

**DONGXING**  
东星机械

**HONGPAI**  
鸿牌

**DONGXING**  
东星机械

持续创新 永不满足



**AUTOMATIC**



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东莞市东星机械设备有限公司  
Dongguan DongXing machinery equipment co., LTD

## 公司简介 Company Profile

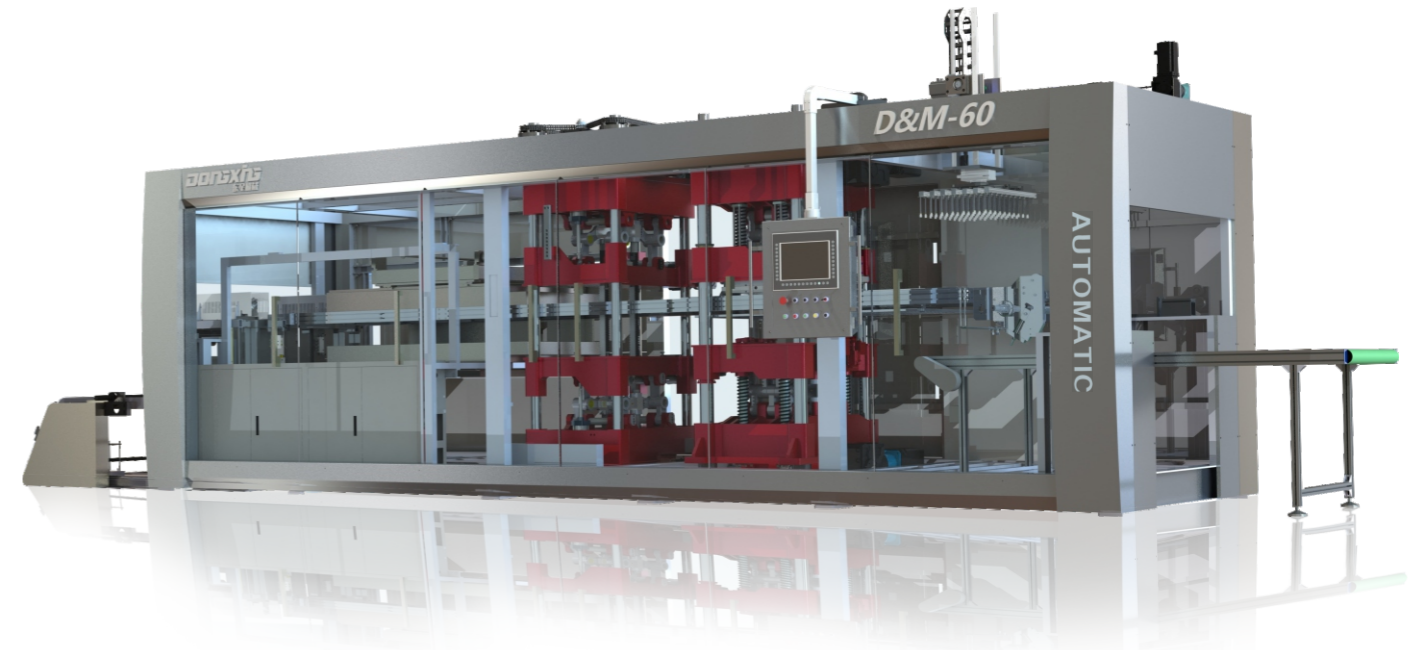
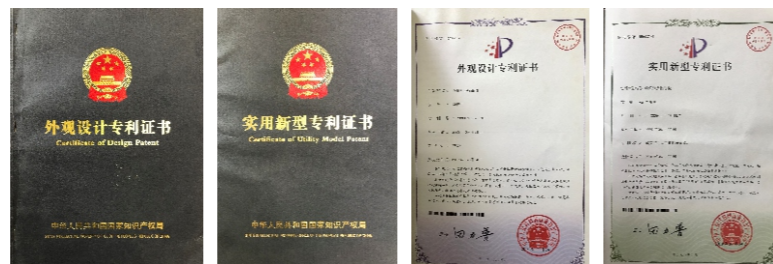
东莞市东星机械设备有限公司是一家致力于各种吸塑成型机的研发、创新、制造的专业化塑料热成型机械设备生产企业。公司位于东莞市桥头镇，毗邻机场、汽车站、货运站，交通十分便利。

结合公司二十多年吸塑机制造经验，开发出拥有自主知识产权的正负压成型冲切堆叠一体机。从上料、正负压成型、冲孔、切边、堆叠、计数、输送、边料自动回收等一系列生产工序一次性完成。公司专业生产正负压热成型一体机、制杯机、伺服驱动高速成型机、普通高速成型机。降低能耗、节约人工成本、减少场地、提高生产品质、做好机械是东星机械的信念。



Dongguan Dongxing Machinery Equipment Co., Ltd. is a professional production enterprise specializing in the R & D, innovation and manufacture of various plastic molding machines. The company is located in Qiaotou town, Dongguan, adjacent to the airport, bus station and freight station. The traffic is very convenient.

Combined with more than 20 years' experience of plastic suction machine manufacturing, we developed a positive and negative pressure forming punching and stacking integrated machine with independent intellectual property rights. From a series of production processes such as charging, positive and negative pressure molding, punching, trimming, stacking, counting, conveying, automatic recovery of materials, etc., a series of production processes are completed at once. The company specializes in producing positive and negative pressure thermoforming machine, cup making machine, servo driven high-speed molding machine and ordinary high-speed molding machine.

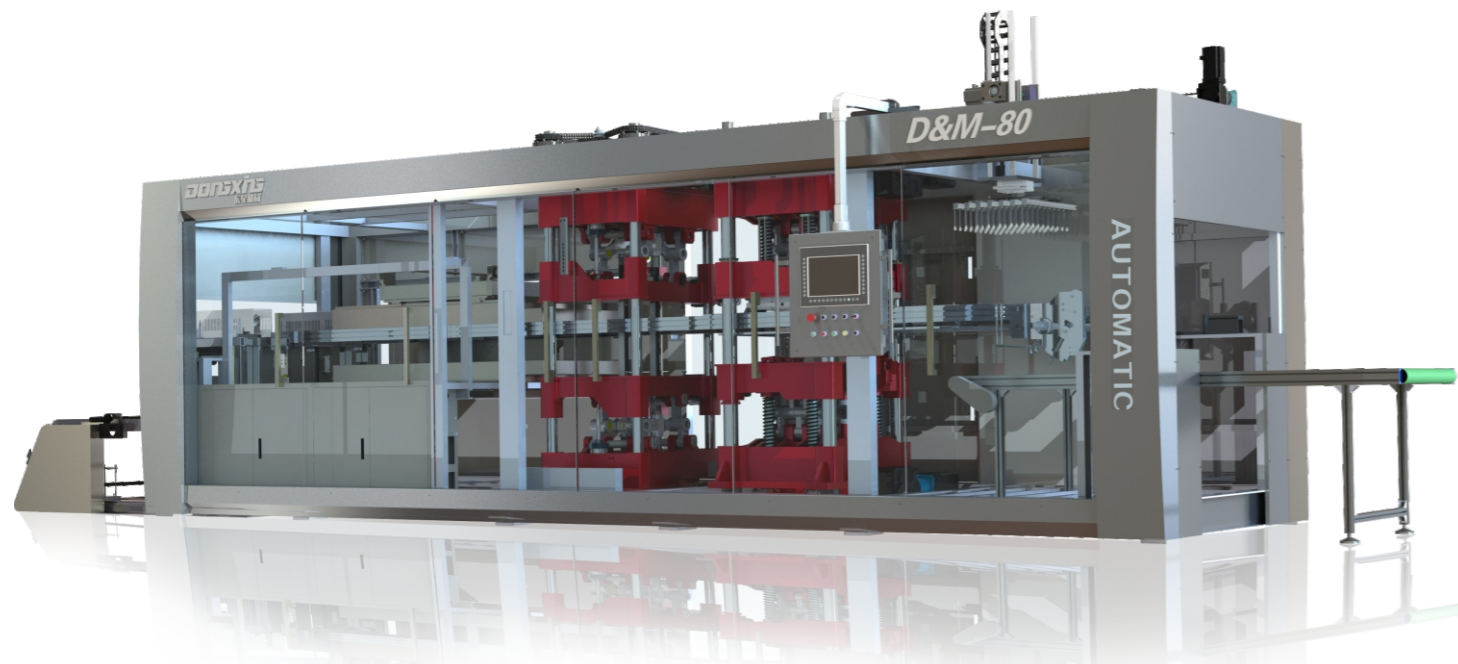


## D&M-60 系列

### 三工位正负压热成型机

### 压空成型裁切、堆叠一体化智能生产线

Parameters参数	D&M-60	Parameters参数	D&M-60
适用原料 Suitable materials	PP,PS,PET,CPET, PVC,OPS,PLA.	成型高度 Formed depth	130mm
成型面积 Formed area	W780×L600mm	加热功率 Heating power	20-55kw
压缩空气压力 Air Pressure	7Bar	额定功率 Rated power	100kw
适用片材宽度 Sheet Width	450-810mm	整机重量 Total weight	14T
适用片材厚度 Sheet Thickness	0.15-2.0mm	外观尺寸 Dimension	L10m×W2.8m×H3m
最小成型模具面积 Min. Formed Area	420×300mm	最大片材料卷径 Max Roll diameter	1000mm
模板行程（下方至上方） Travel depth	150mm	最大空转循环周期 Cycle period	40/min



## D&M-80 系列 三工位正负压热成型机

压空成型裁切、堆叠一体化智能生产线

Parameters参数	D&M-80	Parameters参数	D&M-80
适用原料 Suitable materials	PP,PS,PET,CPET, PVC,OPS,PLA.	成型高度 Formed depth	150mm
成型面积 Formed area	W760×L800mm	加热功率 Heating power	20-55kw
压缩空气压力 Air Pressure	7Bar	额定功率 Rated power	120kw
适用片材宽度 Sheet Width	450-800mm	整机重量 Total weight	16T
适用片材厚度 Sheet Thickness	0.15-2.0mm	外观尺寸 Dimension	L12m×W2.8m×H3m
最小成型模具面积 Min. Formed Area	420×300mm	最大片材料卷径 Max Roll diameter	1000mm
模板行程（下方至上） Travel depth	165mm	最大空转循环周期 Cycle period	40/min

### 智能化系统 Intelligent system

机组采用德国倍福工业PC，结合稳定的伺服系统，无论是加工PP，PET,PS,PVC,PE,OPS,降解材料，还是成型产品的其他材料，我们正负压成型机始终能生产出最好的品质。

The unit adopts German Beckhoff industrial PC, combined with stable and accurate operation Servo system, whether processing PP, pet, PS, PVC, PE, OPS, degradable materials or molding products Other materials, our positive and negative pressure molding machine can always produce Output good quality.



德国倍福 PLC

### 卓越的结构 Excellent structure

成型、裁切工作站的曲臂使用特殊轴承，配合多连杆的结构的应用，更稳定、精准，D&M-80生产效率提升、减少模具制造周期和成本是极为关键的，为客户带来更大优势。

Special bearings are used for the curved arm of the forming and cutting workstation, With the application of multi link structure, it is more stable and precise. Quasi, D & M-80 production efficiency, reduce mold Manufacturing cycle and cost are extremely critical for customers. Bring greater advantages.



伺服控制拉伸头

### 先进的加热系统

#### Advanced temperature control system

独特的控温模块，单独的加热元件控制，响应快，能耗低。

Unique temperature control module, separate heating element control, Fast response and low energy consumption.



瑞士ABB 驱动器

### 自动堆叠多样 Autostack diversity

提供上、下堆叠或机械手模内抓取多样化选择，以适应市场多样化需求。完美的机械堆叠实现了材料到成品包装一体化模式，提升了食品容器的安全卫生，也便于人工装箱作业。

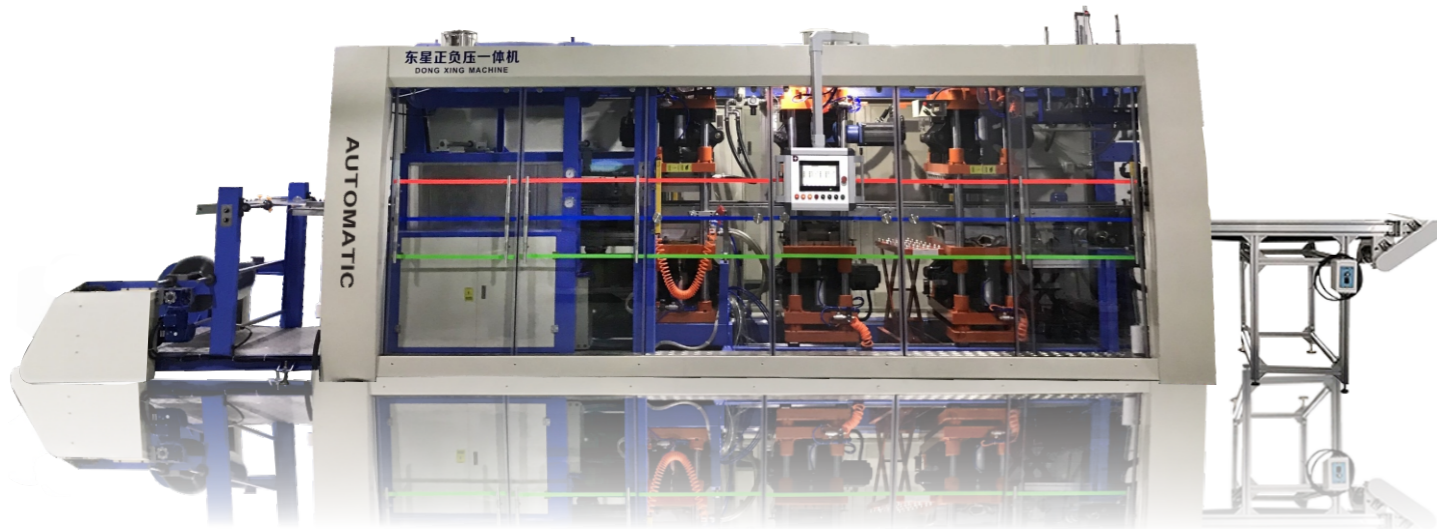
It can be stacked up and down or gripped in the mold by a manipulator To adapt to the diversified needs of the market. The perfect machine Mechanical stacking realizes the integrated mode of material to finished product packaging, The utility model improves the safety and sanitation of the food container, and is convenient for manual operation Packing operation.



数字化温控



自动堆叠多样



## DX-7152

### 小版面-多工位正负压热成型机

Multi Step High-speed Thermoforming Machine

Parameters参数	DX-7152	Parameters参数	DX-7152
适用原料 Suitable materials	PP,PS,PET,PVC, OPS, PLA	成型高度 Formed depth	130mm
成型面积 Formed area	W710 × L520mm	加热功率 Heating power	20-35kw
压缩空气压力 Air Pressure	7Bar	额定功率 Rated power	80kw
适用片材宽度 Sheet Width	450-760mm	整机重量 Total weight	10T
适用片材厚度 Sheet Thickness	0.15-2.0mm	外观尺寸 Dimension	L9m × W2.6m × H2.8m
最小成型模具面积 Min. Formed Area	420 × 300mm	最大片材料卷径 Max Roll diameter	1000mm
模具最大开合行程 Travel depth	150mm	工作效率 Efficiency	30/min

### >>> 适用

本机型适合生产高要求的食品包装类产品：杯盖、生鲜托盘、月饼托、一次性快餐盒、一次性食品盒、方便面碗盖、奶茶杯盖、咖啡杯盖、饮料杯、雪糕杯、果冻杯、包装盒、日用品吸塑包装等包装容器、医疗类吸塑包装、酒类包装、电器类吸塑包装。

### >>> Application

this model is suitable for producing high demand food packaging products: cup cover, fresh tray, moon cake, disposable ast food box, disposable food box, instant noodle bowl cover, milk tea cup lid, coffee cup cover, beverage cup, ice cream cup, jelly cup, packaging box, daily necessities plastic packaging container, medical plastic packaging, wine packaging and electrical plastic packaging.

### >>> 机组优点 Outstanding features

- ※ 机组采用伺服控制系统，结合先进的自动化系统，无论是加工PP,PET,PS,PVC,PE,OPS,降解材料，还是成型产品的其他材料，我们正负压成型机始终能生产出做好的品质。
- ※ 成型站和裁切站的曲臂使用：高效、稳定
- ※ 先进的加热系统，采用先进的控温模块，单独的加热元件控制，响应快，时间短，取得高效性，低能耗
- ※ Machine all uses the servo control system, combined with the advanced automation system, whether it is processing PP, PET, PS, PVC, PE, OPS, degradation material, or other materials of the molding product, our thermoforming machine can always produce the good quality.
- ※ The use of curved arm of the forming station and the cutting station: efficient and stable.
- ※ The advanced heating system adopts advanced temperature control module and independent heating element control, with fast response and short time, achieving high efficiency and low energy consumption.



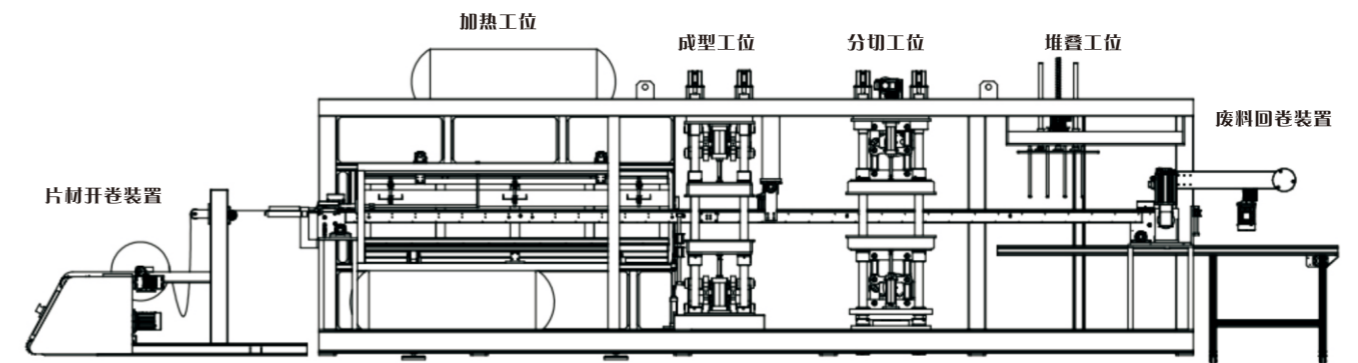


## DX-7185

### 三工位正负压热成型机

Multi Step High-speed Thermoforming Machine

Parameters参数	DX-7185	Parameters参数	DX-7185
适用原料 Suitable materials	PP,PS,PET,PVC, OPS,PLA,CPET	成型高度 Formed depth	150mm
适用片材宽度 Sheet Width	450-760mm	加热功率 Heating power	25-55kw
适用片材厚度 Sheet Thickness	0.15-2.0mm	额定功率 Rated power	120kw
最大成型模具面积 Max. Formed Area	W710 × L850mm	整机重量 Total weight	16T
最小成型模具面积 Min. Formed Area	420 × 300mm	外观尺寸 Dimension	L12m × W2.6m × H2.8m
最大冲切面积 Max.Punching Area	W710 × L850mm	最大片材料卷径 Max Roll diameter	1000mm
成型模具最大开合行程 Travel depth	165mm	工作效率 Efficiency	30/min



#### >>> 机组优点

- ※ 机组采用伺服控制系统，结合先进的自动化系统，无论是加工PP,PET,PS,PVC,PE,OPS,降解材料，还是成型产品的其他材料，我们正负压成型机始终能生产出做好的品质。
- ※ 成型站和裁切站的曲臂使用：高效、稳定
- ※ 先进的加热系统，采用先进的控温模块，单独的加热元件控制，响应快，时间短，取得高效性，低能耗

#### >>> Outstanding features

- ※ Machine all uses the servo control system, combined with the advanced automation system, whether it is processing PP, PET, PS, PVC, PE, OPS, degradation material, or other materials of the molding product, our thermoforming machine can always produce the good quality.
- ※ The use of curved arm of the forming station and the cutting station: efficient and stable.
- ※ The advanced heating system adopts advanced temperature control module and independent heating element control, with fast response and short time, achieving high efficiency and low energy consumption.

#### >>> 适用

本机型适合生产高要求的食品包装类产品：杯盖、生鲜托盘、月饼托、一次性快餐盒、一次性食品盒、方便面碗盖、奶茶杯盖、咖啡杯盖、饮料杯、雪糕杯、果冻杯、包装盒、日用品吸塑包装等包装容器、医疗类吸塑包装、酒类包装、电器类吸塑包装。

#### >>> Application

this model is suitable for producing high demand food packaging products: cup cover, fresh tray, moon cake, disposable fast food box, disposable food box, instant noodle bowl cover, milk tea cup lid, coffee cup cover, beverage cup, ice cream cup, jelly cup, packaging box, daily necessities plastic packaging container, medical plastic packaging, wine packaging and electrical plastic packaging.





## DXM-72 模内切热成型机

压空成型裁切、堆叠一体化智能生产线

### 技术数据

Parameters参数	DXM-72	Parameters参数	DXM-72
适用原料 Suitable materials	PP,PS,PET,CPET, PVC,OPS,PLA.	成型高度 Formed depth	120mm
成型面积 Formed area	L720 × W720mm	加热功率 Heating power	20-55kw
压缩空气压力 Air Pressure	7Bar	额定功率 Rated power	100kw
适用片材宽度 Sheet Width	450-760mm	整机重量 Total weight	10,000kg
适用片材厚度 Sheet Thickness	0.15-2.0mm	外观尺寸 Dimension	L9m × W2.6m × H2.8m
最小成型模具面积 Min. Formed Area	420 × 300mm	最大片材料卷径 Max Roll diameter	1000mm
模具最大开合行程 Travel depth	150mm	工作效率 Efficiency	30/min

### 智能化系统 Servo PLC System

机组全部采用伺服控制系统，结合先进的自动化系统，无论是加工PP, PET,PS,PVC,PE,OPS,降解材料，还是成型产品的其他材料，我们正负压成型机始终能生产出最好的品质。

All units adopt servo control system, combined with advanced automation system, whether it is processing PP, PET, PS, PVC, PE, OPS, degradable materials, or other materials of forming products, our forming machine can always produce good quality.

### 卓越结构 Excellent Structure

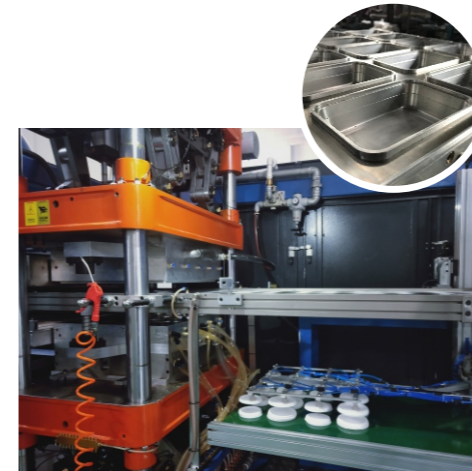
模内切工作站的曲臂使用特殊轴承，配合高精度、稳定的钢刀裁切微调系统，适应多样化的生产需求，DXM-72的效率提升、减少模具制造周期和成本是极为关键的，伺服驱动凸轮结构更稳定、精准为客户带来优势。

The crankshaft of die-cutting workstation uses special bearings, cooperates with high precision and stable steel knife cutting fine-tuning system, can adapt to diverse production needs, servo-driven cam structure is more stable and accurate, DXM-72 production efficiency is improved, reducing die manufacturing cycle and cost is extremely critical, which brings greater advantages to customers.

### 自动堆叠技术 Automatic Stacking

采用了下堆叠和机械手模内抓取两用的堆叠站，适应市场多样化需求。完美的机械堆叠实现了材料到成品包装一体化模式，提升了食品容器的安全卫生，也便于人工装箱作业。

In order to meet the diversified demands of the market, a stacking station with two functions of bottom stacking and grasping in the manipulator model is adopted.



凸轮拉杆结构



两种堆叠结构可以选用



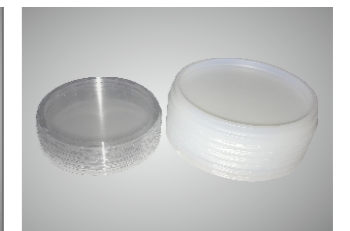
各种食品包装



海鲜盒



蔬果生鲜托盘



各种造型盖子



## DX-FY7190 负压三工位热成型机

High-speed Thermoforming Machine

Parameters参数	DX-FY7190
适用原料 Suitable materials	PP, PS, PET, PVC, PLA等
成型面积 Formed area	W710mmxL900mm
适用材料宽度 Sheet Width	450-760mm
适用片材厚度 Sheet Thickness	0.15-2.0mm
裁切方式 Cutting	伺服裁切

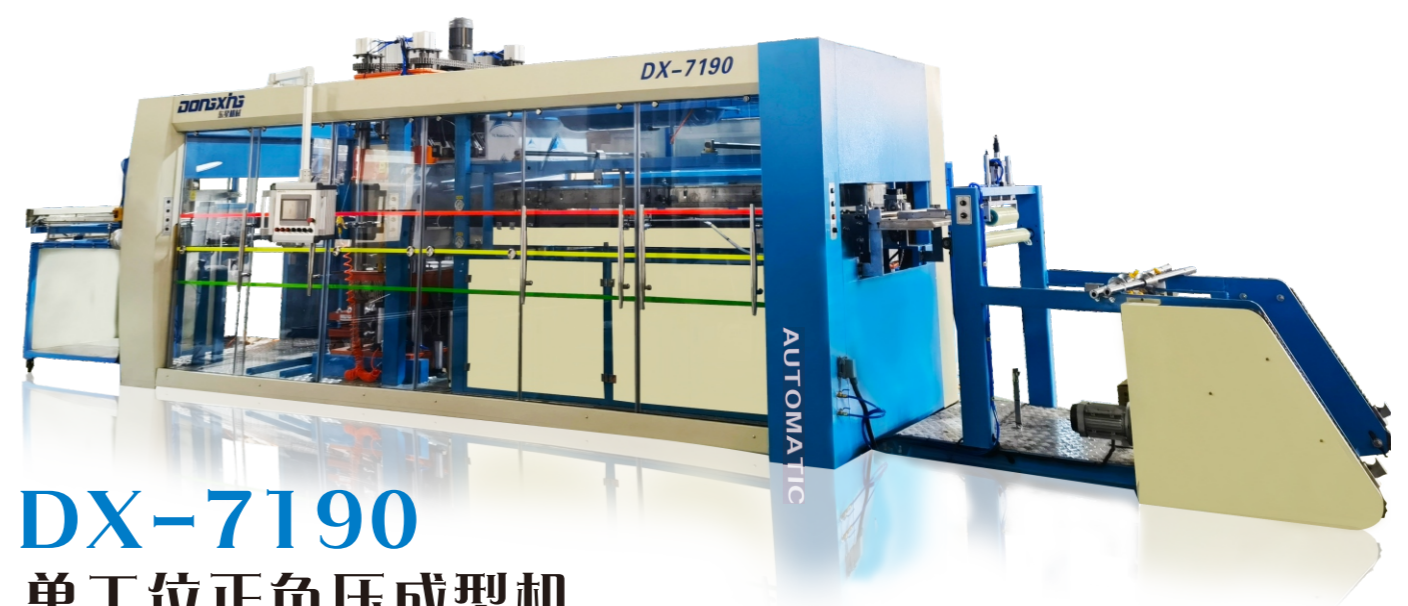
### >>> 机组优点

- ※ 成型站上下模、冲切站上下模 伺服电机驱动
- ※ 节约模具成本：710\*900mm大版面适用普通吸塑模具
- ※ 数字化温控双段加热
- ※ 适用普通激光刀模
- ※ 多样化机械手：模内抓取式机械手或往下打料堆叠

Parameters参数	DX-FY7190
成型高度 Formed depth	150mm
额定功率 Rated power	80KW
整机重量 Total weight	10T
外观尺寸 Dimension	L8mxW2.6mxH2.8m
裁切压力 Cutting pressure	80T

### >>> Outstanding features

- ※ Forming station, punching station servo motor drive
- ※ Save mold cost: 710 \* 900mm large layout is suitable for ordinary blister mold
- ※ Digital temperature control double stage heating
- ※ Suitable for common laser knife mold
- ※ Diversified manipulator: in mold grasping manipulator or downward material stacking manipulator



## DX-7190 单工位正负压成型机

Thermoforming

Parameters参数	DX-7190
适用原料 Suitable materials	PP,PS,PET,PVC, PLA等
成型面积 Formed area	W710mmxL900mm
适用材料宽度 Sheet Width	450-760mm
适用片材厚度 Sheet Thickness	0.15-2.0mm

### >>> 机组优点

- ※ 大版面正负压成型
- ※ 成型上下模伺服控制
- ※ 三段上下炉烤片
- ※ 数字化一对一精准温度控制（温度差±0.5度）
- ※ 正负压高速成型、制品精美

Parameters参数	DX-7190
成型高度 Formed depth	150mm
额定功率 Rated power	80KW
整机重量 Total weight	10T
外观尺寸 Dimension	L8mxW2.6mxH2.8m

### >>> Outstanding features

- ※ AIR pressure and vacuum forming of large layout
- ※ Servo control of upper and lower mould
- ※ Three stage baking
- ※ Digital one-to-one precise temperature control (temperature difference ± 0.5 degrees)
- ※ Positive and negative pressure high speed molding, exquisite products



## 伺服驱动真空吸塑成型机

Series Automatic High-speed Vacuum Forming Machine



Parameters 参数		DGD-1220
成型长度	Formed length	1220mm
成型宽度	Formed width	410mm-710mm (配备自动伸缩底盘)
成型高度	Formed depth	200mm
成型厚度	Sheet Thickness	0.15mm-3.0mm
热炉模式	Heating	上下炉(炉长1280mm)加温烤片单炉侧退
使用电源	Suitable Power	380V / 50HZ
整机功率	Installed Power	30KW
整机尺寸	Dimension	L7500mm*W1800mm*H2680mm
整机重量	Total weight	3500KG

### >>> 机组优点

- ※ 本机采用PLC控制系统，伺服驱动上下模盘、伺服送片更稳定精准。
- ※ 高清工业触摸屏显示作为人机界面，所有参数设置均在触摸屏上监视运行情况。
- ※ 设备具有故障诊断功能，实时显示故障信息，易于操作和维护
- ※ 设备可以储存若干个产品参数，生产不同产品时调试快捷。

### >>> Outstanding features

- ※ The PLC control system is adopted. The servo drives the upper and lower die plates, and the servo sending pieces are more stable and precise.
- ※ HD industrial touchscreen display as human-machine interface, all parameter settings are monitored on the touchscreen.
- ※ Machine has the function of fault diagnosis, real-time display of fault information, easy operation and maintenance.
- ※ Machine can store several product parameters, and debug quickly when producing different products.

## 塑片气压热成型机

Full-automatic Thermoforming Machine



Parameters 参数		750 制杯机
适应物料	Suitable materials	PP、PS、PET、PVC、ABS、降解材料等
适用片材厚度	Sheet Thickness	0.3-2.0mm
适用片材宽度	Sheet Width	750mm
最大模台面积	Max. Formed Area	750 × 520mm
最大成型深度	Formed depth	≤ 180mm
工作功率	Efficiency	≤ 30模次/分钟
加热额定功率	Heating power	100kw
使用电源	Suitable Power	三相 380V
耗气量	Max consumed air	4000 ~ 5000 L/min
耗水量	Max consumed water	40-50L/min
整机重量	Total weight	6000kg



### >>> 机组优点

- ※ 机器运作操作由plc & C触摸屏控制
- ※ 模具采用四导柱控制精度
- ※ 温控模块控制各个温区
- ※ 操作简单，性能可靠、低噪音，高质量

### >>> Outstanding features

- ※ Machine Operation Is Controlled By Plc & Touch Screen.
- ※ Adopt Four Pillars To Fix Mold,ensure Whole Machine Precision.
- ※ Temperature Control Modules To Control Each Temperature Area.
- ※ Cpmvenient Peration,outstanding Performance,low Noise And High Quality.