

DK 系列

BOLE 伯乐智能
BOLE Intelligent Machinery

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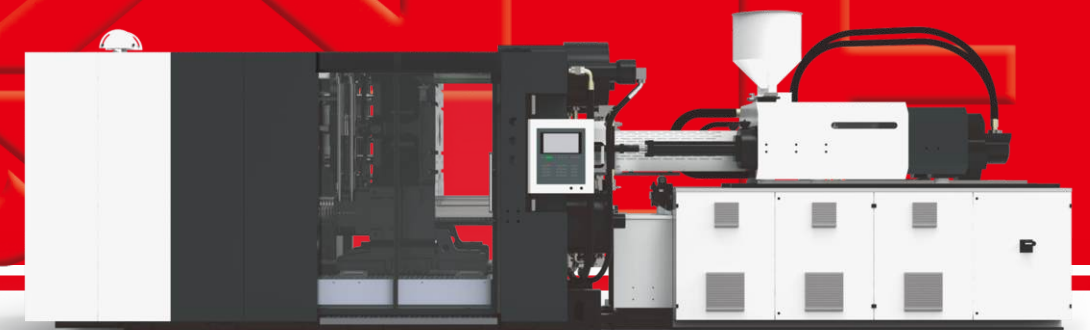
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DK-C系列 二板机 Two Platen Injection Moulding Machine

来自德国 匠心之作
German Origin



BOLE 伯乐智能
BOLE Intelligent Machinery

DK-C系列二板式注塑机



来自德国 匠心之作
German Origin



高效



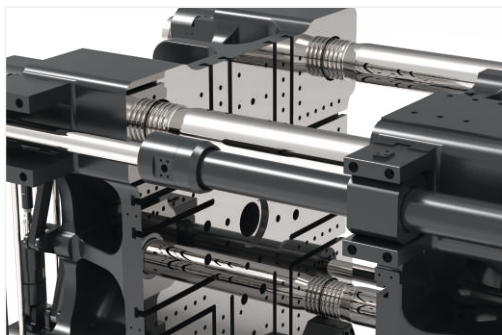
稳定



节能



精密



抗折断拉杆

- 专利的抗折断拉杆设计, 消除应力集中点, 减少拉杆集中受力点的风险, 从而有效降低断裂风险。

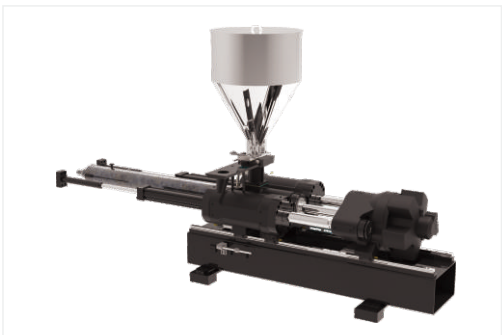
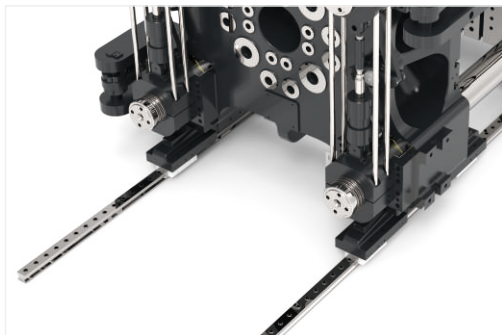
德国设计的塑化系统

- 源自德国设计的塑化系统: 塑化效率远超国内水平20%以上 (ABS、PS、PP等常用塑料); 可定制各种复杂工艺要求、各种应用要求的专用塑化系统; 所有机型A/B/C螺杆长径比都采用23:1, 以保证每一型螺杆都能达最佳塑化效果及塑化效率。



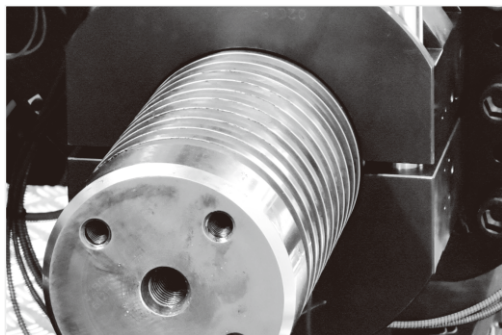
锁模采用线性导轨

- 采用高精度、高强度线轨配合滑脚支撑动模板, 保证模板高平行度, 重复定位精度; 线轨的低阻力、低能耗, 可使开合模更平稳、快速, 同时免除润滑液飞溅问题, 从而使整机运行更平稳、快速。



独特的注射油缸设计

- 独特的注射油缸设计, 使回油阻力接近零点, 同时结合线性滑轨的射台结构, 有效减少注射部分的摩擦力, 使注射单元控制精度及稳定性大幅提升, 远超国内其他品牌。

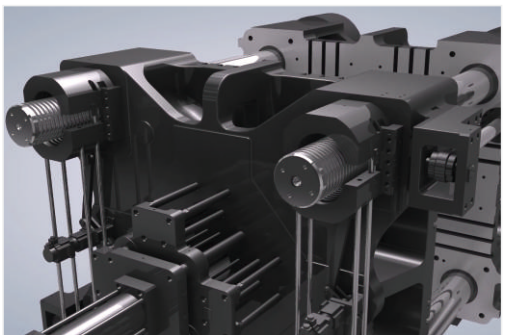


变距螺牙抱闸螺母

- 采用变距螺牙抱闸螺母设计, 使螺牙受力均匀, 确保拉杆使用寿命长。

快速平稳的抱闸系统

- 精确平稳, 高效节能; 闭环控制, 快速精确; 左右独立控制, 稳定可靠; 维护简便, 清洁无渍。



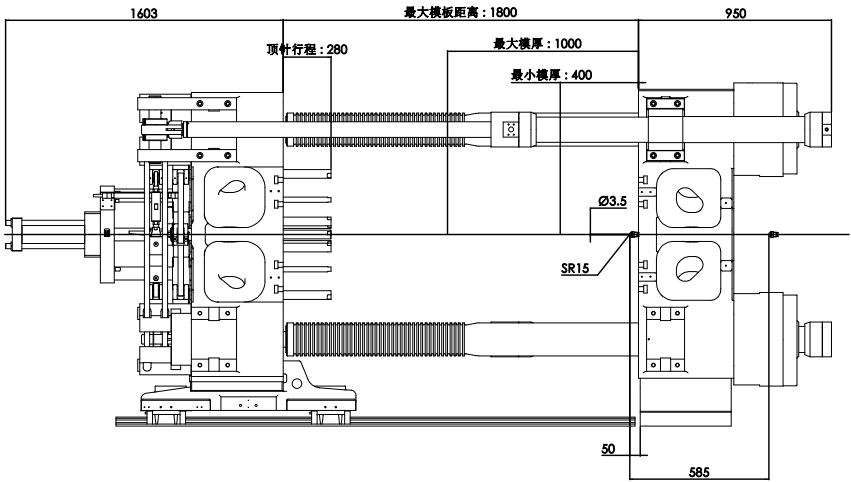
技术参数 Technical Data

		BL850DK-C			BL1050DK-C			BL1300DK-C			BL1600DK-C			
		BL850DK-C/C4800			BL1050DK-C/C5900			BL1300DK-C/C7900			BL1600DK-C/C13400			
注射部分 Injection Unit														
公称射胶能力			C4800			C5900			C7900			C13400		
螺杆直径 Screw diameter	mm	80	85	90	80	90	100	90	100	110	110	120	130	
螺杆长径比 Screw L/D ratio		23	23	21	23	23	19	23	23	19	23	23	19.4	
理论注射容积 Calculated injection volume	cm³	2286	2581	2893	2512	3179	3925	3467	4280	5180	6082	7238	8495	
注射重量,PS Shot weight,PS	g	2103	2374	2662	2311	2925	3611	3189	3938	4765	5596	6659	7815	
	oz	74	84	94	82	103	127	112	138	168	197	235	276	
注射速度 Injection piston speed	mm/s	116			112			104			102			
注射速率 Injection rate	cm³/s	583	659	738	563	712	879	666	822	995	969	1153	1353	
	g/s	536	599	672	517	655	809	612	756	915	891	1060	1245	
注射压力 Injection pressure	MPa	210	186	166	230	182	147	230	186	154	221	186	158	
螺杆转速 Screw speed	r/min	140			135			120			100			
锁模部分 Clamping Unit														
锁模力 Clamping force	Ton	867			1071			1327			1633			
	kN	8500			10500			13000			16000			
模板尺寸(hxv) Size of mould platens(h x v)	mm × mm	1510×1380			1720×1570			1985×1725			2190×2070			
拉杆内间距 Clearance between tie bars (h x v)	mm × mm	1110×960			1260×1020			1420×1160			1520×1360			
开模行程1) Opening stroke	mm	1400/800			1600/950			2270/1500			2200/1500			
最小模具厚度 Mould height min.	mm	400			450			580			650			
最大模具厚度 Mould height max.	mm	1000			1100			1350			1350			
最大模板距离 Max. daylight	mm	1800			2050			2850			2850			
顶出行程 Ejector stroke	mm	280			280			320			360			
顶出力 Ejector force forward	kN	232			232			232			309			
顶针回缩力 Ejector force backward	kN	155			155			155			210			
顶出杆数 Number of ejector rods	PC	17			17			25			25			
动力电热 Driving and Heating														
电热功率 Installed heating power	kW	36	38.3	38.3	43	48.5	48.5	50	54.2	54.2	70	72	72	
电机功率 Drive power	kW	37+37			47+37			65+47			75+47			
系统压力 Working pressure	MPa	17.5			17.5			17.5			17.5			
其他 Other														
油箱容积 Oil tank capacity	L	800			900			1100			1300			
最大模具重量 Maximum mould weight	kg	9500			12000			15000			21000			
整机尺寸(LxWxH) Machine dimensions (LxWxH)	m × m × m	8.35×2.93×2.95			9.15×3.19×3.13			10.78×3.52×3.2			11.53×3.74×3.81			

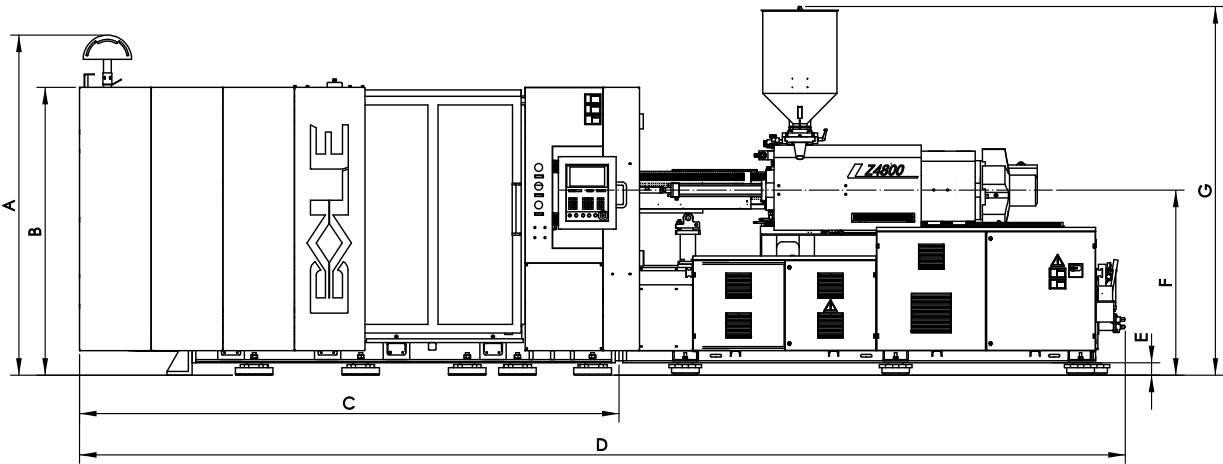
BL1850DK-C			BL2200DK-C			BL2500DK-C		BL2800DK-C		BL3300DK-C	
BL1850DK-C/C17100			BL2200DK-C/C25000			BL2500DK-C/C36000		BL2800DK-C/C36000		BL3300DK-C/C57000	
C17100			C25000			C36000		C36000		C57000	
130	140	150	140	150	160	160	180	160	180	190	210
23	21	19.6	24	22.4	21	23.6	21	23.6	21	23	21
9021	10462	12011	14155	16250	18488	22508	28486	22508	28486	36840	45004
8300	9625	11050	13023	14950	17009	20707	26207	20707	26207	33893	41404
293	340	390	460	528	601	731	926	731	926	1197	1463
104			97			102		102		81	
1378	1598	1834	1489	1710	1945	2048	2592	2048	2592	2290	2797
1254	1454	1669	1355	1556	1770	1864	2359	1864	2359	2083	2545
191	164	143	176	154	135	158	125	158	125	153	125
110			86			72		72		63	
1888			2245			2551		2857		3367	
18500			22000			25000		28000		33000	
2300×2200			2500×2160			2660×2430		2760×2460		2850×2600	
1660×1560			1850×1510			1920×1700		2010×1710		2155×1825	
2570/1700			2580/1700			2720/1800		2920/1900		3220/2200	
680			720			780		880		980	
1550			1600			1700		1800		2000	
3250			3300			3500		3700		4200	
400			450			450		500		550	
309			496			465		465		465	
210			396			310		310		310	
25			25			25		29		29	
76			80			118.5		118.5		191.5	
75+37+47			118+47			118+47+47		118+47+47		118+47+47	
17.5			17.5			17.5		17.5		17.5	
1600			1800			2000		2000		2000	
35000			42000			50000		60000		70000	
13.23×4.05×4.11			13.41×4.26×4.20			14.77×4.31×4.20		15.57×4.46×4.41		16.91×4.8×4.69	

模板尺寸&机器尺寸

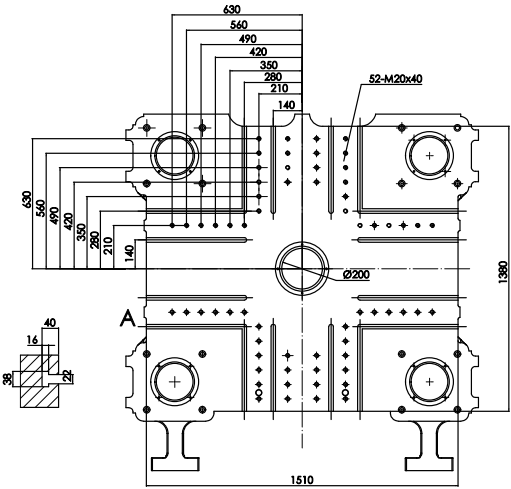
合模装置
Clamping unit



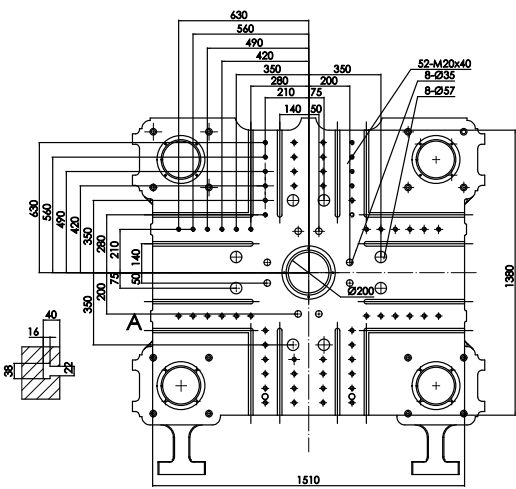
主视图
main view



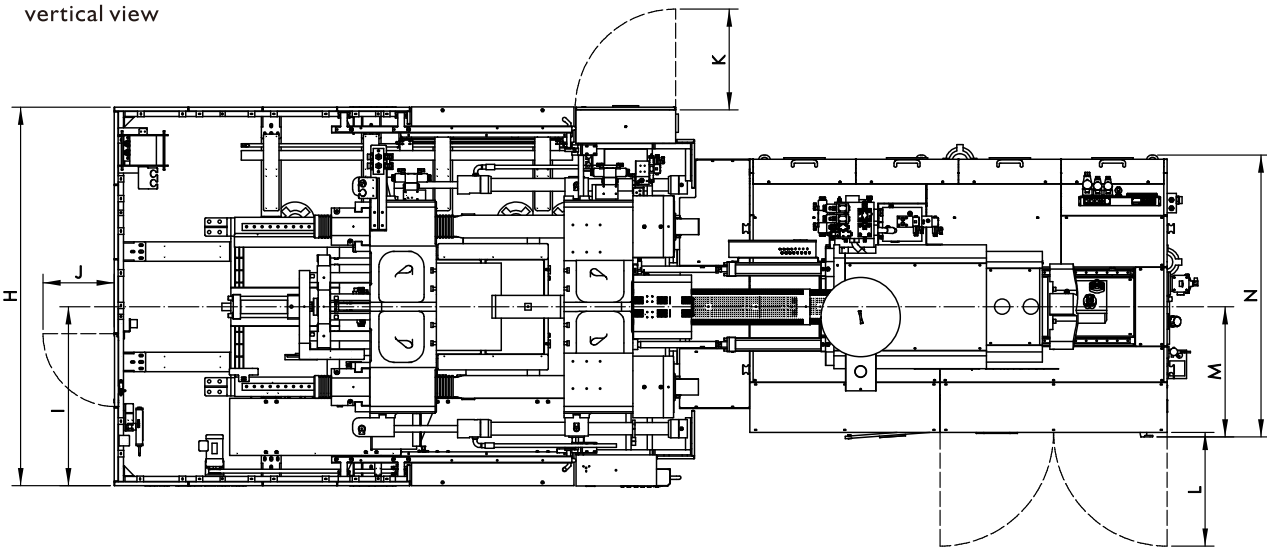
固定模板正面尺寸
Dimensions of stationary platen



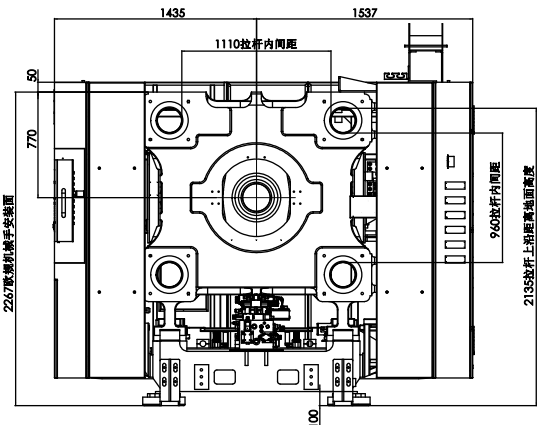
移动模板正面尺寸
Dimensions of moving platen



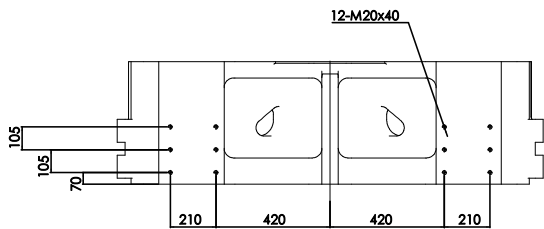
俯视图
vertical view



机器人安装尺寸
Robot installation dimensions



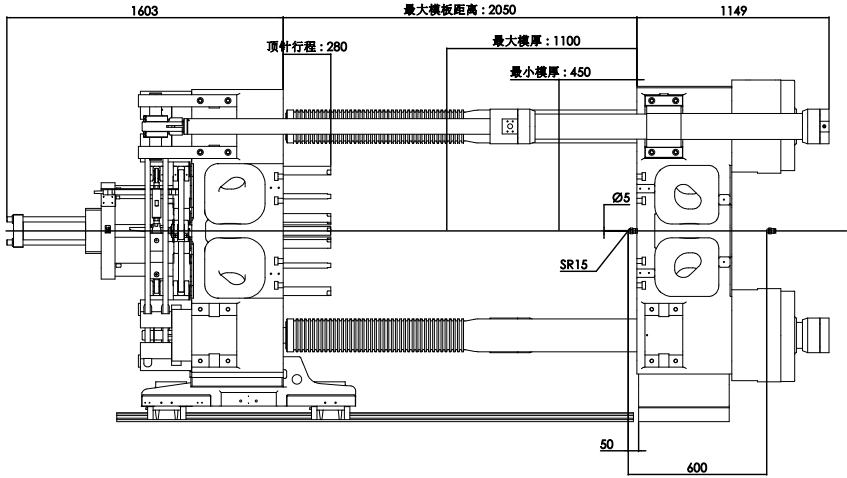
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



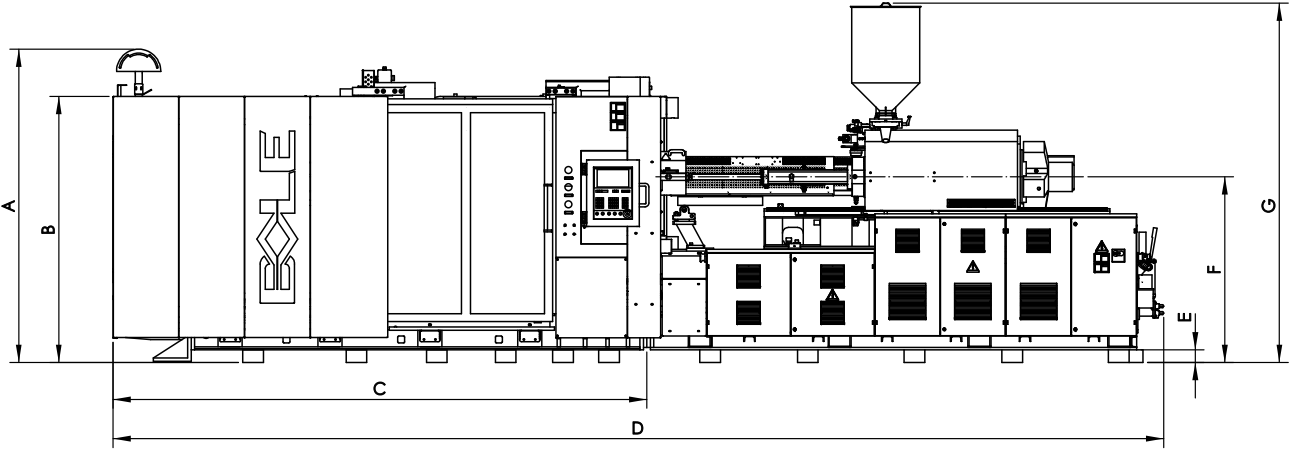
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N
BL850DK-C	2714	2297	4304	8345	100	1477.5	2943	2930	1380	548	775	874	1000	2170

模板尺寸&机器尺寸

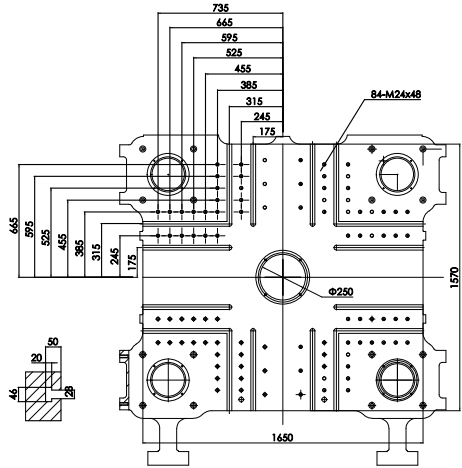
合模装置
Clamping unit



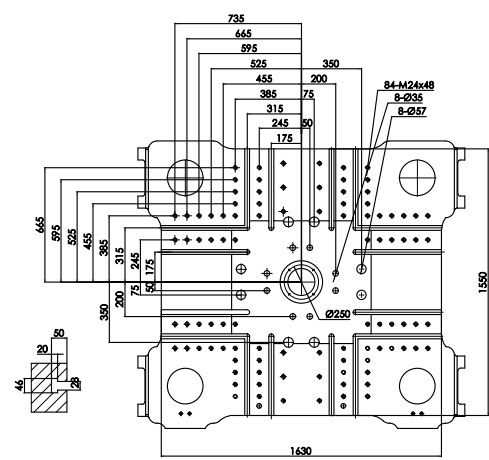
主视图
main view



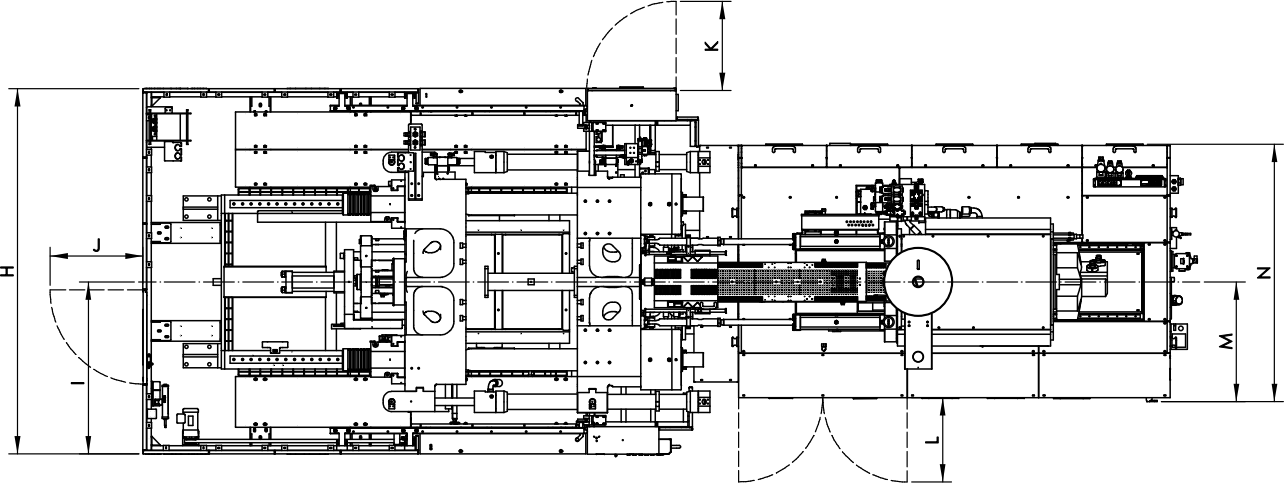
固定模板正面尺寸
Dimensions of stationary platen



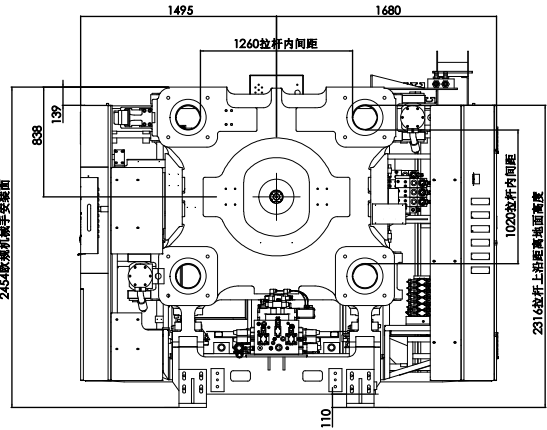
移动模板正面尺寸
Dimensions of moving platen



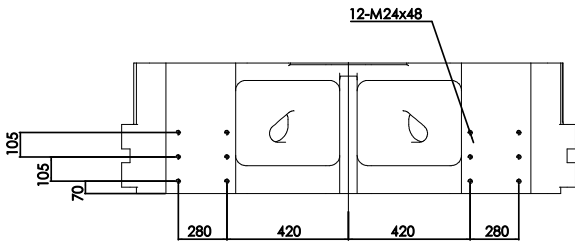
俯视图
vertical view



机器人安装尺寸
Robot installation dimensions



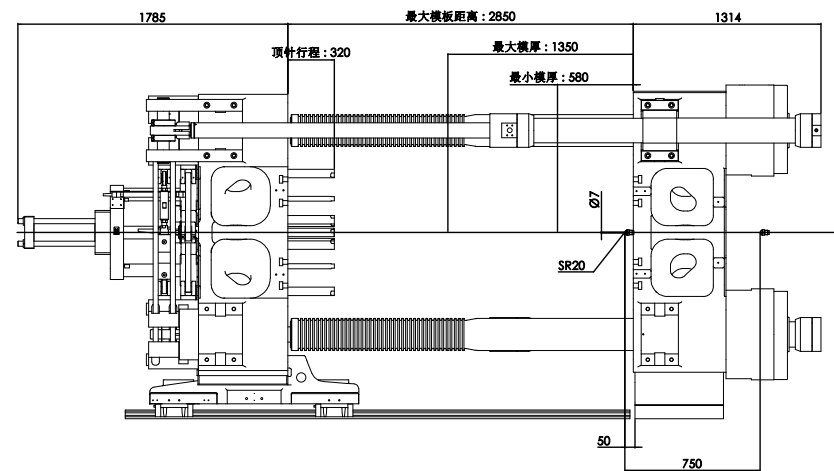
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N
BL1050DK-C	2728	2316	4649	9151	110	1616	3129	3185	1495	806	775	731	1037	2232

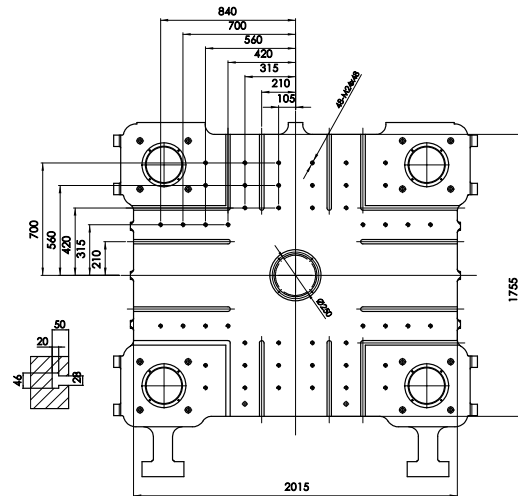
模板尺寸&机器尺寸

合模装置
Clamping unit

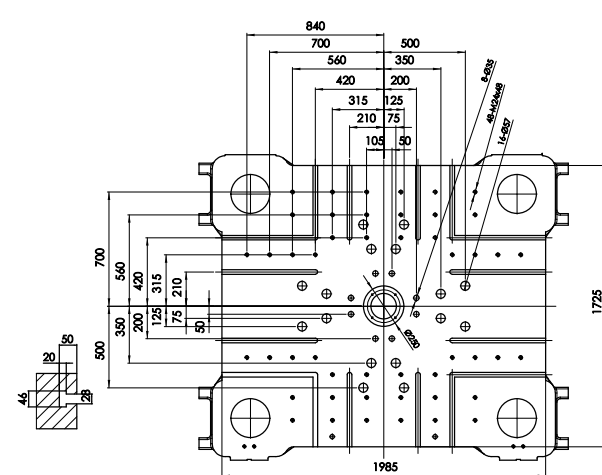


固定模板正面尺寸

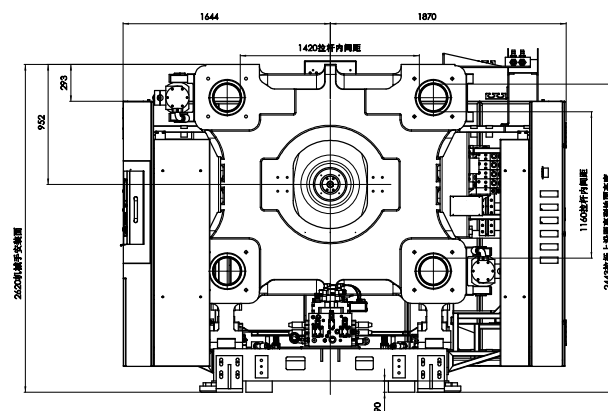
Dimensions of stationary platen



移动模板正面尺寸
Dimensions of moving platen

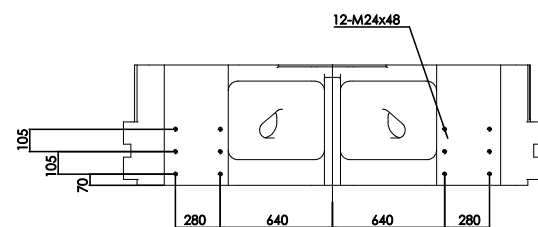


机器人安装尺寸 Robot installation dimensions

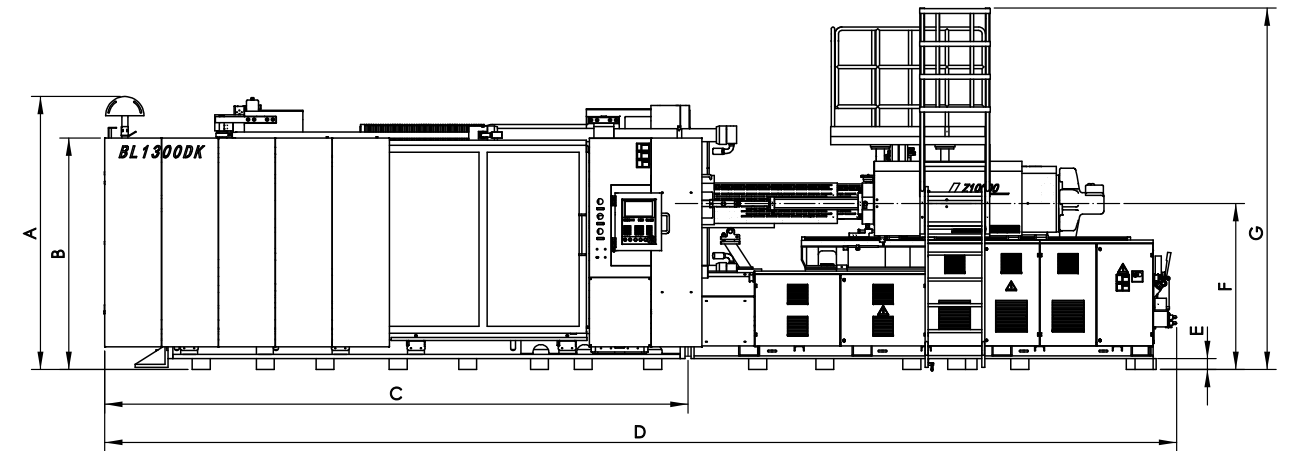


机器人固定模板安装尺寸

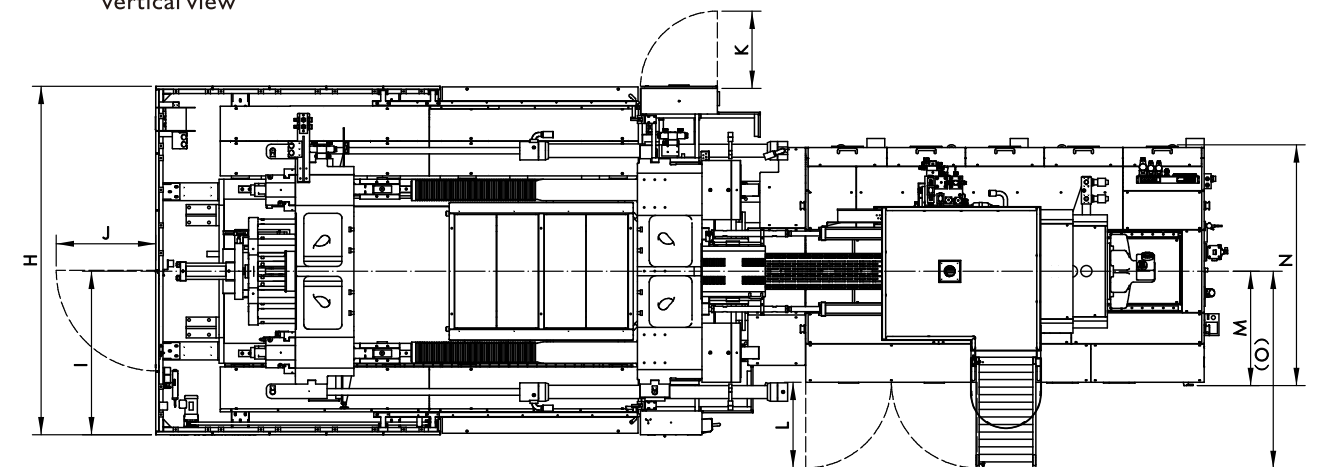
Robot installation dimensions on stationary platen



主视图
main view



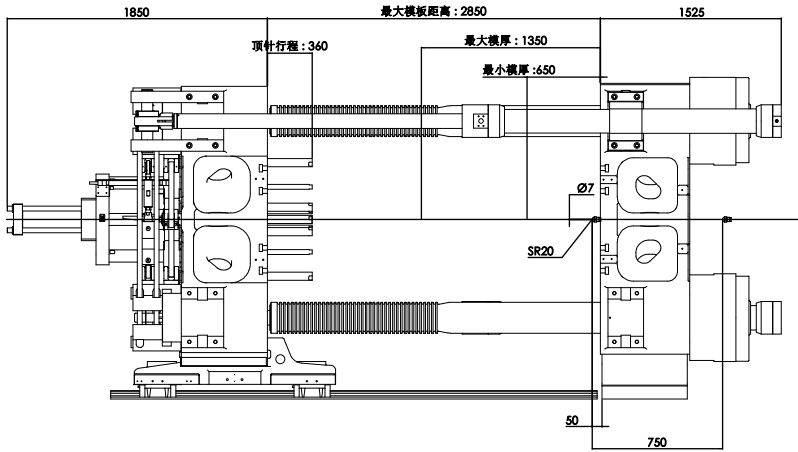
▼ 俯视图
vertical view



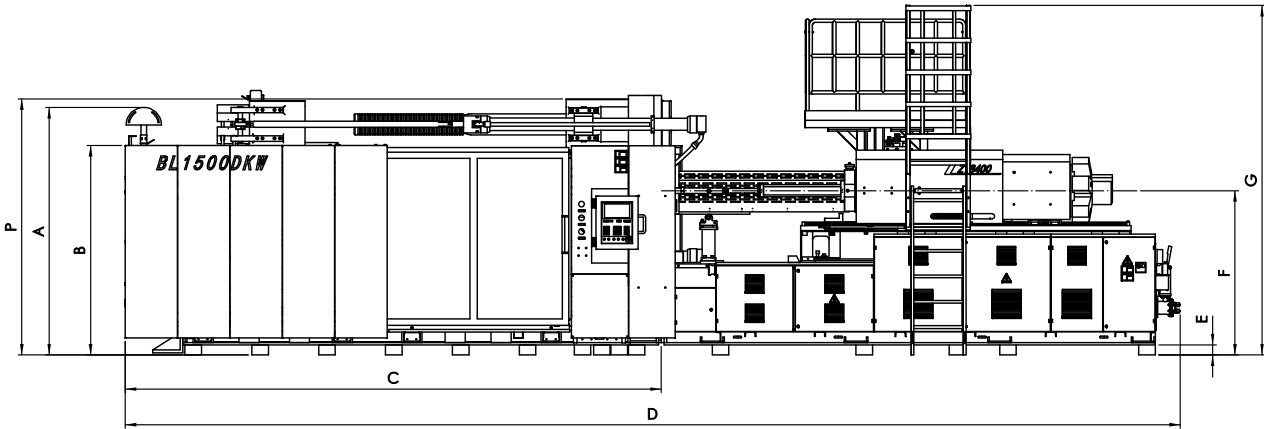
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
BL1300DK-C	2743	2327	5865	10777	110	1668	3632	3514	1642	1000	775	861	1147	2419	1983

模板尺寸&机器尺寸

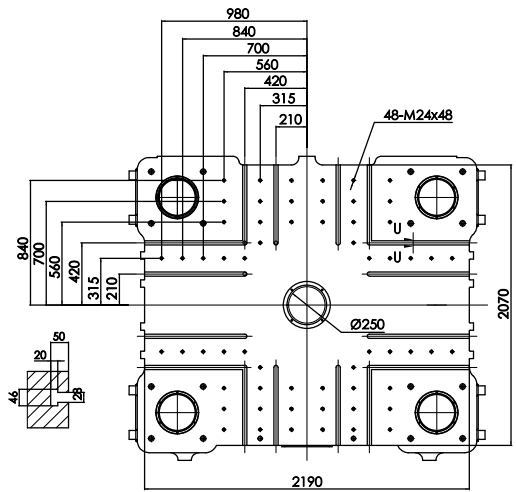
合模装置
Clamping unit



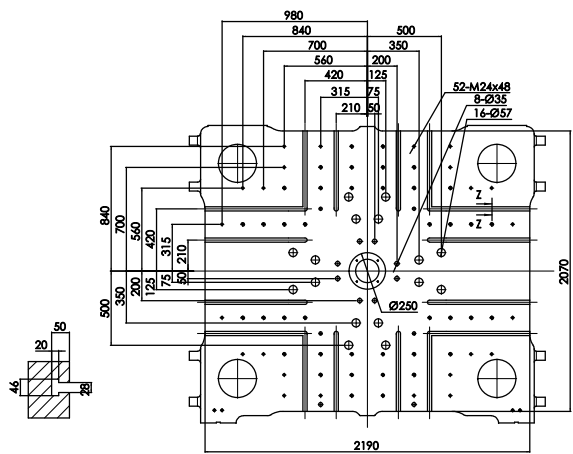
主视图
main view



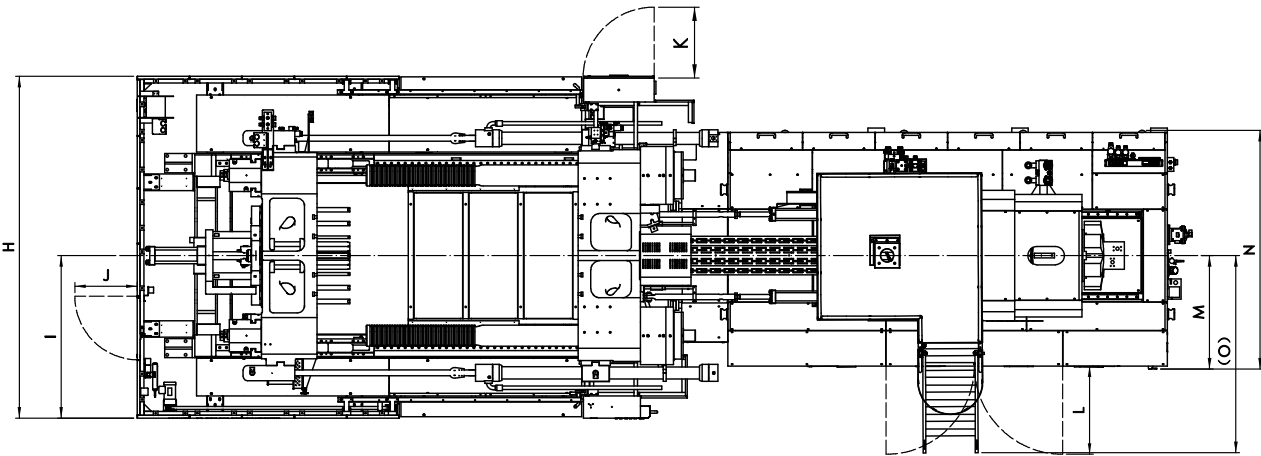
固定模板正面尺寸
Dimensions of stationary platen



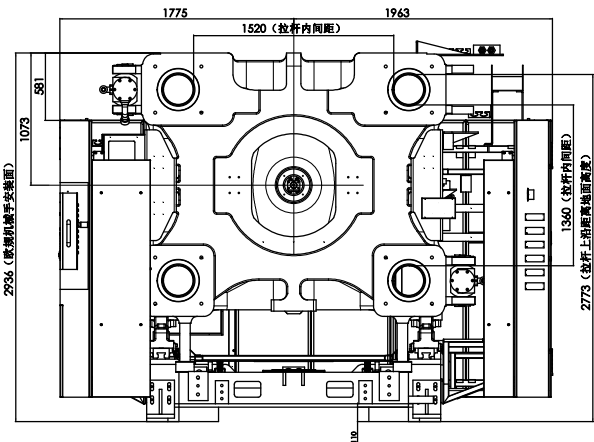
移动模板正面尺寸
Dimensions of moving platen



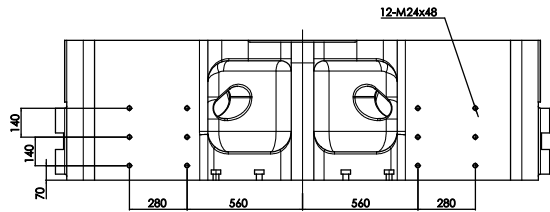
俯视图
vertical view



机器人安装尺寸
Robot installation dimensions



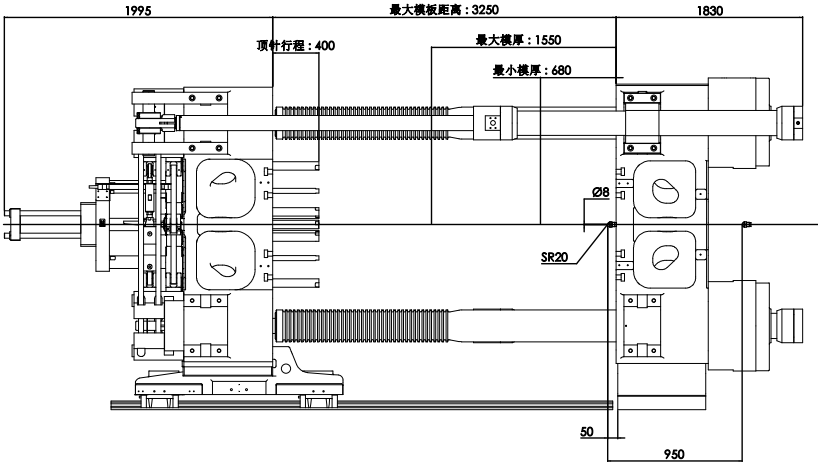
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



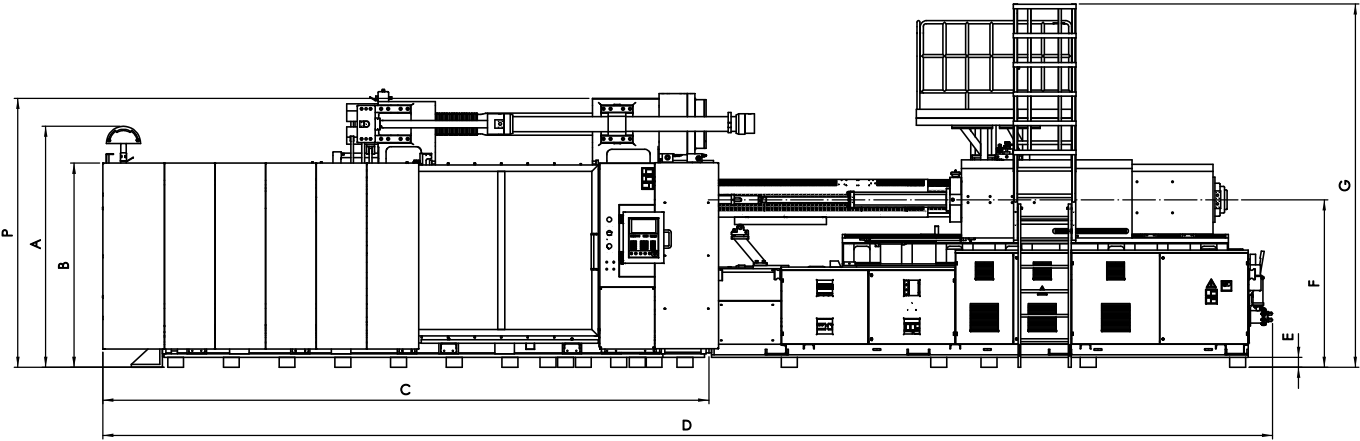
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
BL1600DK-C	2702	2286	5852	11518	110	1863	3815	3738	1773	683	775	963	1237	2603	2151	2936

模板尺寸&机器尺寸

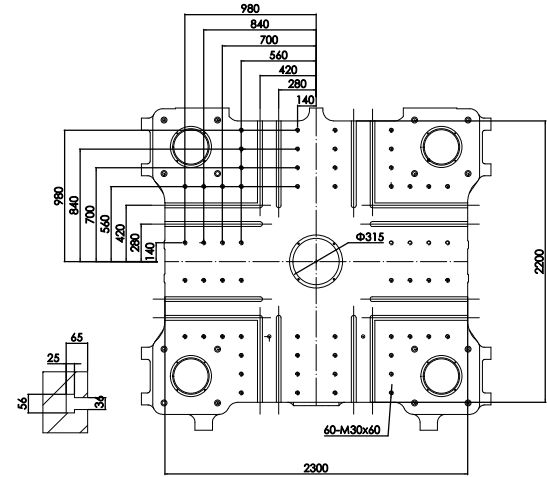
合模装置
Clamping unit



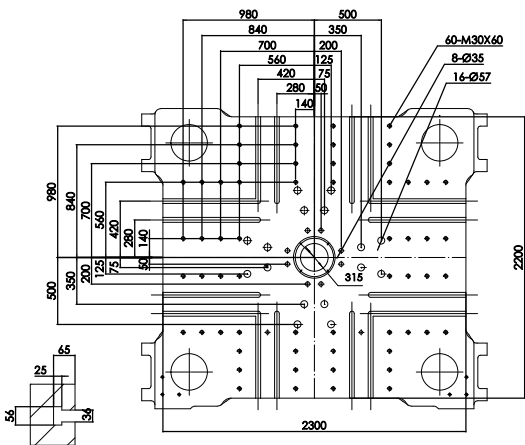
主视图
main view



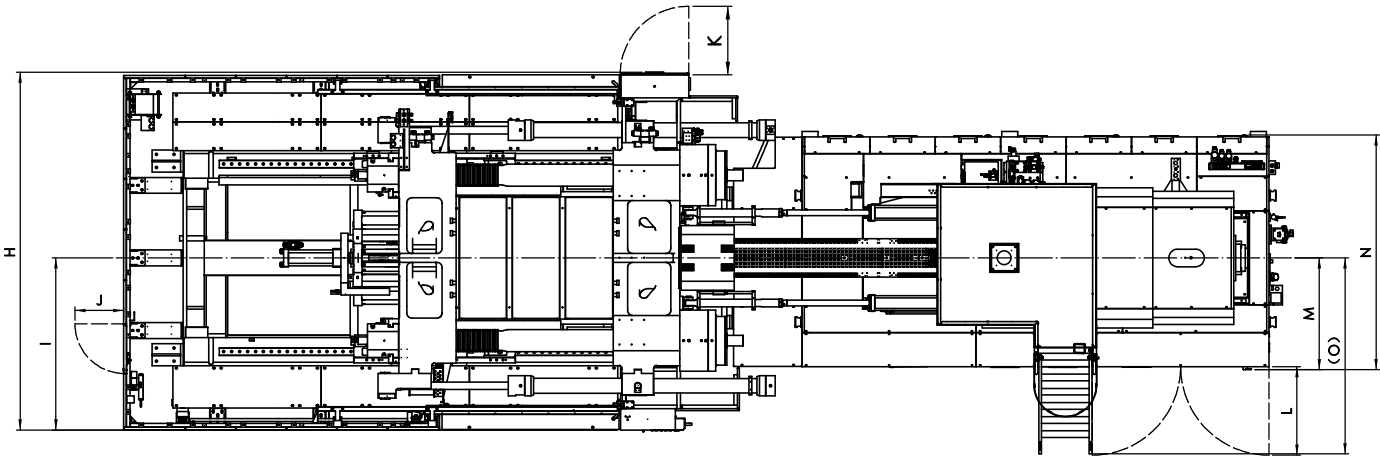
固定模板正面尺寸
Dimensions of stationary platen



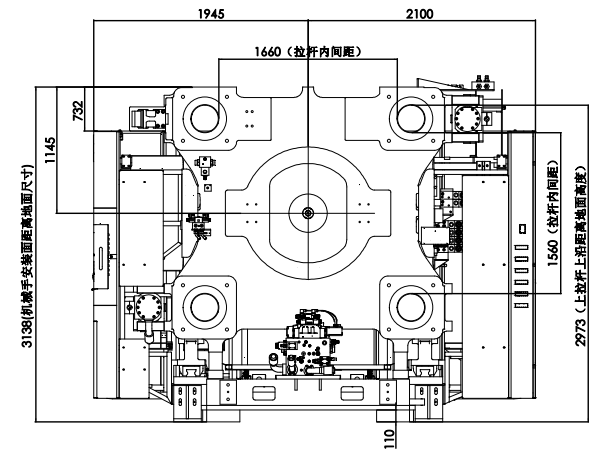
移动模板正面尺寸
Dimensions of moving platen



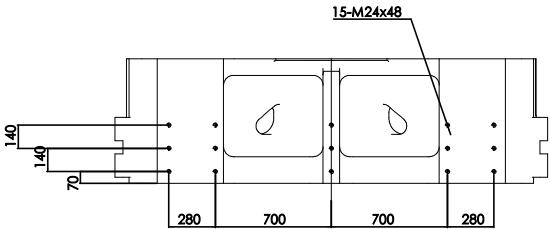
俯视图
vertical view



机器人安装尺寸
Robot installation dimensions



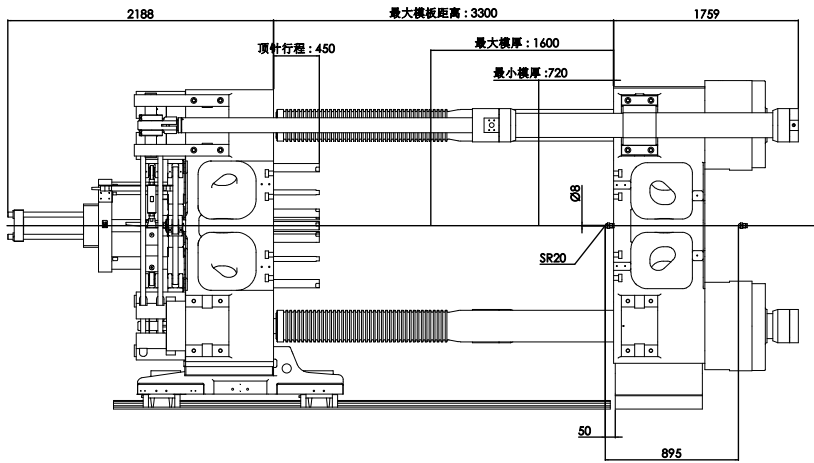
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



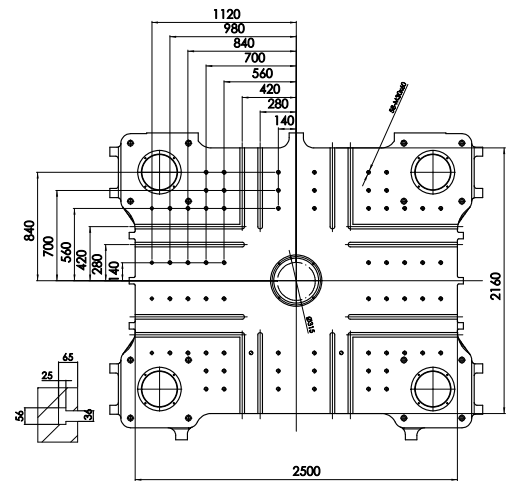
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
BL1850DK-C	2723	2306	6852	13225	110	1893	4107	4045	1945	550	775	999	1262	2653	2213	3038

模板尺寸&机器尺寸

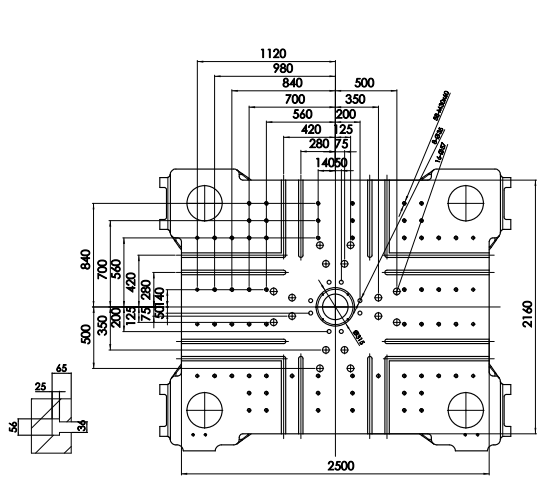
合模装置
Clamping unit



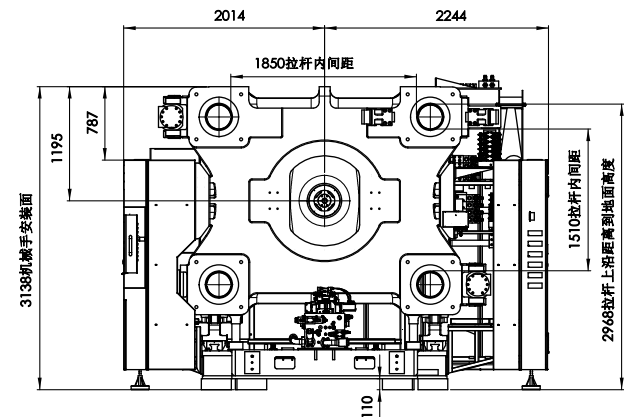
固定模板正面尺寸
Dimensions of stationary platen



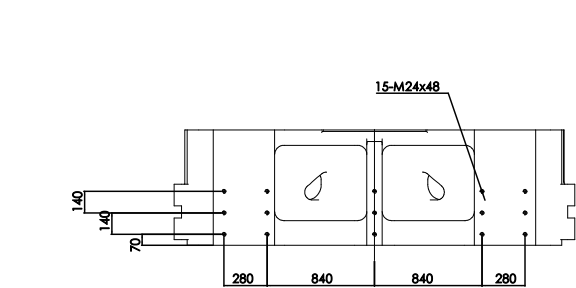
移动模板正面尺寸
Dimensions of moving platen



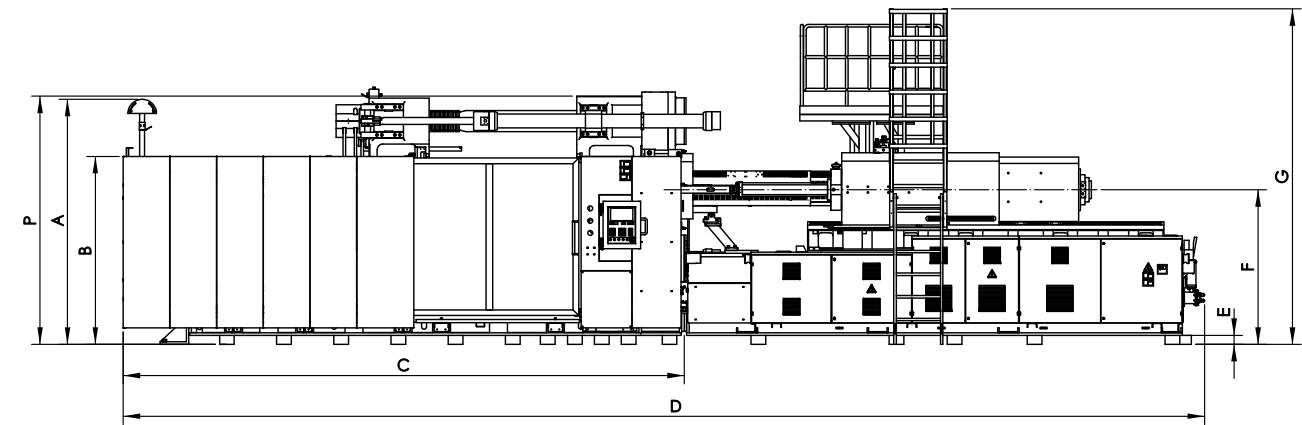
机器人安装尺寸
Robot installation dimensions



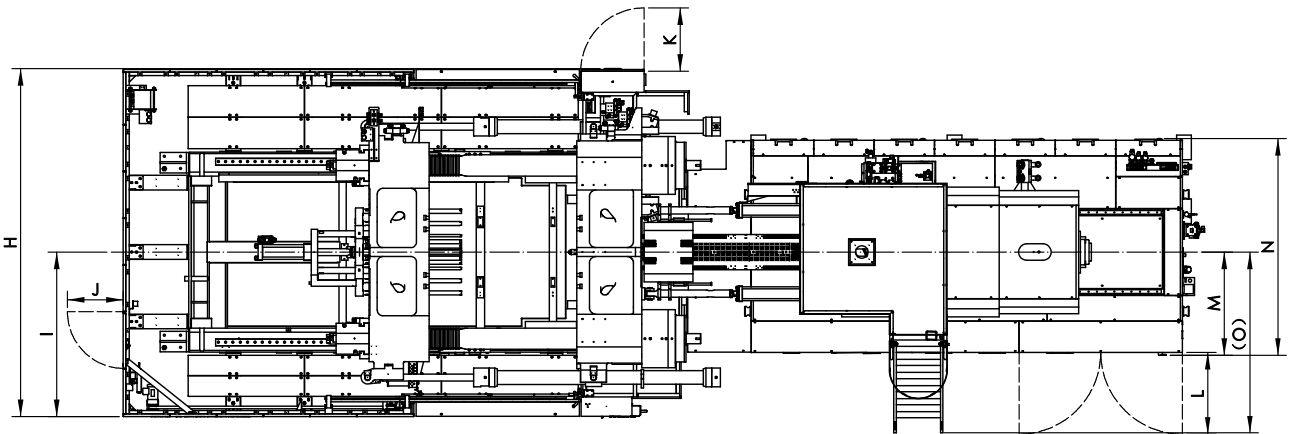
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



主视图
main view



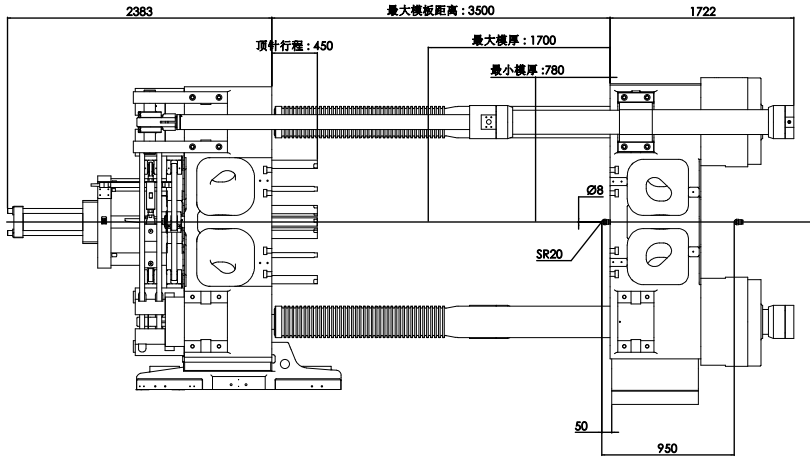
俯视图
vertical view



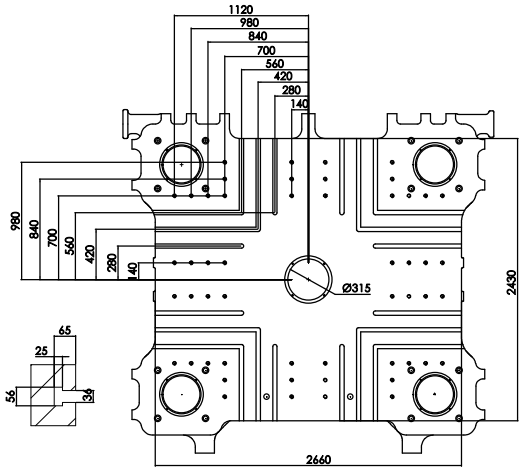
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
BL2200DK-C	3000	2301	6870	13413	110	1993	4107	4258	2013	683	775	999	1263	2653	2213	3138

模板尺寸&机器尺寸

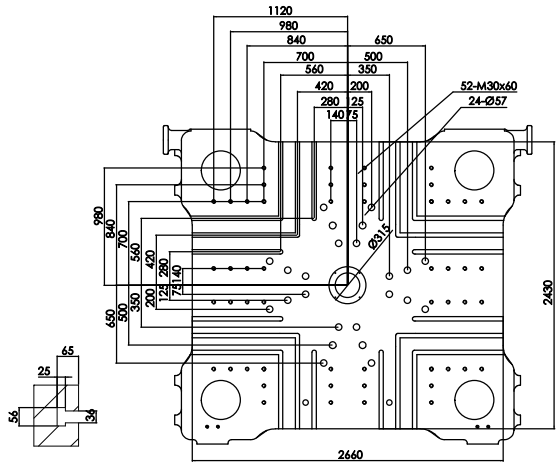
合模装置
Clamping unit



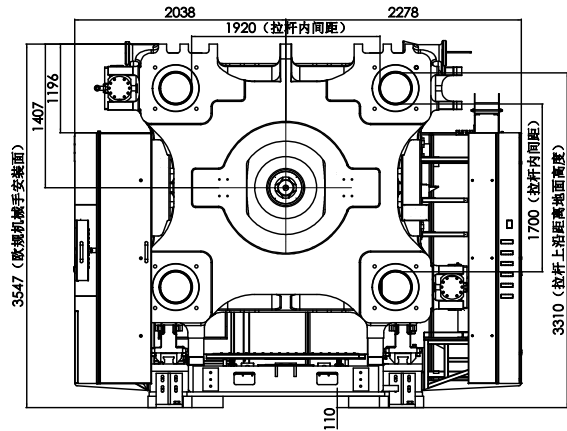
固定模板正面尺寸
Dimensions of stationary platen



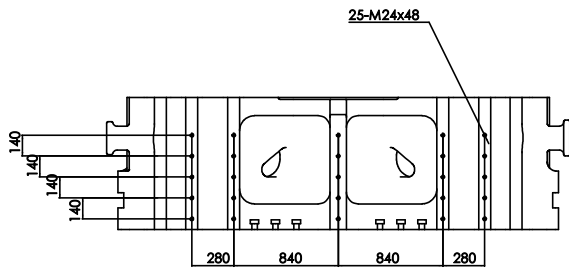
移动模板正面尺寸
Dimensions of moving platen



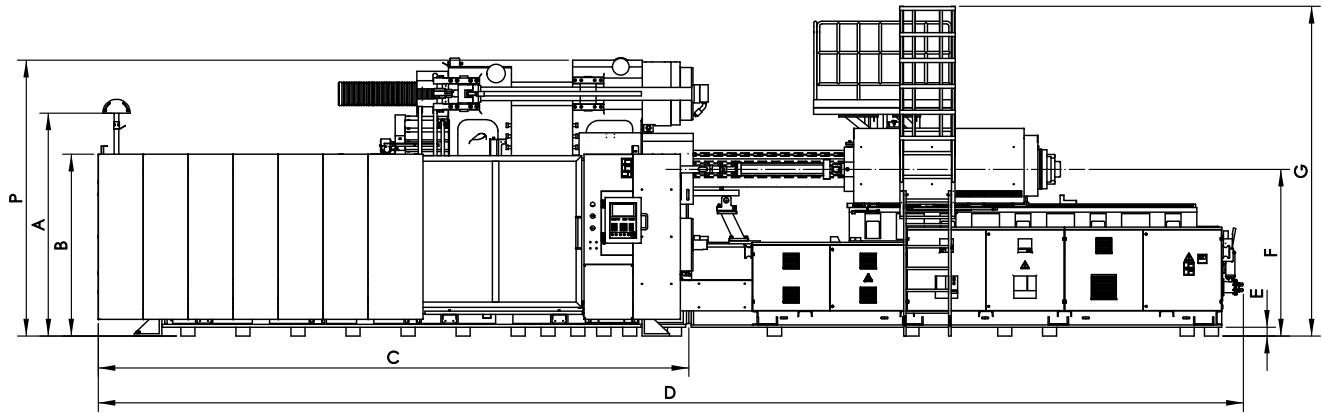
机器人安装尺寸
Robot installation dimensions



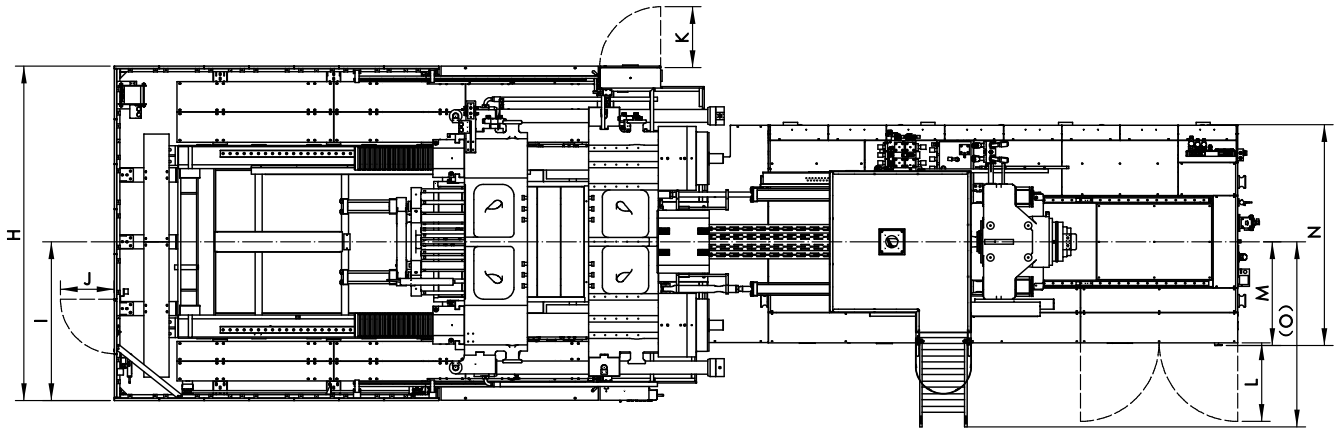
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



主视图
main view



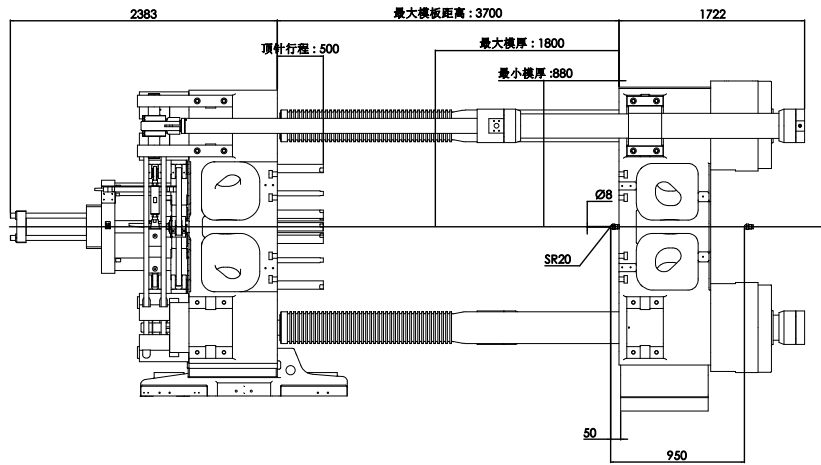
俯视图
vertical view



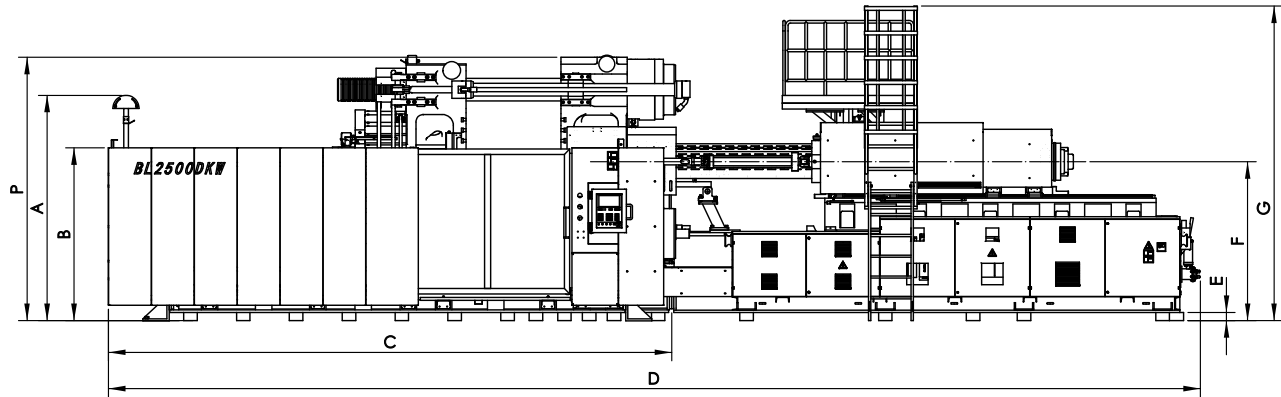
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
BL2500DK-C	2835	2311	7512	14765	110	2160	4215	4316	2038	683	775	999	1317	2806	2353	3547

模板尺寸&机器尺寸

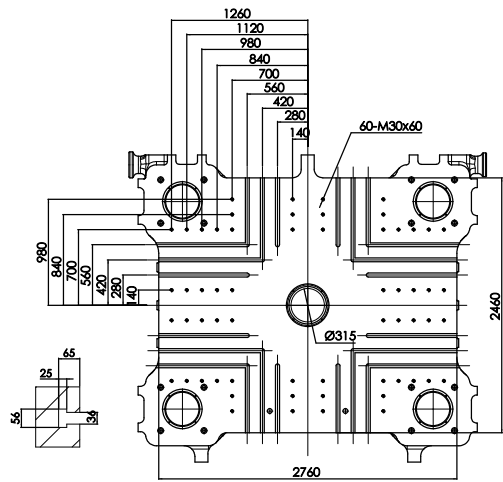
合模装置
Clamping unit



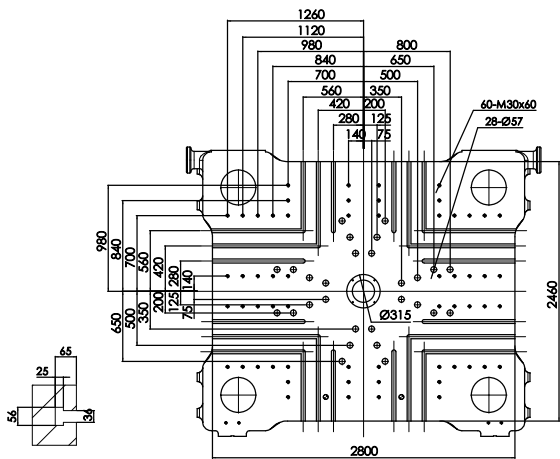
主视图
main view



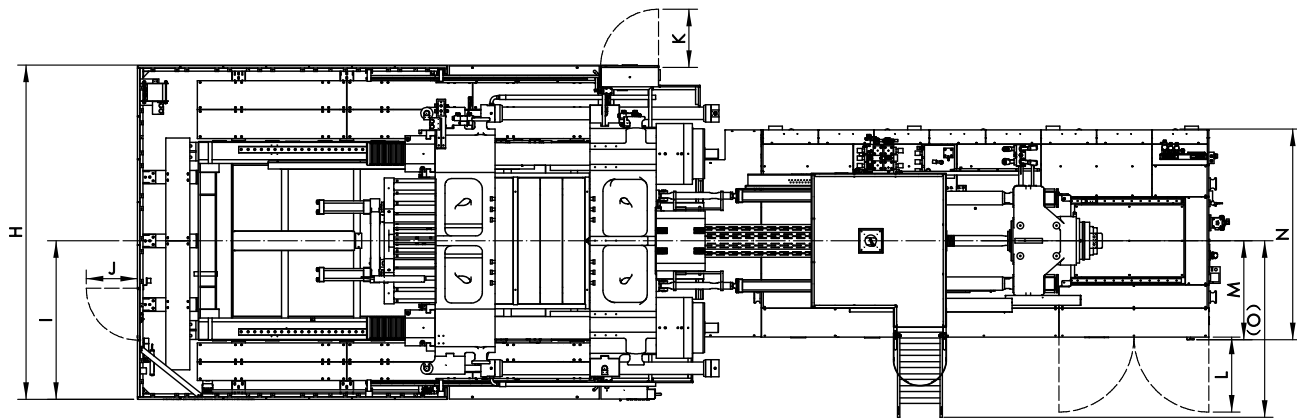
固定模板正面尺寸
Dimensions of stationary platen



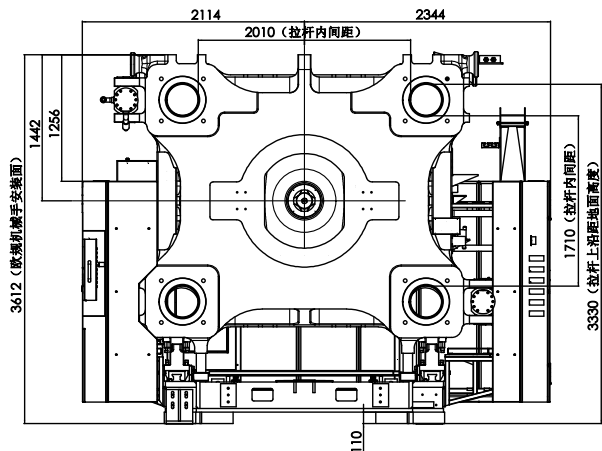
移动模板正面尺寸
Dimensions of moving platen



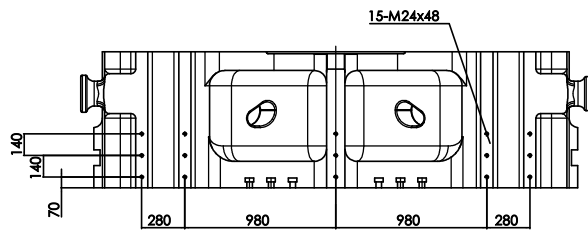
俯视图
vertical view



机器人安装尺寸
Robot installation dimensions



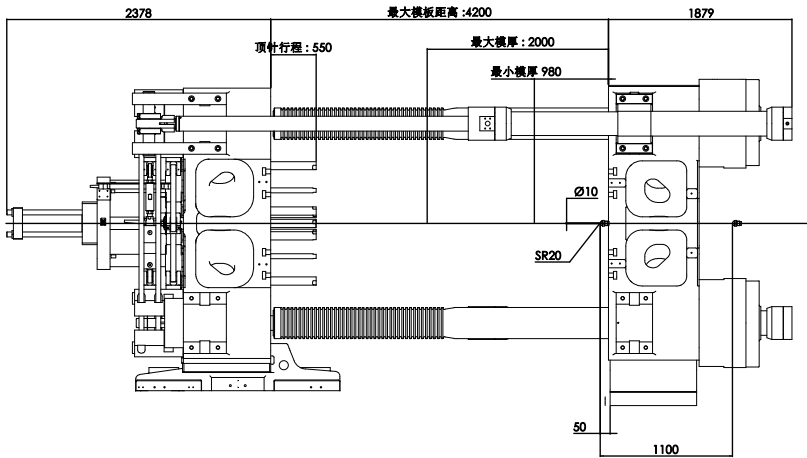
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



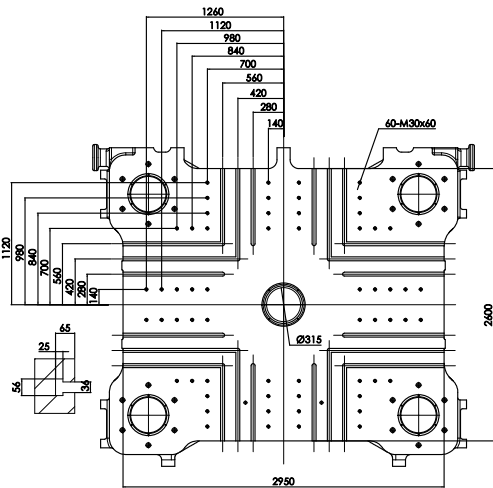
机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
BL2800DK-C	3005	2306	7512	15565	110	2220	4414	4458	2113	683	775	999	1317	2807	2353	3612

模板尺寸&机器尺寸

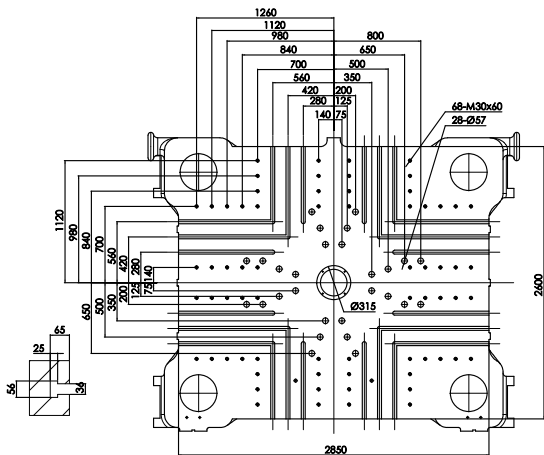
合模装置
Clamping unit



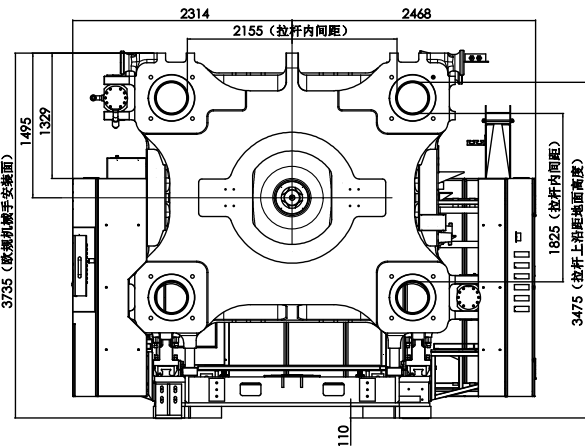
固定模板正面尺寸
Dimensions of stationary platen



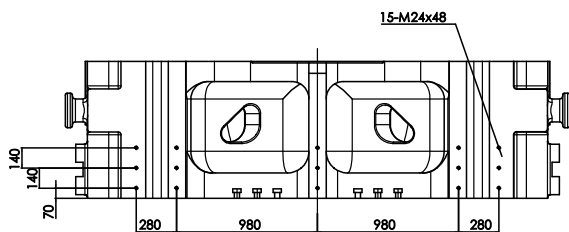
移动模板正面尺寸
Dimensions of moving platen



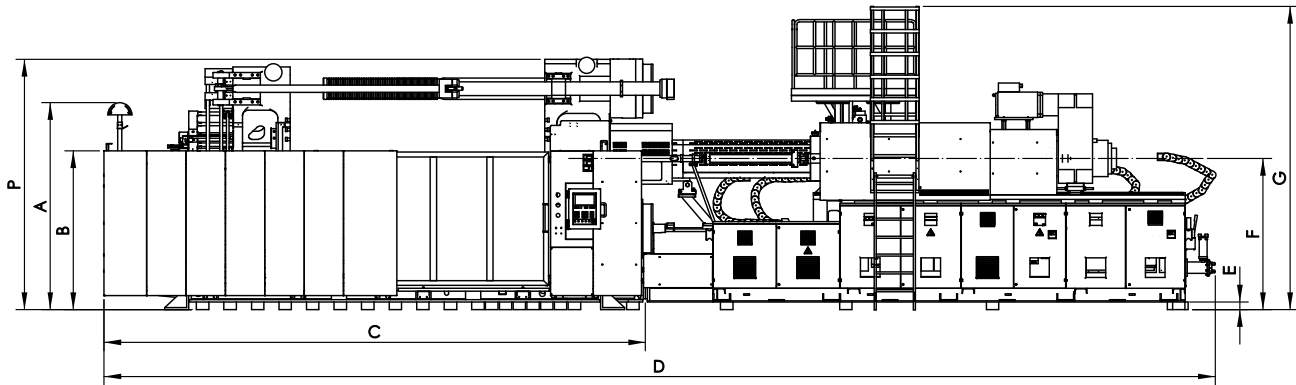
机器人安装尺寸
Robot installation dimensions



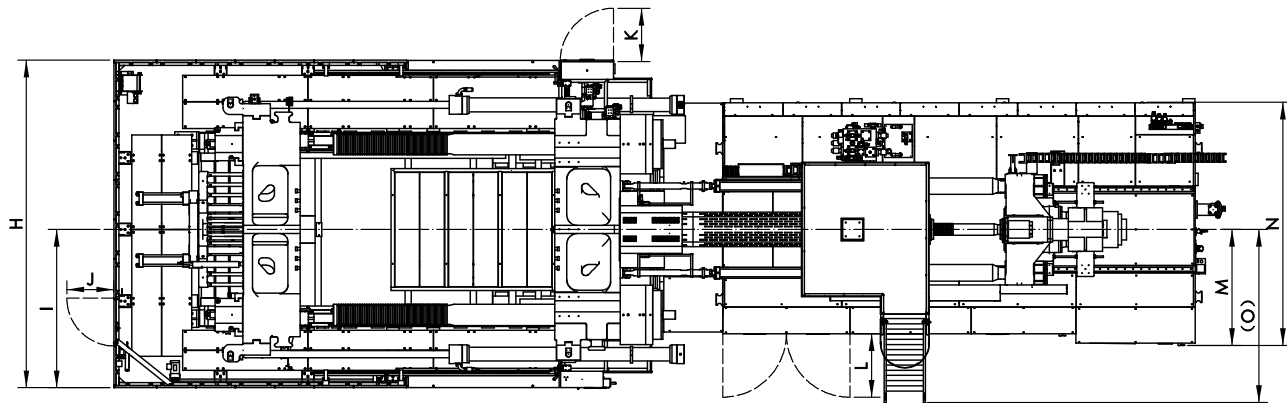
机器人固定模板安装尺寸
Robot installation dimensions on stationary platen



主视图
main view



俯视图
vertical view



机型	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
BL2500DK-C	2835	2311	7512	14765	110	2160	4215	4316	2038	683	775	999	1317	2806	2353	3547

DK-C标准配置表

DK-C合模部分
T型槽模板 (含T型槽+码模孔)
移动板滑脚(BL1600DKC及以下标配线轨结构, BL1850DKC及以上标配钢带滑脚支撑结构)
液压抱闸结构
液压、电气二重安全保护
一键式自动调模功能
合模力按需自动调整功能
欧规U18机械手安装位置
高精度低压保护模具功能
锁模部分配备模具安全踏板
自动安全门控制并附安全边沿开关和关模确认按钮
开合模、顶出动作采用高精度电子尺控制
多种顶出模式可选, 压力、速度分别设定
配置同步顶出/抽芯功能
顶出倒拉强制复位功能
二组分水排 (动、定各一组, 为6进6出 ,10mm快插接头)
自动检知容积式集中油脂润滑系统, 配末端压力监测
BL1850DKC以下标配2组抽芯 (动定各1组) , 预留2组抽芯 (动定各1组) 带中子保持及泄压功能
L2200DKC以上标配4组抽芯 (动定各2组) , 预留2组抽芯 (动定各1组) 带中子保持及泄压功能
开模差动装置
开合模比例阀
前后门、模具区急停开关保护
两组吹气 (动定各一组)

DK-C注射部分
注射座、预塑座线性导轨支撑结构
德国设计优质氮化钢高效塑化螺杆机筒
料筒支撑机构
射嘴及料管多段PID温度控制
全封闭式保温罩、射嘴防护罩
高精度电子尺控制射胶行程
喷嘴对中微调装置
定时加热功能, 螺杆防冷启动
螺杆松退防流涎 (抽胶/松退/射退)
螺杆转速检测
自动清料功能
熔胶比例背压
射台手动集中润滑
加长喷嘴, 加长50mm
陶瓷加热圈
辅助注射信号接口
下料口温度控制
液压马达系统 (电预塑功能BL3300DKC标配, 其余机型选配)
BL1300DKC以上料平台, 不配料斗, BL1050DKC以下标配轴承式移动料斗

DK-C电气液压部分
伊士通电脑
多种操作语言
三色报警灯
实时合模力监控
配欧规U67机械手接口
USB接口, 可方便进行面板程序更新和模具参数备份
具备停机记忆功能, 可随机存储模具资料
异常警报及修改记录存储
多级密码保护, 可依不同授权等级更改设定, 防止错误修改成型参数
输入、输出点检测及I/O在线仿真功能, 可快速确认机器运转状况
质量数据过程监控界面
生产统计过程控制实时列表界面 (SPC)
插座:5芯32A×2+5芯16A×1,3芯多功能×2
注塑机工业4.0联网功能接口
伺服节能系统
油温检测, 油温偏差自动报警
电机过载保护功能
独立冷却过滤系统

DK-C整机部分
双马DK标准色
防震可调机床垫脚
L型固定块
附件箱、常用工具、模具压板、易损备件、加长喷嘴、说明书
地脚螺栓