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# Used AOKI SBIII-250LL-50S - Year 2016

| | |
|---|---|
| **Machine type:** | Injection Molding Machine |
| **Ref:** | PR30 |
| **Model:** | AOKI-250LL-50S |
| **Year:** | 2016 |
| **Condition:** | Ready for Operation |
| **Formats:** | 2 L, 3 L, 5 L |
| **Containers:** | PET |

## Technical details

| | | | |
|---|---|---|---|
| No. of cavities: | 4 | Neck type: | 60 mm neck diameter |
| Safety features: | Yes | Manuals: | Yes |
| Width: | 2100 mm | Length: | 5340 mm |
| Height: | 3410 mm | Weight: | 10650 kg |
| Power: | 75 kW | Voltage: | 380 V |
| Frequency: | 60 Hz | Ampere: | 143 A |

## Description

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### Technical Specifications & Performance Data

The AOKI-250LL-50S is a four-cavity injection stretch-blow molding machine with Direct Heatcon technology, manufactured by Aoki Technical Laboratory, Inc. in 2016. Designed for integrated preform injection and stretch-blow molding, this industrial packaging machine supports the production of plastic containers in a compact, controlled process.

- **Configuration:** 4 cavities
- **Injection capacity:** 386.0 $cm^3$/shot
- **Injection pressure:** 121.0 MPa
- **Injection rate:** 204.2 $cm^3$/sec
- **Injection mold clamping force:** 490.6 kN
- **Blow mold clamping force:** 297.2 kN

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- **Maximum preform length below neck:** 160 mm
- **Dimensions with safety doors closed:** 5,340 × 2,100 × 3,410 mm
- **Machine weight:** approximately 10,650 kg

In its four-cavity configuration, the machine is suited to containers with an approximate capacity of up to 2.0L, with an example neck diameter of 60 mm, body diameter of 100 mm, and height of 335 mm. The documented product-range examples extend from approximately 0.12L to 5.0L across alternative cavity configurations.

## Advanced Automation & Control Systems

The machine operates from a 3-phase 380 V, 60 Hz electrical supply, with total installed power of 75.0 kW and current of 143 A. Its injection system incorporates a 64 mm screw, 120 mm screw stroke, maximum screw speed of 127 $min^{-1}$, and an AC servo-motor rated at 4 kW.

- Pump motor: 37 kW
- Barrel heater: 23.415 kW
- Hot runner heater: 8.41 kW
- Nozzle touch force: 18.5 kN
- Safety-door enclosed operating footprint

The combined injection and blow-molding arrangement supports repeatable container forming while reducing intermediate preform handling. Machines of this type are well suited to automated industrial packaging environments where process consistency and coordinated mold operation are required.

## Production Line Integration Capabilities

This Aoki injection stretch-blow molding machine can operate as a dedicated container-production asset within a used bottling line or as part of a broader beverage production and industrial packaging facility. It produces molded plastic containers directly from resin, supporting downstream filling, capping, labeling, and secondary packaging operations.

Integration planning should account for molded-container transfer, production balancing with downstream bottling equipment, and mold compatibility for the intended neck finish and container geometry. The 4-cavity configuration is documented for approximately 2.0L containers, while the machine category offers flexibility through appropriate mold tooling.

## Machine Condition & Maintenance History

Manufactured in November 2016, this second hand Aoki machine is identified as AOKI-250LL-50S. The documented machine identification plate indicates CE marking. Installation planning should include a complete operational inspection, verification of utility connections, and confirmation of mold, heating, hydraulic, pneumatic, and cooling-system condition before commissioning.

## Operational Performance & Versatility

The direct injection stretch-blow process combines preform injection, conditioning, stretching, and blow molding in one machine platform. This configuration is suited to the efficient manufacture of plastic containers for beverage production

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and other industrial packaging applications where container quality, dimensional repeatability, and neck-finish control are important.

The injection unit delivers 389.3 kN injection force, while the blow section provides 3.0 MPa blow-air pressure. Blow mold clamping stroke is 65 mm in each direction, and lip mold stroke is 20 mm in each direction. These operating characteristics support coordinated mold movement throughout the forming cycle.

## Installation Requirements & Site Preparation

Site preparation should provide sufficient space for the 5,340 × 2,100 × 3,410 mm machine envelope, safety-door access, mold handling, maintenance access, and material supply. The machine requires 3-phase electrical power at 380 V and 60 Hz, pneumatic pressure of 3.0 MPa, operating air pressure of 0.96–0.98 MPa, and water supply pressure of 0.3 MPa.

- Hydraulic system maximum pressure: 17.5 MPa
- Hydraulic oil volume: 640 L
- Operating air volume: 460 NL/min
- Cooling-water requirement: 63.5 L/min
- Associated air-cooled condenser capacity: 10 RT
- Refrigerant: R-22

A stable installation surface, appropriate drainage, ventilation around the condenser, and unobstructed airflow to condenser fins are important for reliable operation.

## Safety Standards & Compliance Certification

The machine is identified with CE marking and is specified with safety doors enclosing the stated machine dimensions. Safe operation requires maintained guards, correctly functioning interlocks, suitable electrical grounding, protected access to moving mold sections, and controlled handling of hydraulic, pneumatic, and heated components.

For bottling equipment and industrial packaging installations, commissioning should include inspection of emergency-stop functions, electrical protection, safety-door operation, hydraulic connections, compressed-air connections, cooling-water circuits, and condenser airflow clearance.