.2	637.3	771.1
Injection Pressure	Bar	2065	1799	1581	2293	1785	1429	2380	1880	1523	1259
Screw Speed	r/min	152			144			131			
Clamping Unit											
Clamping Force	kN	4500			5500			7000			
Opening Stroke	mm	760			900			1000			
Space Between Tie-bars(HxV)	mm	780 x 730			886 x 820			980 x 960			
Max. Mold Height	mm	750			850			960			
Min. Mold Height	mm	320			350			400			
Ejector Stroke	mm	200			250			280			
Ejector Force	kN	110			130			200			
Others											
Pump Motor Power	kW	39.4			55.4			36.7+36.7			
Heater Power	kW	27.71			32.15			54.25			
Machine Dimensions(LxWxH)	m	8.2 x 2.0 x 2.2			9.1 x 2.2 x 2.2			10.3 x 2.3 x 2.7			
Machine Weight	t	16.3			21.6			32			
Hopper Capacity	kg	50KG			100			100			
Oil Tank Capacity	L	650			750			880			

Due to continuous improvements, we reserve the right to amend any aspect of the above specifications without notice.

TECHNICAL PARAMETERS

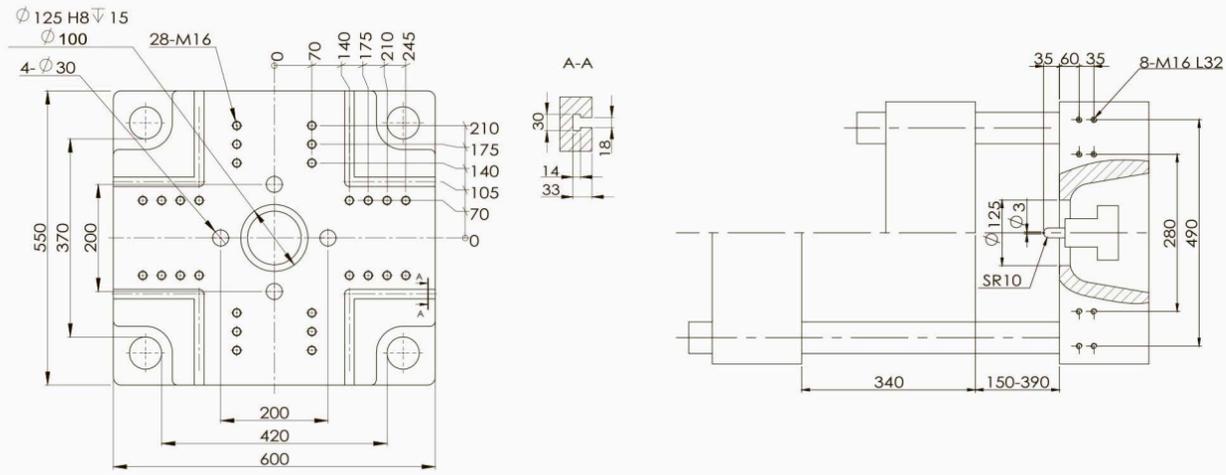


DESCRIPTION	UNIT	F7 9000 - II				F7 11000 - II				F7 13000 - II			
International Size Rating		6800				8490				8490			
Injection Unit		A	B	C	D	A	B	C	D	A	B	C	D
Screw Diameter	mm	90	100	110	120	100	110	120	130	100	110	120	130
Screw L/D Ratio	L/D	24.4	22	20	18.3	24.2	22	20.2	18.6	24.2	22	20.2	18.6
Shot Size (Theoretical)	cm ³	3181	3691	4467	5315	4006	4847	5768	6769	4006	4847	5768	6769
Shot Weight(Ps)	g	2721	3359	4065	4837	3645	4411	5249	6160	3645	4411	5249	6160
Injection Rate	g/s	506.5	625.4	756.7	900.5	625.9	757.3	901.3	1057.7	625.9	757.3	901.3	1057.7
Injection Pressure	Bar	2276	1843	1523	1280	2122	1753	1473	1255	2122	1753	1473	1255
Screw Speed	r/min	105				100				100			
Clamping Unit													
Clamping Force	kN	9000				11000				13000			
Opening Stroke	mm	1130				1230				1320			
Space Between Tie-bars(HxV)	mm	1080 x 1080				1180 x 1180				1250 x 1250			
Max. Mold Height	mm	1100				1200				1300			
Min. Mold Height	mm	450				500				550			
Ejector Stroke	mm	320				320				320			
Ejector Force	kN	215				215				215			
Others													
Pump Motor Power	kW	39.4+39.4				39.4+55.4				39.4+55.4			
Heater Power	kW	70.6				82.8				82.8			
Machine Dimensions(LxWxH)	m	11.2 x 2.5 x 3.3				11.9 x 2.7 x 3.3				12.9 x 2.8 x 3.3			
Machine Weight	t	45				50				61			
Hopper Capacity	kg	100				100				100			
Oil Tank Capacity	L	1000				1150				1150			

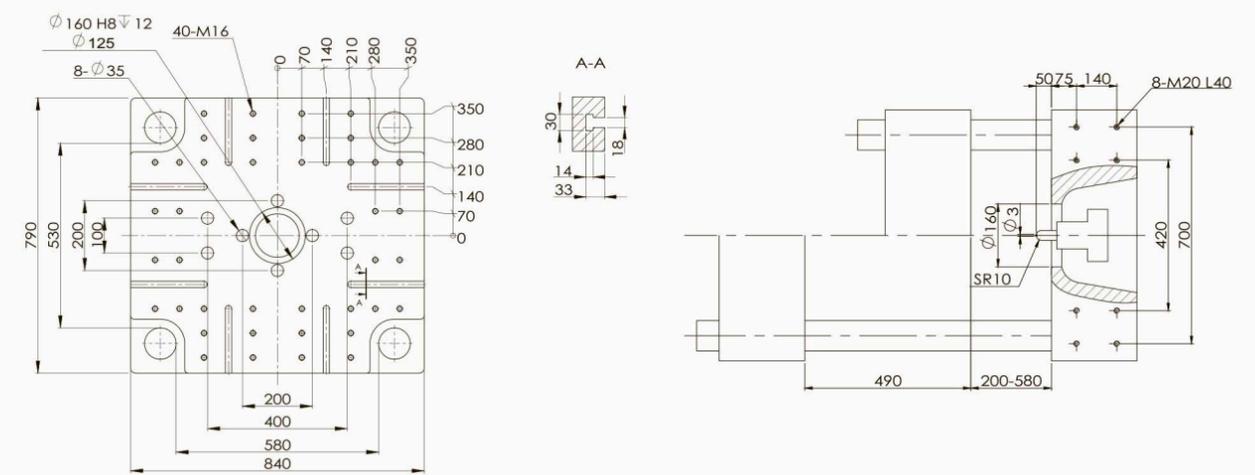
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TEMPLATE DIMENSIONS

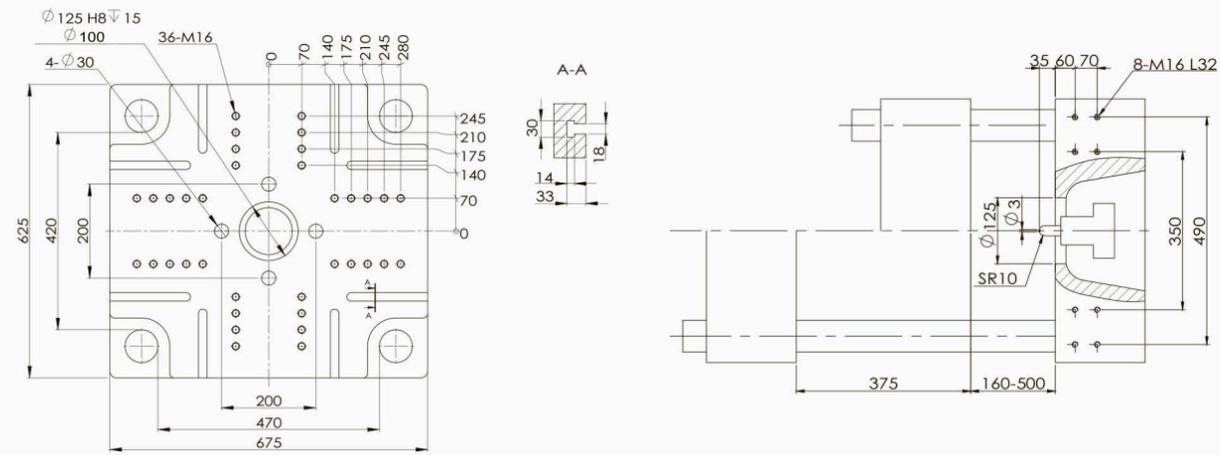
F7 1100 - II



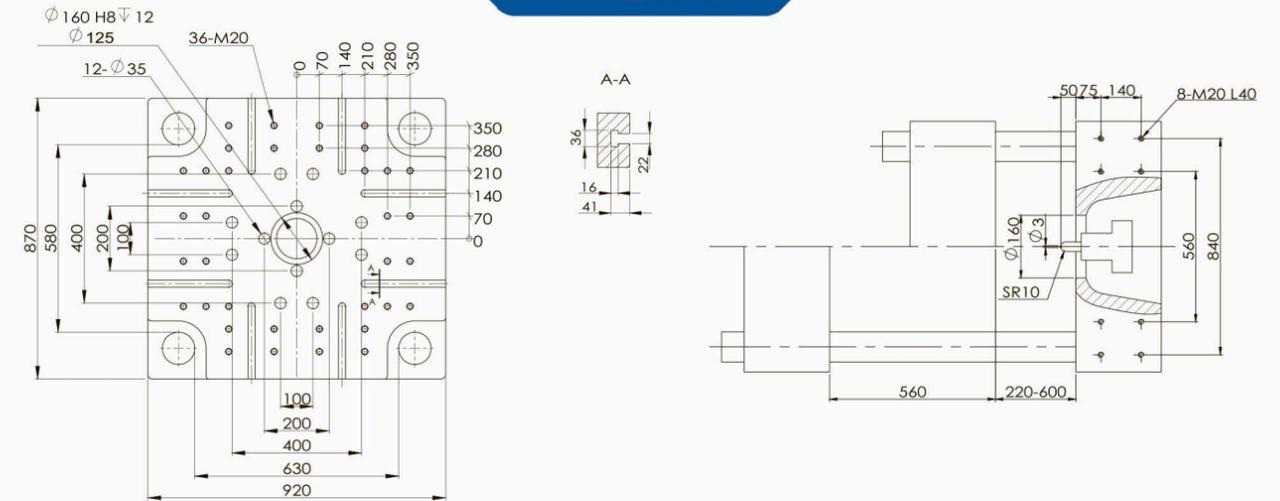
F7 2200 - II



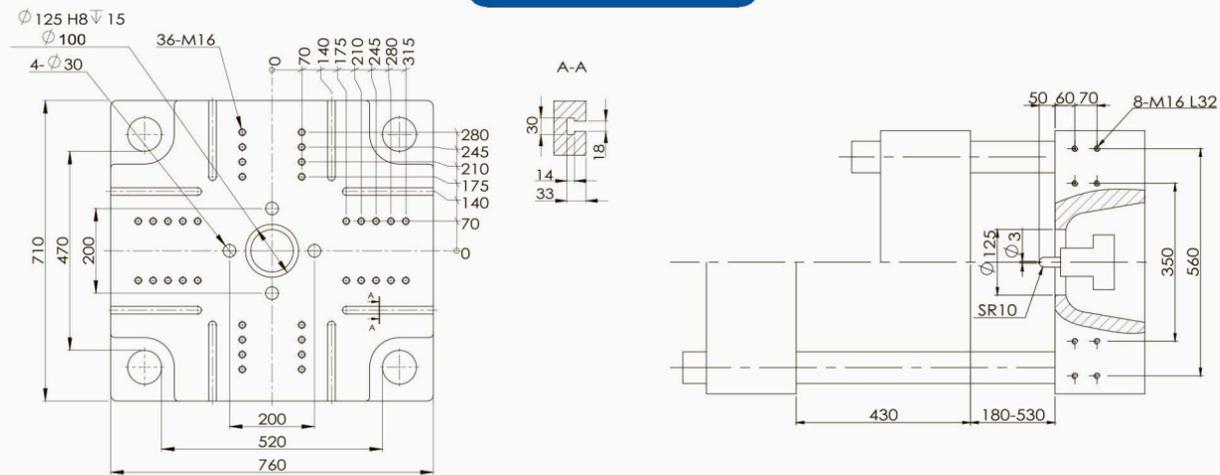
F7 1500 - II



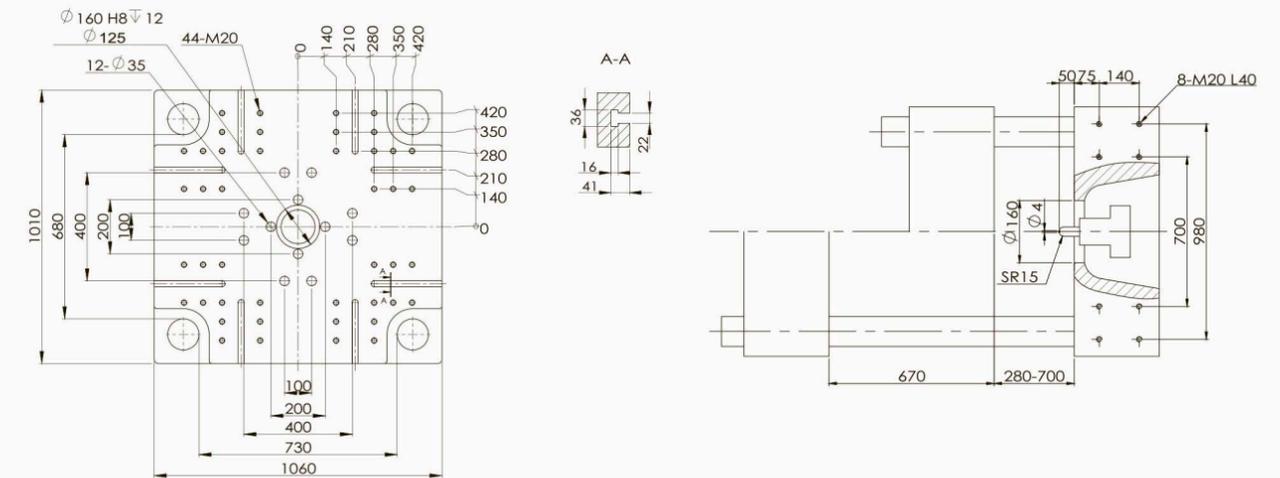
F7 2800 - II



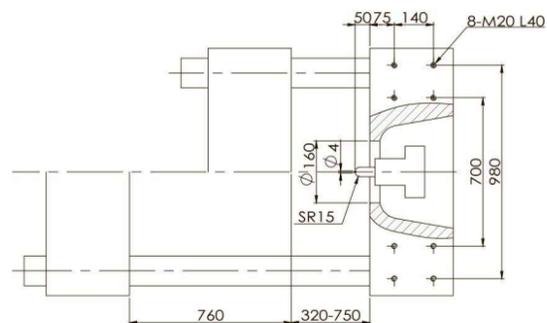
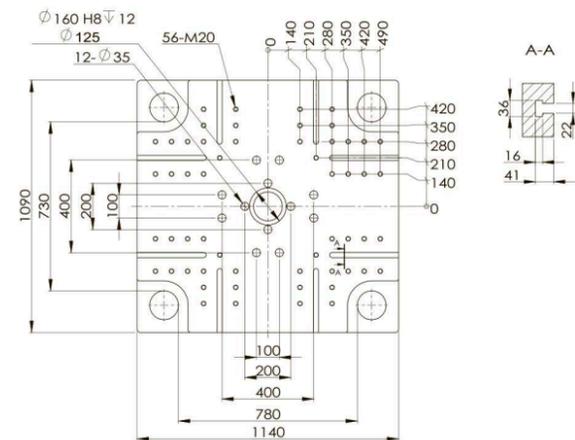
F7 1800 - II



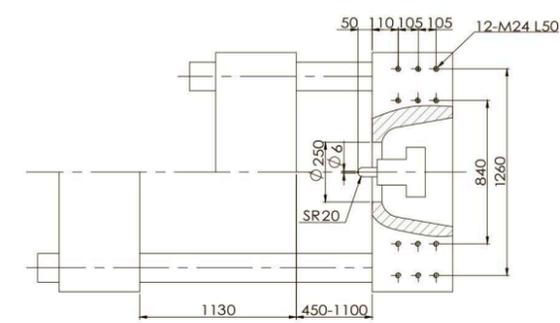
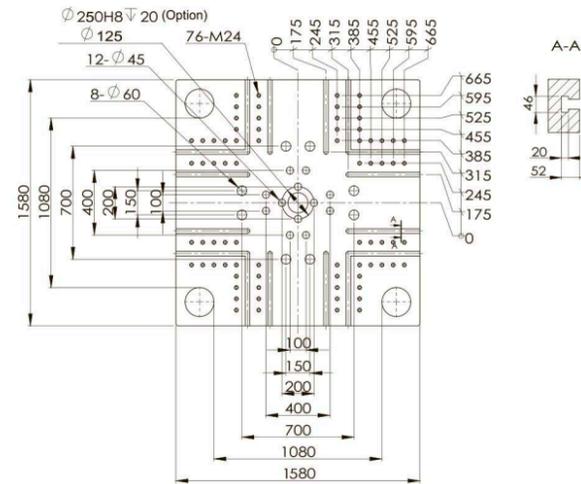
F7 3500 - II



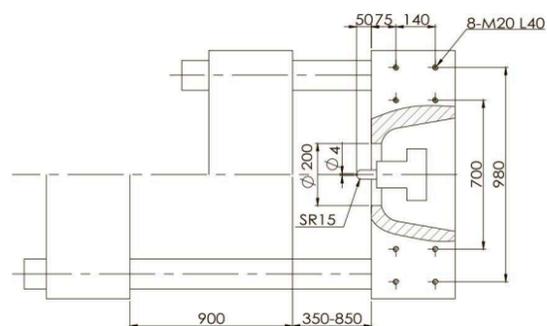
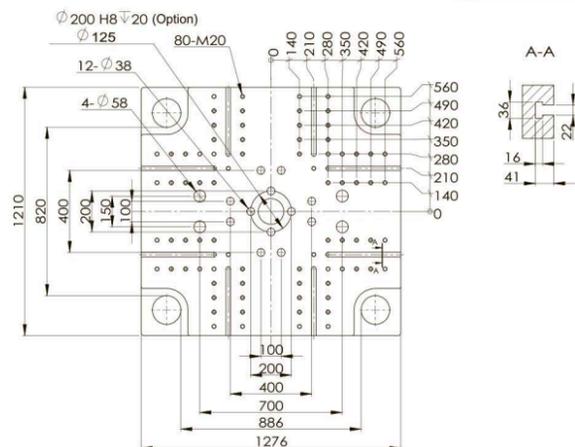
F7 4500 - II



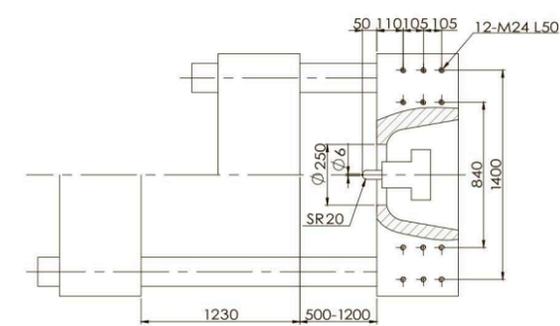
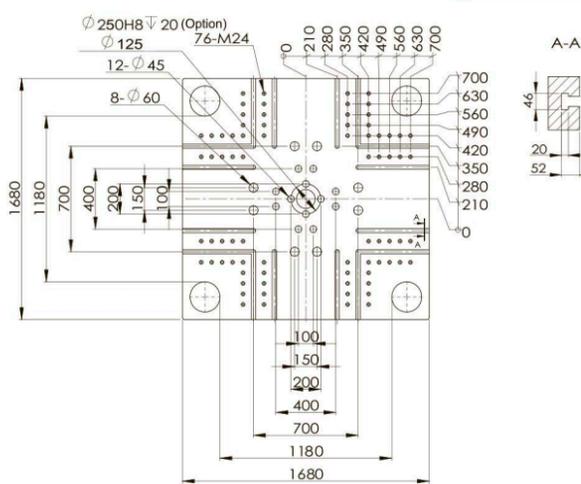
F7 9000 - II



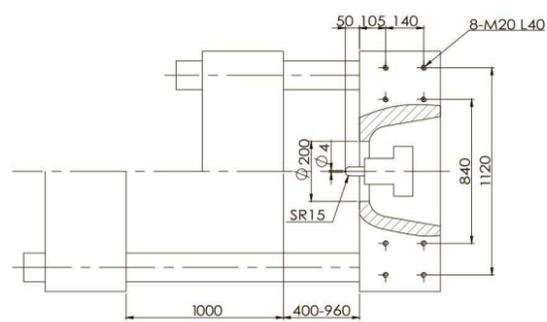
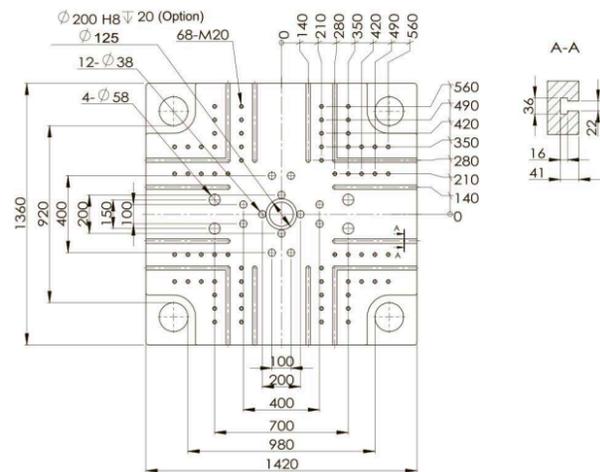
F7 5500 - II



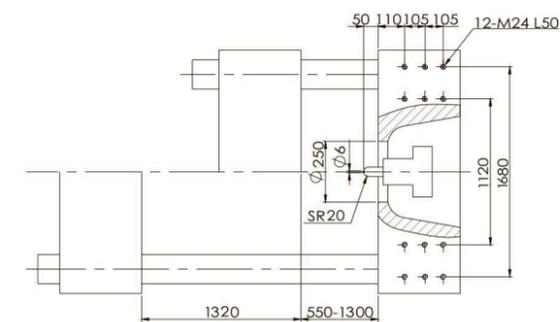
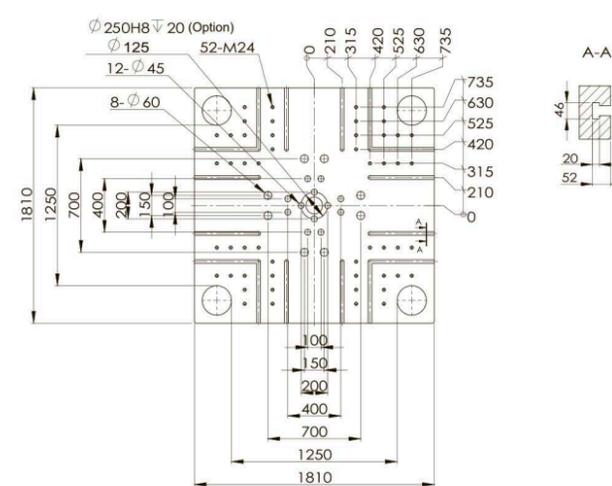
F7 11000 - II



F7 7000 - II



F7 13000 - II





SERVICE EVERYWHERE- OUR IDEOLOGY FOREVER

Service along with IIG F7 actual core business, the manufacture and sales of machines. Marketing competition required increasing and extra value for Clients, service becomes more and more important. IIG F7 services all—around and from beginning to end, we serve to our Clients the complete before-sales consultation, in-sales support and after-sales service. No matter how long your machine used, our services are available throughout the machine's useful life for every client.

Circumspect Technology Team

Leadway technology team is well known more than 20 years in injection molding machine industry, we not only R&D machines which are popular in market, but also use our powerful technology to lead our clients to a higher efficiency, more saving and higher quality manufacturing area.

All—around Consultation Centre

Leadway technology team's core business: help clients to solve problems, provide turn—key projects and make solutions on projects. We analyze all the difficulties and give clients the suitable solutions, recommend clients the suitable machines. The whole solutions from economic and suitable machine, high precise and high efficiency machine to the marketing development trend machine, clients can choose one of them according to their buying ability and necessary.

Fast Service System

With IIG F7 modernized management system, we will try our fastest to inform our cooperation, agency or our frontline service personal the service requests, arrive at the scene at the first time to solve problems.

Considerate Training Service

Each Leadway's cooperation or agency area will offer our user the considerate training service; ensure our clients can comprehensive understanding, proper use and maintenance our machine. Senior engineers from Leadway headquarters will dispatched to visit our clients in fixed time, investigated Clients' use, and upgrade our machine according to clients' feedback, make our machine will be better to meet clients' needs.

Quick Global Delivery

A high quality service always depends on the suitable spare parts' delivery time, Leadway serve to our clients 7 days per week and 24 hours per day. There are enough normal parts stocks in our headquarters and our cooperation and agency area; for special parts, we will accept without delaying a single day, and try our utmost to deliver them, as quickly as possible so as to ensure the speedy restoration of clients' production.