



DALGAKIRAN
大格格兰



台州市大格格兰包装机械有限公司
TAIZHOU DALGAKIRAN PACKAGING MACHINERY CO., LTD

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TEC BLOW
EASY BLOW
让吹瓶更简单



GO TO GREEN

创造可持续发展之路



ENTERPRISE OVERVIEW

企业概述



台州市大格格兰包装机械有限公司是由大格格兰在临海投资兴办的制造型实体企业，是专业生产PET直线和旋转高速全自动吹瓶机的制造商，创建于2004年。公司目前拥有员工一百人，其中技术研发三十多人，拥有多年的生产实践经验，并吸收国内外先进技术，经过多年的研发和改进，其产品不断的推陈出新，研发出多款高速型节能吹瓶机，在行业内享有很高的声誉。

公司以“创新，未来”为企业精神，以“高精密，高品质，高产能”为企业生命线，以完善的售后服务满足客户的需求，赢得了国内外很多客户的赞许和认可。

Founded in 2004, Taizhou Dalgakiran Packaging Machinery Co., Ltd AOKTAC is the sector leader on an international level in designing and building two stage reheat stretch blow molding machine for pet bottle industry. It consists of many professional engineers with rich experience in the PET industry. The main products include: PET two stage reheat stretch blow molding machine, PMMA lamps, PP intrusion bottles, edible oil bottles, and cosmetic containers, etc. The main target markets are regions and countries in Europe, Middle-East, South-America and South Asia. Over the past several years, AOKTAC has always been devoting its utmost efforts to improving the technology, researching the market and developing new products to suit for all customer needs.

With the foundation of "Be people-oriented and Sci-tech innovated" and the aim of "creating more profits for the society", AOKTAC has been doing its best in realizing win-win cooperation with customers all over the world.





工厂外景Whole company view



瓶子造型Bottle design



CNC加工部门 CNC Tooling Dept.



TEC BLOW生产车间 TEC BLOW workshop

EUROPE TECHNOLOGY MADE IN CHINA

欧洲技术 & 中国制造

源于欧洲技术，适合全球市场

Originated in Europe, suitable for worldwide

荟萃欧洲和中国工程师团队，专门针对吹瓶市场精心创作的一款旋转加热直线吹瓶工艺-TEC BLOW。其紧凑的设计，减少了占地面积，并最大程度地尊重客户的需求，有效控制生产成本。

With great efforts of European and Chinese engineering team, We designed one rotary heating&linear blowing technology which most suit for blowing market-TEC BLOW. The compact Design makes machine takes smaller room, and maximum meets Customers' requirements, controls productioncost more efficiently.

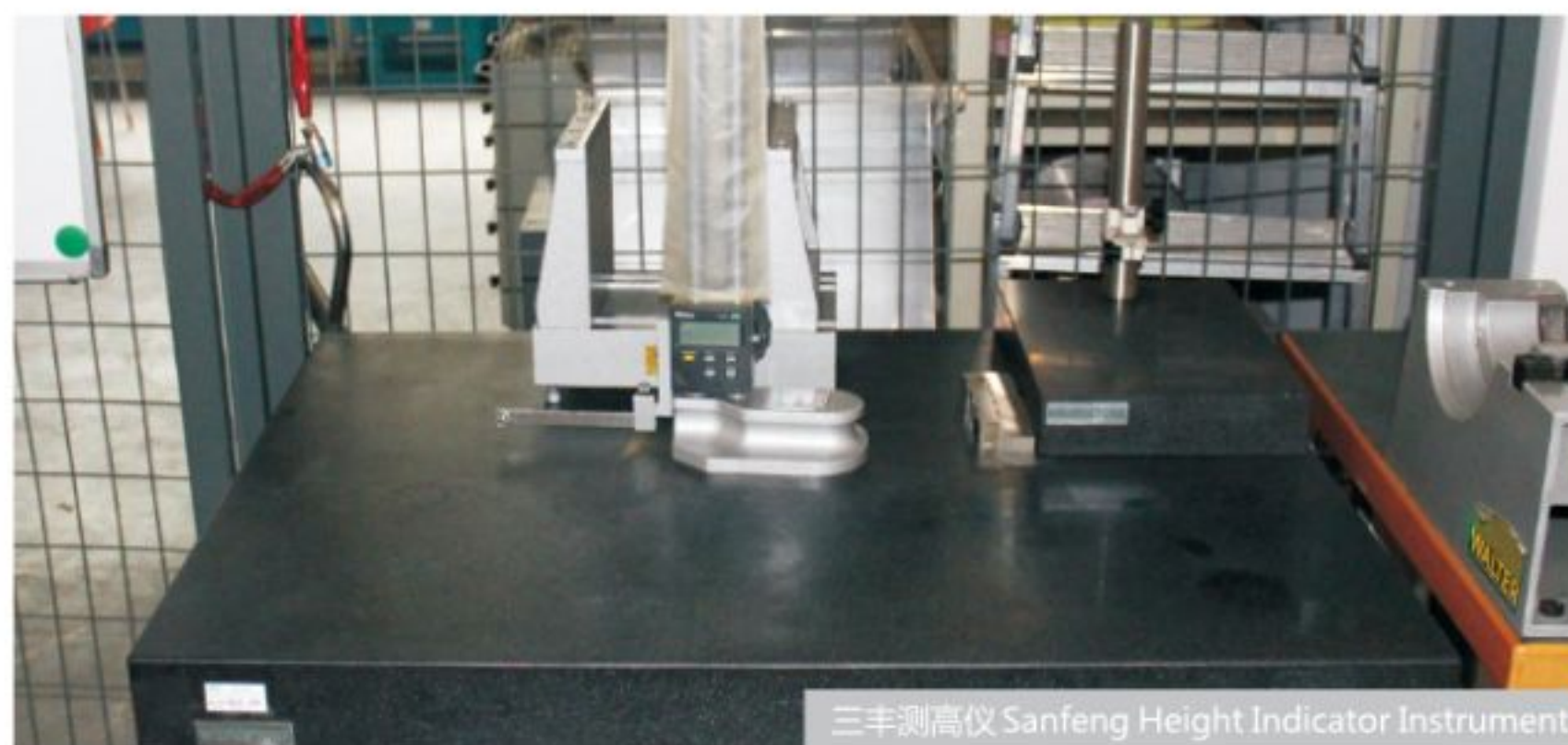
工艺精湛，适用范围广

Precise technology, worldwide usage

客户需要稳定且易于操作的成熟技术，TEC BLOW是吹瓶厂家和水厂理想的选择。精心设计各种不同标准机型供客户选择

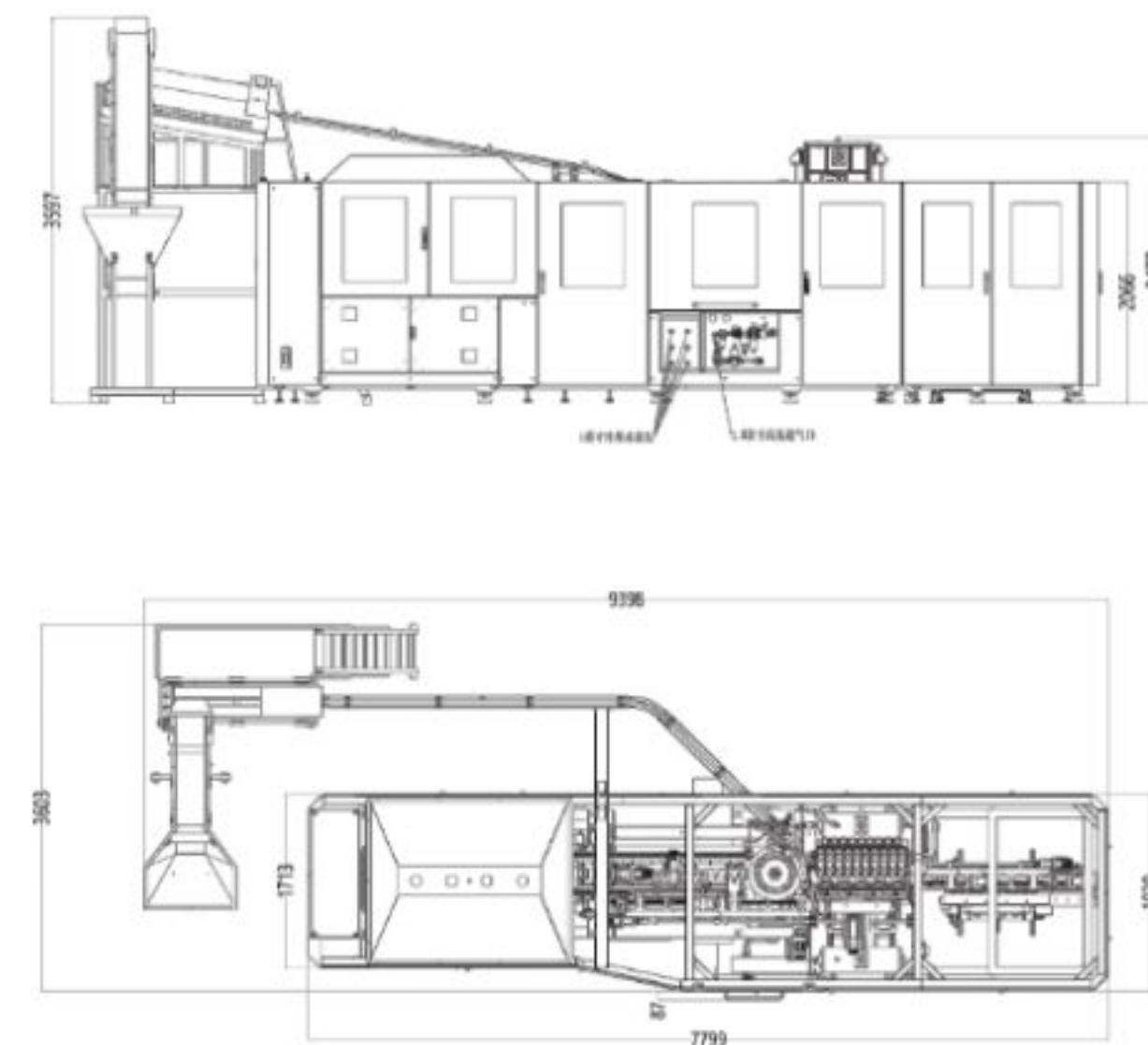
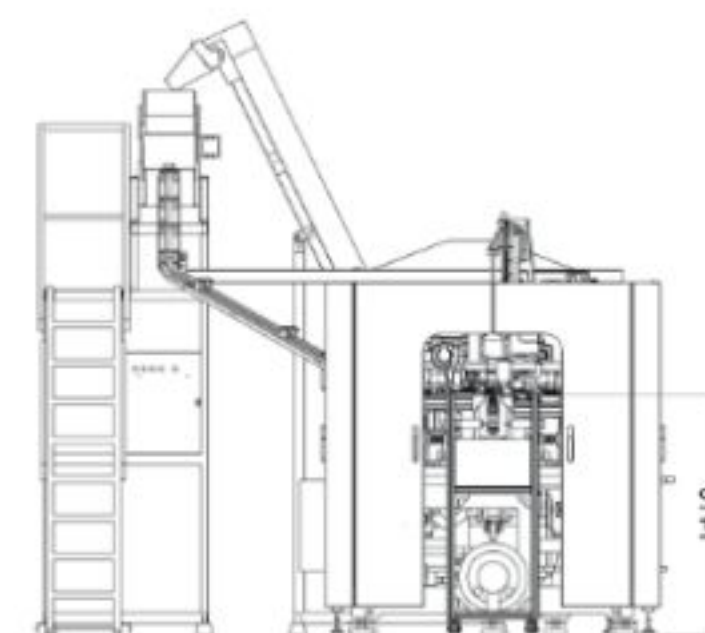
What customers need is mature technical which is stable and easy operation, TEC BLOW is the ideal choice for blowing companies & water plant companies. We can offer customers precise design for different standard machines.

合作企业 COOPERATIVE ENTERPRISE



设备结构

EQUIPMENT STRUCTURE



全自动的操作界面

- Mitsubishi触摸屏以及PLC
- 带图解的触屏界面, 存储有关机器控制, 加热和吹塑参数, 警报和故障诊断, 生产统计数据, 维护维修程序和录像, 便于服务客户

Fully automatic operation page

- Touch screen and PLC all Mitsubishi
- With strong storage of relevant machine control, parameters of heating, blowing, alarm and fault diagnosis, production statistic data, maintenance repair program and video, easy for serve customers



星轮进胚装置

- 采用星轮进胚方式, 取消传统机械翻转结构, 进胚更顺畅, 故障率更小

Preform feeding unit

- Using star wheel system for preform feeding like combi blowing machine, preform feeding more smoothly and less mechanical problem.



加热单元

- 采用行业内最小的38.1mm加热节距技术, 极大程度上降低加热炉的使用功率。
- 采用瑞士进口陶瓷反射板, 提高了反射板反射效率, 提升烘箱效率, 高效, 节能。

Heating unit

- Adopt the smallest heating distance 38.1mm, maximumly lower down the heating oven usage.
- Adopt the swiss infrared ceramic reflector technology, highly improve the reflection efficiency. It makes heating oven more efficient and power saving.

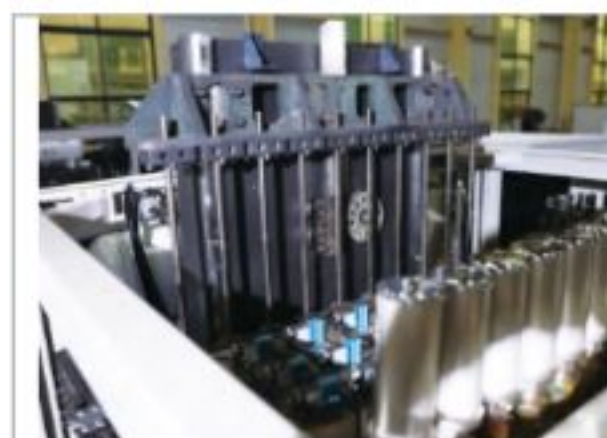


分胚合模单元

- 业内首次采用滚珠动丝杆+气囊补偿合模
- 丝杆采用独立Lube润滑脂泵进行加注油脂, 并设有油路低压保护。
- 螺杆分胚顺时针旋转, 从加热小节距变吹瓶大节距, 没有以往的正反转结构, 磨损更少噪音更低。

Clamping unit

- First adopt ball screw+air bag compensation for clamping
- Screw adopts separate lubrication system and also has oil route low pressure protector.
- Screw bar runs clockwise, from heating small pitch to blowing big pitch. Avoid normal-reverse transferring, less wear, less noise, less mechanical problems.



拉伸吹瓶结构

- 拉伸采用伺服电机驱动, 齿轮齿条式拉伸机构
- 采用瑞士Seitz 高压吹气阀, 可带气体回收功能

Stretch and blowing unit

- Stretching by servo, chain wheel type stretch.
- Adopt Swiss SEITZ High pressure blowing valve, having air recycle function.



模具

- 所有模具采用7075航空铝材料, 模具均采用单腔圆模结构, 更换模具快捷方便, 速度快

Blow Mold

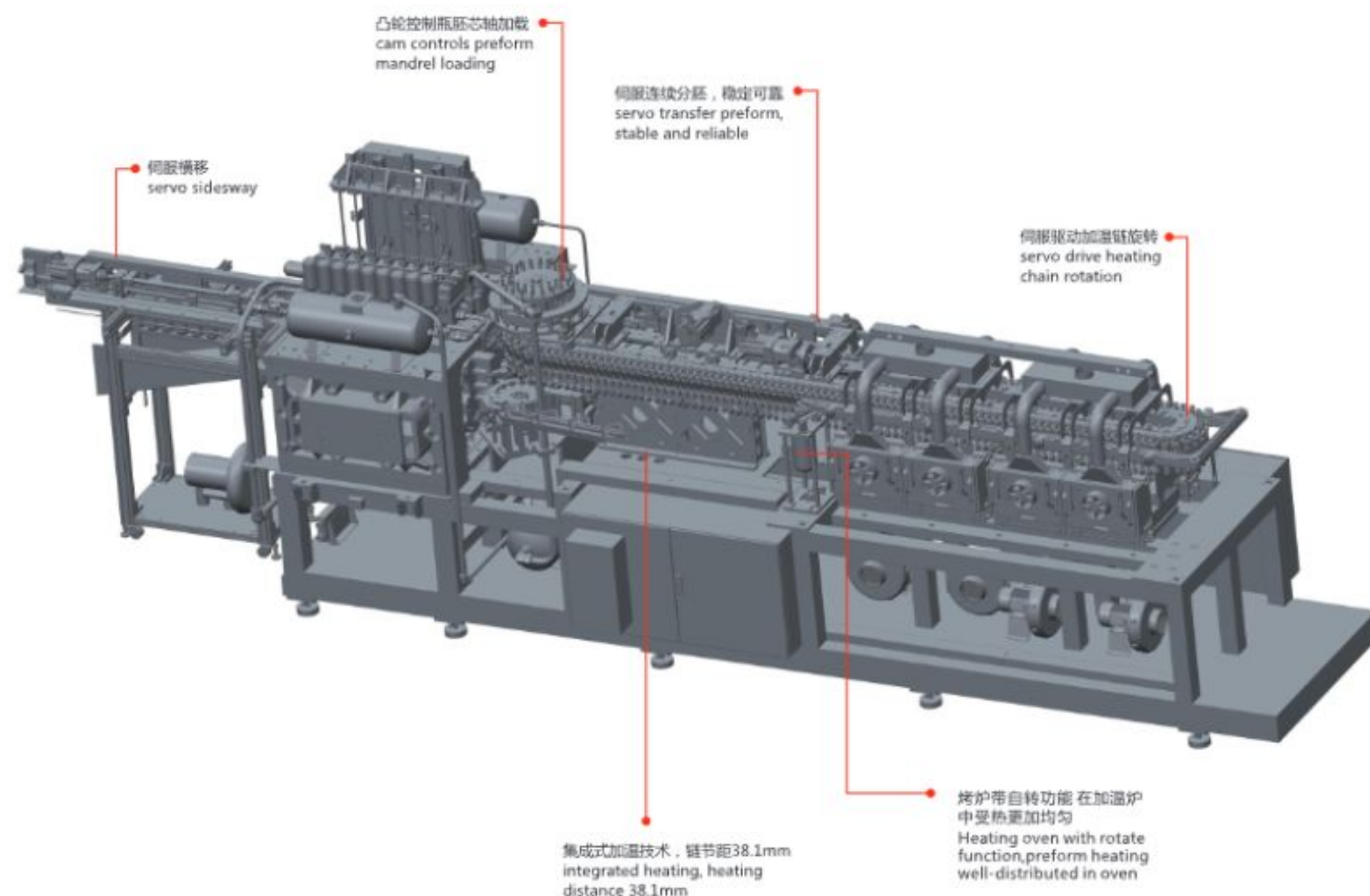
- All molds material is 7075AL, molds are separated type, single cavity, convenient for customers changing molds.

EQUIPMENT INTRODUCTION

设备介绍

第二代TEC BLOW吹瓶机显著的技术优势和创新理念尽显于设备的各项关键功能中。第二代TEC BLOW吹瓶机操作简单灵活，生产连续不间断，占地面积小，产能高，加热能耗和耗气量节省可观。这些特点再次验证了设备完全可以满足客户高要求并奠定了第二代TEC BLOW技术领先地位。

The second generation TEC BLOW's significant technology and innovation applied in the key part of blowing machines. Its convenient operation, nonstop production, less room, high capacity, less heating power and air consumption all meets customers' requirement. TEC BLOW becomes the leading technology in plastic machinery field.



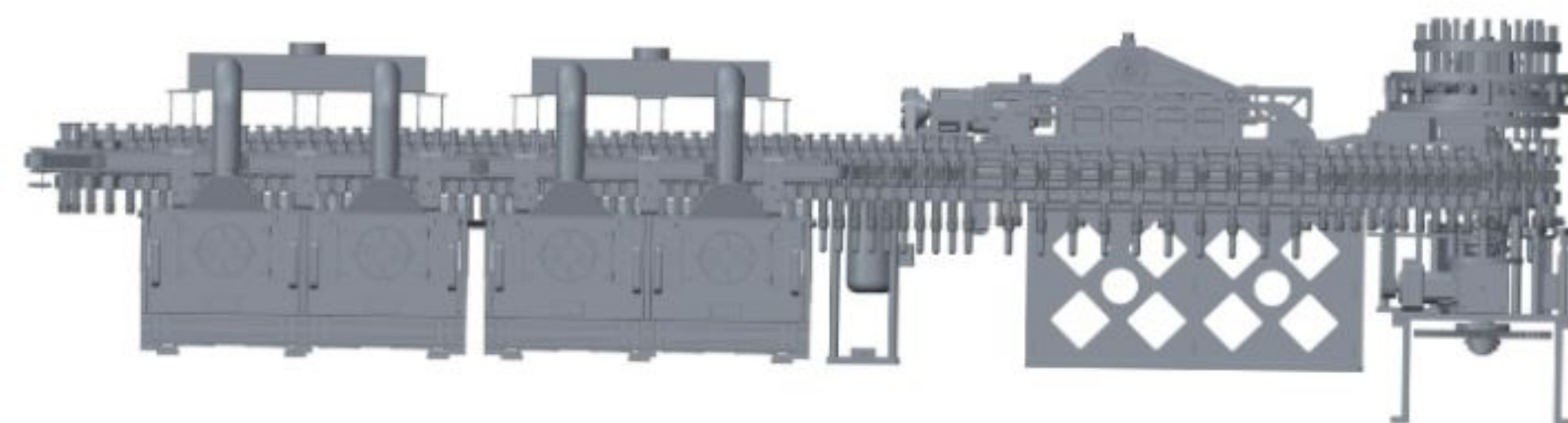
第二代吹瓶机技术优点 TEC BLOW II SERIES advantages

加热炉理念

- 平衡式加热芯轴技术。
- 凸轮控制瓶胚芯轴加载。
- 近红外加热（NIR），加热辐射密集，瓶胚受热更加均匀，优化。
- 加热炉采用瑞士进口红外线陶瓷全封闭反射通道。（加热效率更加高效，和不锈钢反射板比较，陶瓷反射板能耗降低10%-30%）
- 加热炉链节距38.1mm 业内最小，相比以往50.8mm 节距能耗更低。

Heating oven advantage

- Balanced heating mandrel technology
- Cam controls preform active mandrel loading
- NIR heating, intensive heating, PET preform much more uniform heated and optimized.
- Heating oven adopt Swiss infrared ceramic reflector technology (heating efficiency much higher than SS reflector, and power consumption 10% - 30% lower than traditional type).
- 38.1mm-the smallest heating distance in blowing machine field, power consumption is much lower than 50.8mm heating pitch.



芯轴理念

- 平衡式加热芯轴技术（国家发明专利）
- 优点：运转平稳，芯轴旋转同心度高，旋转时不偏心，加热炉内瓶胚链节距仅38.1mm，低能耗。

Active mandrel advantage

- Balanced heating mandrel technology (national patent)
- Advantage: stable running, Active mandrel high rotation concentricity, rotate never off-centre, the heating distance will be only 38.1mm, maximum saving power.



第二代吹瓶机技术优点

TEC BLOW II SERIES advantages

瓶胚传送理念

- 快速横移传送结构，采用保险杠式设计
- 轻量化封口技术，封口更加敏捷
- 采用连续分胚技术（国家发明专利）
- 伺服拉伸实现精准定位，更有利于轻量化瓶成型
- 螺杆分胚，单方向旋转，减少磨损，减少机械运动

Preform transfer advantages

- Fast sideways transfer structure, adopt bumper design.
- Lighter aluminum sealing technology, sealing is much agile.
- Adopt contentiously transfer preform technology. (national patent)
- Servo stretching for accurate positioning, much better for light weigh bottle blowing.
- Screw bar seperating preform system, one way movement, Reducing wear and meachainial movement.

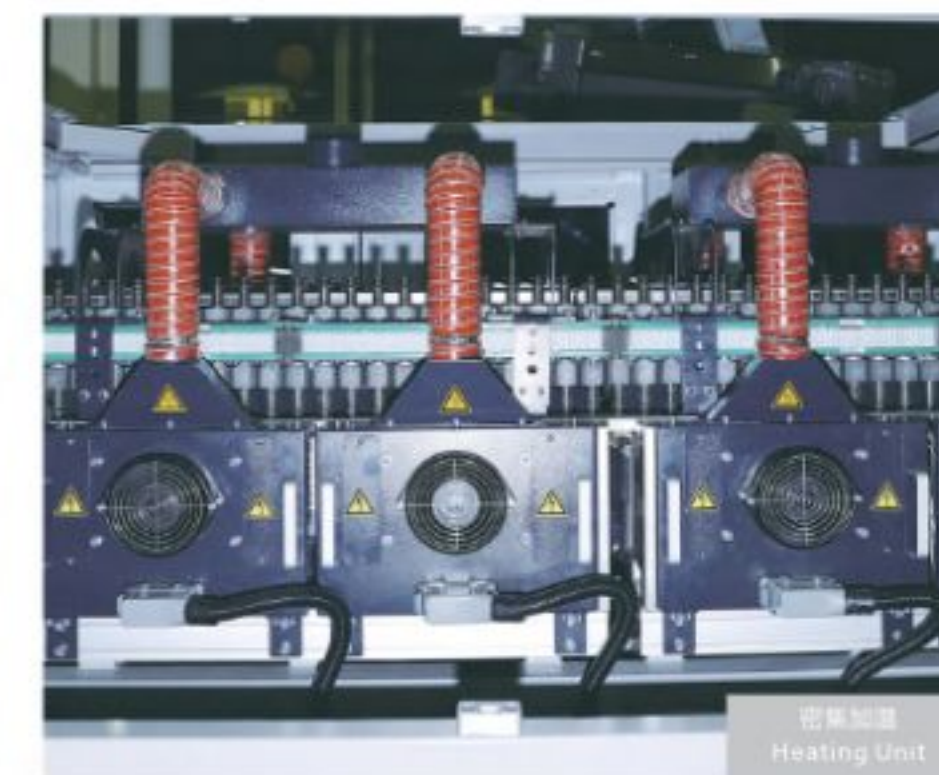
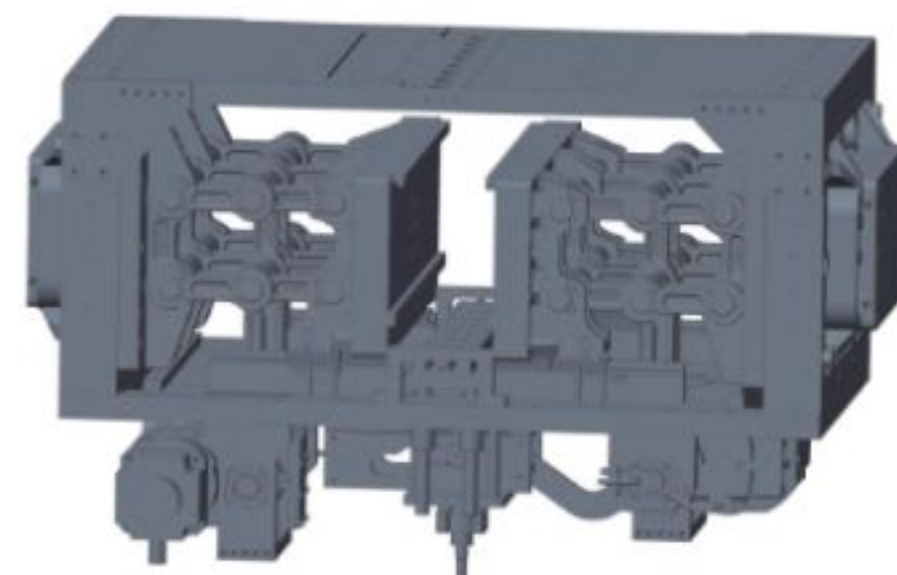


四板伺服合模（国家发明专利）

优点：伺服电机带动减速机驱动合模，底模凸轮联动实现快速合模快速开模。

Four plate servo clamping (national patent)

Advantage: servo motor drives gearbox and bottom cam working together for fast open and close mold.



TEC BLOW-生产PET小瓶的解决方案
TEC BLOW-SOLUTIONS FOR PET SMALL BOTTLES

	型号 Model	单位 Unit	RL-4II	RL-6II	RL-8- 500ML	RL-8II	RL-10II	RL-12- 500ML
成型组规格 Clamping System	模穴数(Number of cavity)	cavities	4	6	8	8	10	12
	模具行程(Mold stroke)	mm	0-130	0-130	0-90	0-130	0-90	0-90
	拉杆行程(Stretch stroke)	mm	340	340	250	340	250	250
	底模运动行程(Bottom stroke)	mm	50	50	30	50	30	30
	瓶子间距(Cavity distance)	mm	152.4	114.3	76.2	114.3	80	80
	加热间距(Heating distance)	mm	38.1/50.8	38.1/50.8	44.48	44.45	44.45	44.45
	胚头数(Number of holder)	PCS	74	96	178	178	178	178
瓶型规格 Container	瓶子最大容量(Max.container volume)	ltr	2.5	1.5	0.6	1.5	0.75	0.6
	牙部尺寸(外径)(Max. neck diameter)optional	mm	30/38	30/38	30	30/38	30	38
	最大瓶胚高度(Max.prefrom height)	mm	140	120	90	120	90	90
	最大瓶身直径(Max.container diameter)	mm	130	95	65	95	65	65
	最大瓶身高度(Max.container height)	mm	340	320	250	320	250	250
	※理论产能(theoretical output)	B.P.H	8000	12000	16000	16000	20000	24000
电控规格 Electrical System	加热箱数量(Heating oven)	UNITS	4	5	6	8	8	10
	(灯管道数量)(Box*channel)	层	12	10	9	10	10	10
	灯管数量(Number of lamp)	pcs	48	50	54	80	80	100
	最大加热配置功率(Heating power)	KW	57.6	60	54	96	96	120
	加热实际功率0.5L/15g Average power	KW	19.2	24	21	30	30	35
	电力总容量(Installed power)	KW	67	72	65	105	105	130
	电压(Voltage)	Voltage	220v/380V/50/60hz/3phase					
空压规格 Air System	操作压力(Operating pressure)	kg/cm ²	7					
	吹瓶压力(Blowing pressure)	mpa	3.0-3.8					
	高压空气耗氧量 (High pressure air consuming)	m ³ /min	4	6	8	12	9	12
冷却水规格 Chiller System	温度范围(Temperature)	°C	10-15					
	压力(Pressure)	Mpa	0.4					
	流量(Flow rate)	L/min	80	80	80	120	120	120
	额定功率(Heating power)	HP	8	8	10	10	10	15
机台规格 Machine	主机尺寸(L×W×H) (Machine dimension)	(主机/ machine)	6.5*2.2*2.6	6.5*2.2*2.6	7.8*1.7*2.6	7.8*1.7*2.6	7.8*1.7*2.6	8.5*1.7*2.6
	机台重量(Machine weight)	KG	7500	8000	9500	10000	10000	11000

注： 1 操作压力的低压气源，通过气体回收系统，将高压吹瓶排气回收利用，无需单独配置低压空压机设备
Note1: The high pressure air exhausted after blowing is recovered, which can be instead of low pressure compressor
2 实际产量，需根据客户所提供的瓶型规格和瓶坯设计的品质而定
Note2: Actual production depends on customers' bottle shape, preform design and quality

TEC BLOW-5L/20L-生产PET大瓶的解决方案
TEC BLOW-5L/20L-SOLUTION FOR PET LARGE BOTTLES

	型号Model	单位Unit	RL-2-5L	RL-4-5L	RL2-15L	RL-2-20L
成型组规格 Clamping System	模穴数(Number of cavity)	cavities	2	4	2	2
	模具行程(Mold stroke)	mm	0-200	0-200	266	350
	拉杆行程(Stretch stroke)	mm	360	360	400	450
	底模运动行程(Bottom stroke)	mm	50	50	80	80
	瓶子间距(Cavity distance)	mm	203.2	203.2	266	330.2
	加热间距(Heating distance)	mm	76.2	76.2	76.2	101.6
	胚头数(Number of holder)	PCS	74	96	85	96
瓶型规格 Container	瓶子最大容量(Max.container volume)	ltr	5	5	15	20
	牙部尺寸(外径)(Max. neck diameter) optional	mm	48	48	55	85
	最大瓶胚高度(Max.prefrom height)	mm	160	160	200	300
	最大瓶身直径(Max.container diameter)	mm	180	180	250	300
	最大瓶身高度(Max.container height)	mm	360	360	400	550
※理论产能 theoretical output		B.P.H	2000	3500-4000	1200	1200
电控规格 Electrical System	加热箱数量(Heating oven)	UNITS	4	6	8	10
	(灯管道数量)(Box*channel)	层	12	12	16-20	16-20
	灯管数量(Number of lamp)	pcs	48	96	96	128
	最大加热配置功率(Heating power)	KW	57	86	96	115.2
	加热实际功率 Average power	KW	28	56	40	55
	电力总容量(Installed power)	KW	67	92	115	125
	电压(Voltage)	Voltage	220v/380V/50/60hz/3phase			
空压规格 Air System	操作压力(Operating pressure)	kg/cm ²	7			
	吹瓶压力(Blowing pressure)	mpa	3.0-3.8			
	高压空气耗氧量(High pressure air consuming)	m ³ /min	6	12	8	12
冷却水规格 Chiller System	温度范围(Temperatur e)	°C	10-15			
	压力(Pressure)	Mpa	0.4			
	流量(Flow rate)	L/min	60	100	80	80
	额定功率(Heating power)	HP	8	10	10	10
机台规格 Machine	主机尺寸(L×W×H)(Machine dimension)	(加热/heating)	3.3*2.2*2.5	1.0*3.*2.5	1.0*3.0*2.5	7.8*2.2*2.6
		(主机/machine)		2.5*2.0*2.5	2.0*2.2*2.5	
	机台重量(Machine weight)	KG	6500	8000	8500	12000

注： 1 操作压力的低压气源，通过气体回收系统，将高压吹瓶排气回收利用，无需单独配置低压空压机设备
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Note2: Actual production depends on customers' bottle shape, preform design and quality

AOK-2000全自动吹瓶机

Full Automatic Blow Molding Machine

- 采用模块化设计，减少占地面积，零配件可以互换
- 线性式结构，滑块采用特殊材料热压铸成型，轮子设计无凹角，运转平顺
- 瓶口环状不锈钢防夹装置和一体式铝合金冷却装置，保护瓶颈加热不变形，提高瓶子和瓶盖的密封性，延长内装物的保质期
- 各组红外线灯管独立的热平衡调节装置使瓶坯加热时温度一致和瓶子外观色泽均匀，提高成品率
- 带预吹可调试功能的大流量二级吹气装置
- 采用光电控制预吹和吹气设置，使拉伸时间不会受气压波动的影响，达到瓶子上下壁厚的均匀和一致性。

- Use modular design, reduced the occupation area it's easy to change spare parts
- Use the linear type structure, Compact space for convience of mold-conversion, repairing and maintenance
- The mouth of the annular stainless steel clamping device and integral aluminum alloy cooling device, protect the bottleneck heating deformation, improve the bottle and the bottle cap sealing, prolong the life of the contents
- The groups of infrared lamp independent thermal balance adjusting device of the bottle blank heating when the temperature uniformity and the bottle exterior color uniform,improve the rate of finished products
- If you take a blow can debug function of large flow two stage blowing device
- Adopted photoelectric control pre-blowing and blowing settings, the La time is not affected by pressure fluctuationsup to the bottle on wall thickness uniformity and consistency



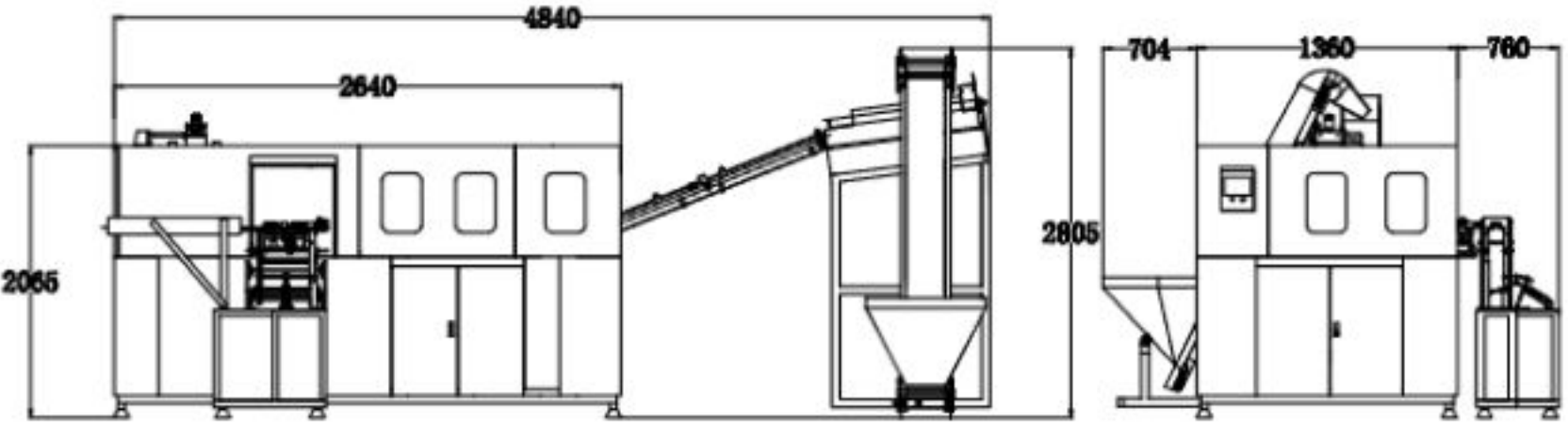
机台规格配置表

Machine Specification



机台规格配置表

Machine Specification



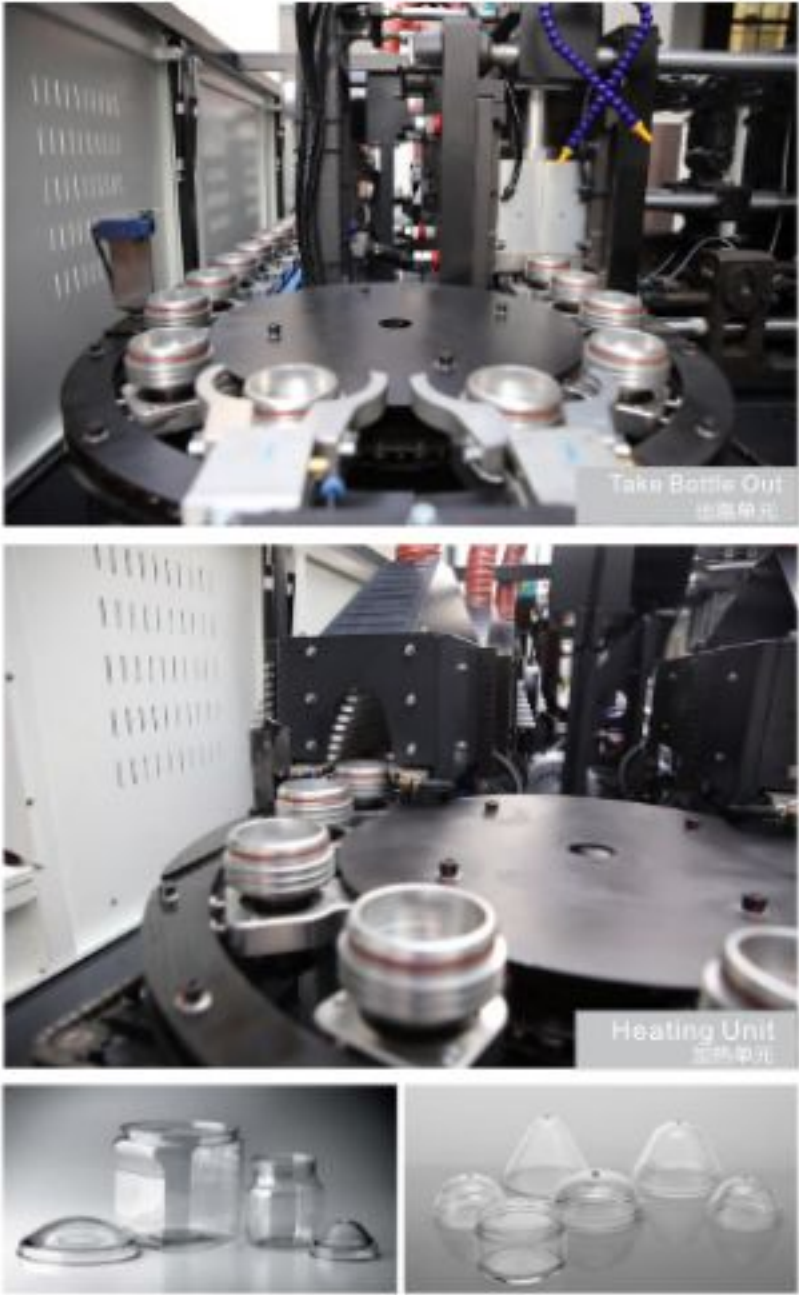
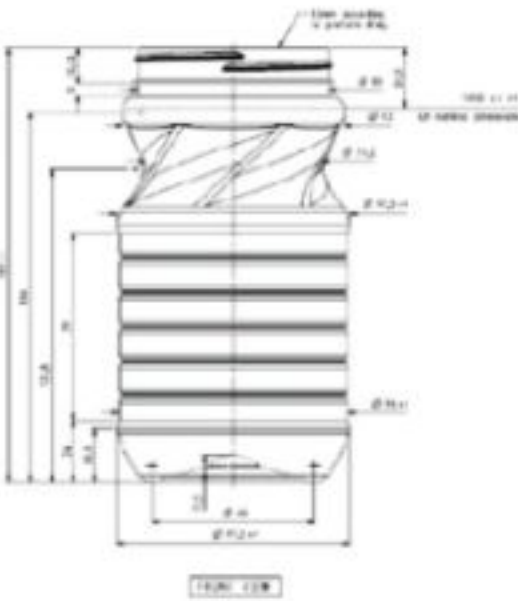
	型号Model	单位Unit	AOK-2000 (Standard)	AOK-2000 (Feeding By Hand)
成型组规格 Clamping System	模穴数 (Number of cavity)	cavities	2	2
	锁模力 (calmping unit)	KG	20000	20000
	模具行程 (mold stroke)	mm	120	120
	拉杆行程 (stretch stroke)	mm	320	320
	底模行程 (Bottom stroke)	mm	30	30
	瓶子间距 (Cavity pitch)	mm	120	120
	加热间距 (heating pitch)	mm	55	55
	胚头数 (Number of holder)	PCS	64	64
瓶型规格 Container	瓶子最大容量 (Max.container volume)	ltr	2.0	2.0
	牙部尺寸 (外径) (Max. neck diameter)	mm	32/38	32/38
	最大瓶胚高度(Max.prefrom height)	mm	140	140
	最大瓶身直径(Max.container diameter)	mm	105	105
	最大瓶身高度(Max.container height)	mm	320	320
	※理论产能 (theoretical output)	B.PH	2200	2200
电控规格 Electrical System	加热箱数量 (heating oven)		2	2
	(箱数×灯管道数) box*channel	UNITS	2*9	2*9
	灯管数量 (Number of lamp)	pcs	18	21.6
	加热配置功率 (heating power)	KW	21.6	24
	电力总容量 (installed power)	KW	25.5	25.5
	电压 (voltage)	Voltage	220v/380V/3phase	220v/380V/3phase
空压规格 Air System	操作压力 (operating pressure)	Kg/m	7	7
	吹瓶压力 (blowing pressure)	mpa	3.5	3.5
	高压空气耗氧量 (high pressure air consuming)	L/min	20000	20000
	配置功率 (power)	m3/min	2.4	2.4
冷却水规格 Chiller System	温度范围 (temperature)	℃	10-15	10-15
	压力 (pressure)	Mpa	0.3-0.5	0.3-0.5
	流量 (flow rate)	L/min	40	40
	额定功率 (heating power)	HP	4	4
机台规格 Machine	主机尺寸(L×W×H) (machine dimension)	M	2.6*1.6*1.8	2.6*1.6*1.8
	机台重量 (machine weight)	KG	3000	3000

AOK-2000JAR

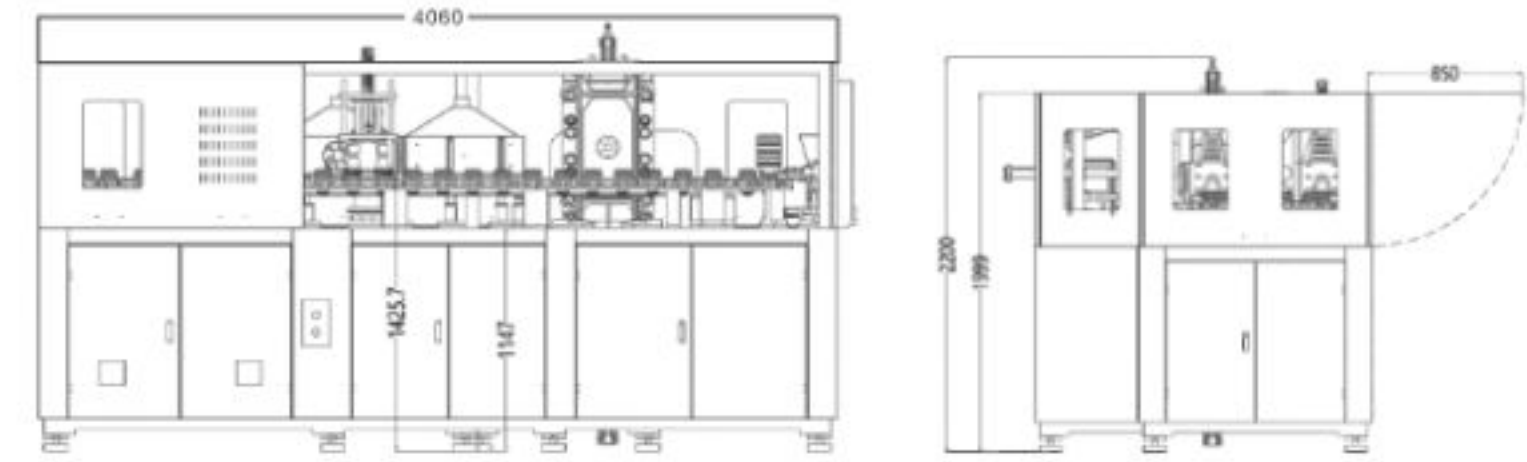
窄口化妆品吹瓶机/广口吹瓶机

Narrow-mouth Cosmetic Blowing Molding Description Of Application

- 精能机械有3600的窄口/大口径瓶总体解决方案
- 窄口/大口径专用瓶的设计
- 窄口/大口径专用瓶坯的设计, 我们知道怎样设计让材料分布更均匀
- 新型窄口/大口径瓶吹嘴设计, 吹瓶时无泄漏
- 提供窄口/大口径注坯模具的设计和瓶坯产品
- 提供合作伙伴高质量的瓶坯
- Aoktac offers A 3600 solution including
- Jar bottle design development
- Pet preform design development
- New Nozzle design for blowing
- Provision of injection molds and production of sample
- Preforms by qualified partners



机台规格配置表 Machine Specification



	型号Model	单位Unit	AOK-2000JAR-L 中广口	AOK-2000JAR-L 大广口	AOK-4000JAR	AOK-6000JAR
成型组规格 Clamping System	模穴数 (Number of cavity)	cavities	2	2	4	6
	锁模力 (calmping unit)	KG	48000	48000	48000	56000
	模具行程 (mold stroke)	mm	180	220	130	130
	拉杆行程 (stretch stroke)	mm	320	340	280	200
	底模行程 (Bottom stroke)	mm	30	50	50	30
	瓶子间距 (Cavity pitch)	mm	152.4	190.5	114.3	76.2
	加热间距 (heating pitch)	mm	152.4	190.5	114.3	76.2
	胚头数 (Number of holder)	PCS	66	66	72	72
瓶型规格 Container	瓶子最大容量 (Max.container volume)	ltr	3	5	0.5	0.6
	牙部尺寸 (外径) (Max. neck diameter)	mm	130	150	80	65
	最大瓶胚高度(Max.preform height)	mm	130	150	115	100
	最大瓶身直径(Max.container diameter)	mm	135	175	105	65
	最大瓶身高度(Max.container height)	mm	280	340	250	200
	※理论产能 (theoretical output)	B.PH	1200-1600	1000-1200	2400	3800
电控规格 Electrical System	(箱数×灯管道数) box*channel	UNITS	4*12	4*12	8*9	10*7
	灯管数量 (Number of lamp)	pcs	48	48	72	70
	加热配置功率 (heating power)	KW	48	48	72	70
	电力总容量 (installed power)	KW	52	52	84	82
	实际用电 (Actual electricity consumption)	KW	25	25	35	35
	电压 (voltage)	Voltage	220v/380V/3phase	220v/380V/3phase	220v/380V/3phase	220v/380V/3phase
空压规格 Air System	操作压力 (operating pressure)	kg/m3	7	7	7	7
	吹瓶压力 (blowing pressure)	mpa	3.5	3.3	3.3	3.3
	高压空气耗氧量 (high pressure air consuming)	L/min	3200	3200	3200	3200
	配置功率 (power)	KW	36	18	18	18
冷却水规格 Chiller System	温度范围 (temperature)	°C	10-15	10-15	10-15	10-15
	压力 (pressure)	Mpa	0.3-0.5	0.3-0.5	0.3-0.5	0.3-0.5
	流量 (flow rate)	L/min	40	40	40	40
	额定功率 (heating power)	HP	5	5	5	5
机台规格 Machine	主机尺寸(L×W×H) (machine dimension)	M	3.8*2.0*2.2	4.8*2.2*2.2	6.5*2.2*2.2	6.5*2.2*2.2
	机台重量 (machine weight)	KG	4500	5500	6000	6000



AOK-4000 全自动吹瓶机
Full Automatic Blow Molding Machine

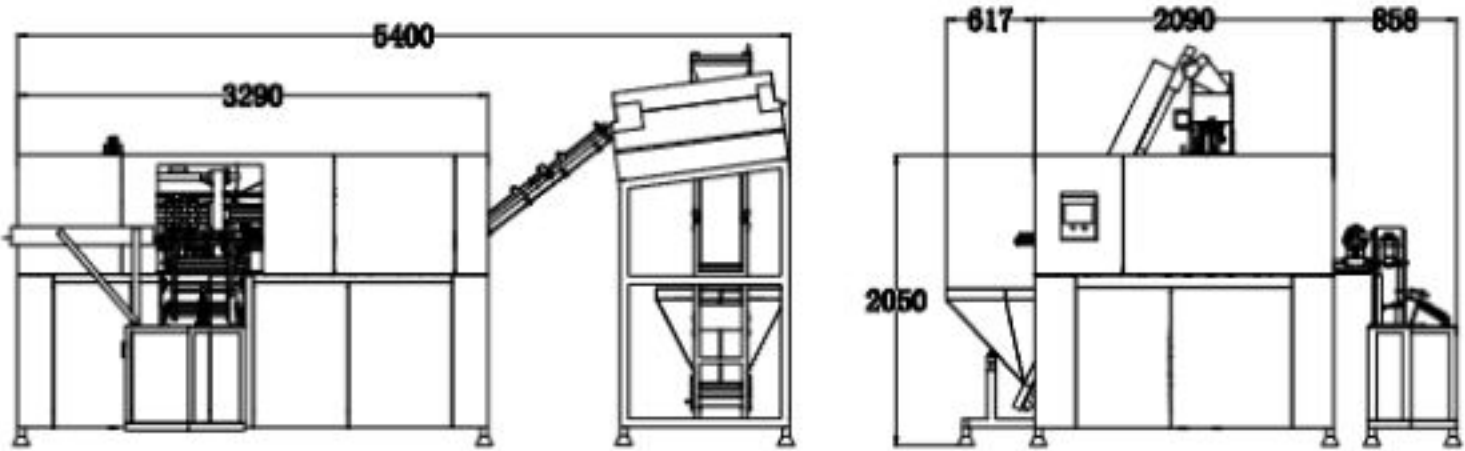
- 机器全自动操作
 - 专利单通道上胚机构
 - 采用双排灯管加热，加热密集，更加节能
 - 加热单元每组和每支灯管可调，采用恒定电压控制
 - 触摸式操作简单方便
 - 模块化设计拆装便捷
 - 智能模块化高压吹气组合阀
 - 采用液压混合驱动开合模
 - 采用高级米汉纳铸铁的开关模系统
- Use double heating oven, heating densed, saving more energy
 - Automatic feeding, heating, blowing with air system
 - Potented preform feeding system for easy and safety
 - Heating system for each lamp adjustment and constont
 - voltage control system
 - Touch scree human-machine interface for easy operation
 - Modular component design for easy maintenance
 - Compact design for effective usoge of floor space
 - Intelligence flow control with high pressure valve



结构示意图
Structure Diagram



机台规格配置表
Machine Specification



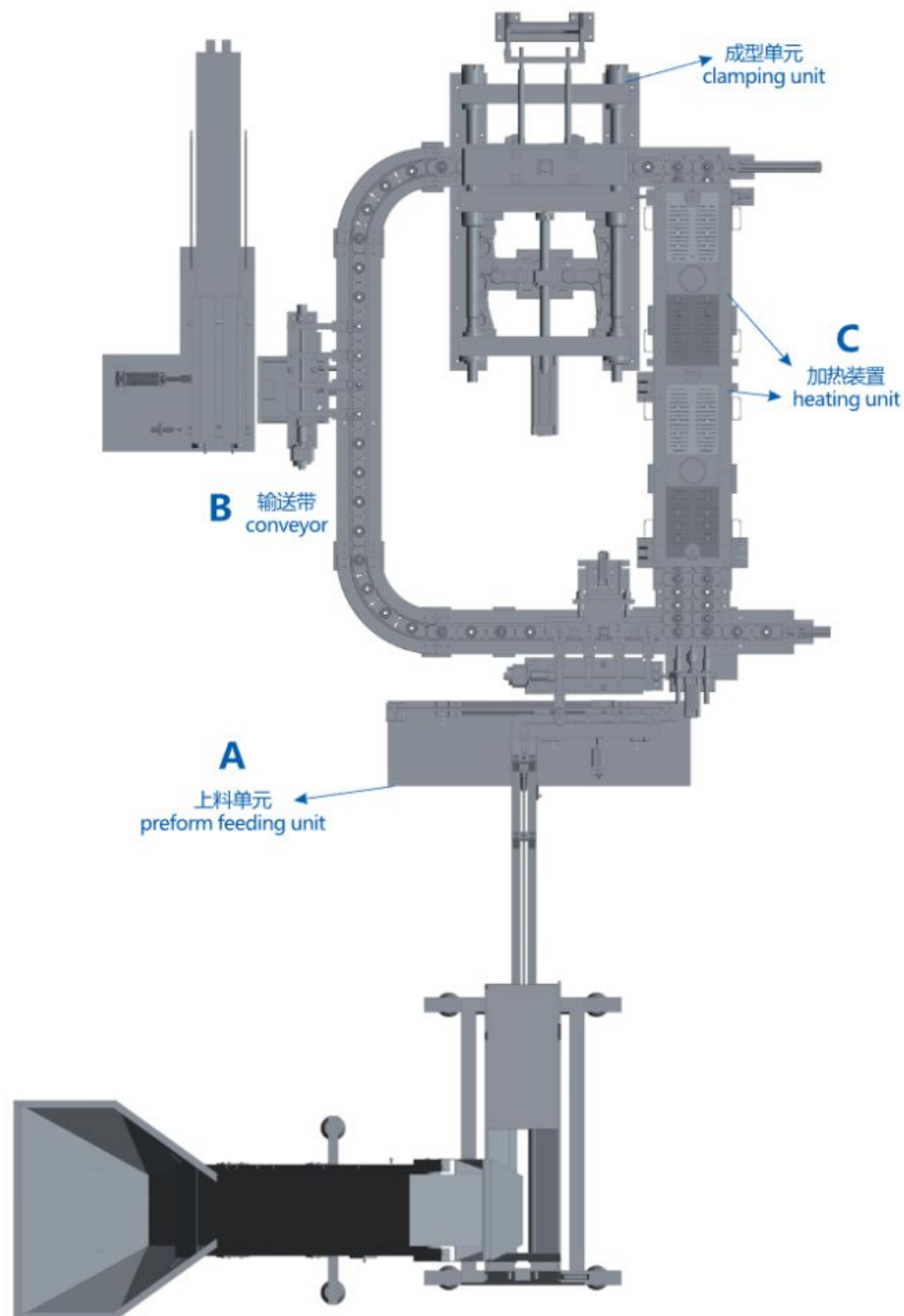
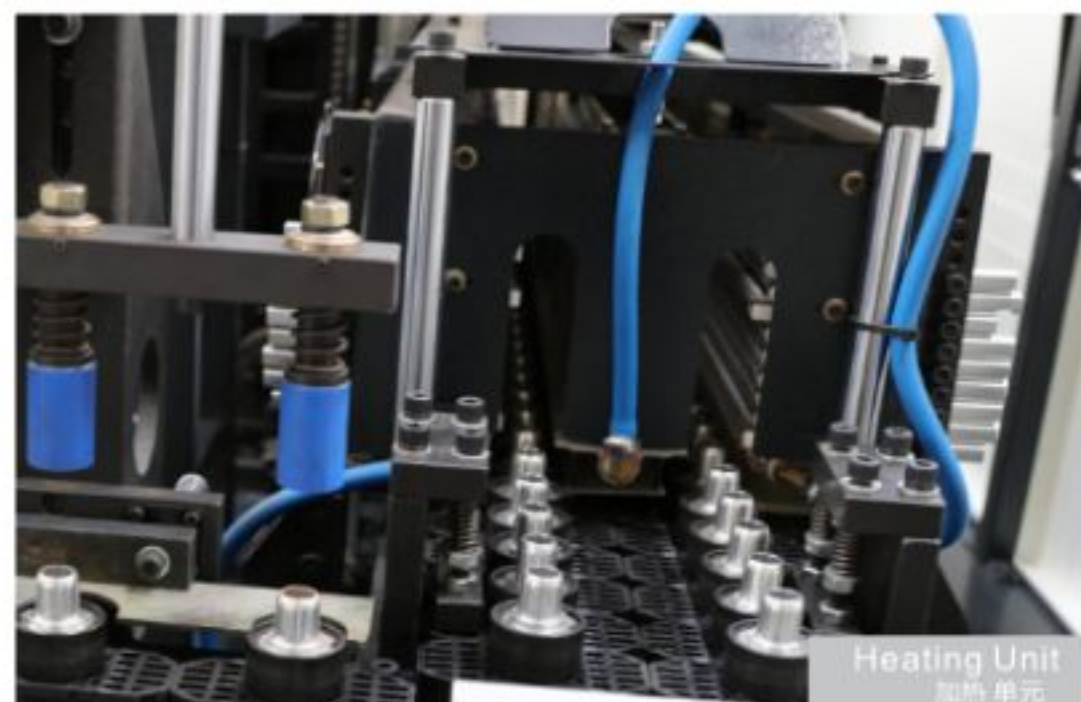
	型号Model	单位Unit	AOK-4000-L
成型组规格 Clamping System	模穴数 (Number of cavity)	cavities	4
	锁模力 (calmping unit)	KG	48000
	模具行程 (mold stroke)	mm	130
	拉杆行程 (stretch stroke)	mm	340
	底模行程 (Bottom stroke)	mm	30
	瓶子间距 (Cavity pitch)	mm	120
	加热间距 (heating pitch)	mm	55
	胚头数 (Number of holder)	PCS	114
瓶型规格 Container	瓶子最大容量 (Max.container volume)	ltr	2
	牙部尺寸 (外径) (Max. neck diameter)	mm	38
	最大瓶胚高度(Max.prefrom height)	mm	140
	最大瓶身直径(Max.container diameter)	mm	110
	最大瓶身高度(Max.container height)	mm	340
电控规格 Electrical System	※理论产能 (theoretical output)	B.PH	4000
	加热箱数量 (heating oven)	UNITS	4
	(箱数×灯管道数) box*channel		4*12
	灯管数量 (Number of lamp)	pcs	48
	加热配置功率 (heating power)	KW	57.6
	电力总容量 (installed power)	KW	65
	电压 (voltage)	Voltage	220v/380V/3phase
空压规格 Air System	操作压力 (operating pressure)	kg/cm2	7
	吹瓶压力 (blowing pressure)	mpa	3.5
	高压空气耗氧量 (high pressure air consuming)	L/min	4200
	配置功率 (power)	KW	44
冷却水规格 Chiller System	温度范围 (temperature)	°C	10-15
	压力 (pressure)	Mpa	0.3-0.5
	流量 (flow rate)	L/min	80
	额定功率 (heating power)	HP	5
机台规格 Machine	主机尺寸(L×W×H) (machine dimension)	M	3.8*2.0*2.0
	机台重量 (machine weight)	KG	4800

A 入胚系统

输送带将瓶胚从料筒至整列机，再将瓶胚自动排列成序单道送胚采用 FESTO 无杆气缸进行分胚动作及定位，入胚夹爪将瓶胚至公转滑块上，减少卡胚造成停机或者浪费瓶胚

A Preform Feeding System

The conveyor put the preform from the barrel to the entire machine, then the preform are automatic arranged in order for feeding in a single way Adopt FESTO rodless cylinder to divide into blank movement and positioning The clipper picks preforms and place them on the transfer system The way will avoid preforms jamming or wasting preforms



B 公转系统

传统直线机公转采用链条转动或者气缸驱动，气缸驱动时，往返动作，速度缓慢，导致效率低，链条驱动时，噪音较大，AOK系列采用铸压尼龙滑块组成，并有伺服电机驱动，噪音小，磨损小，环保卫生

B Transfer System

The traditional linear machine is normal transmitted by chain or air cylinder, when cylinder drives, the speed is slow, efficiency is down, when chain drives, it is too noisy, AOK series composed of the casting nylon slider with servo motor drive, providing fast and which can meet environmental requirements

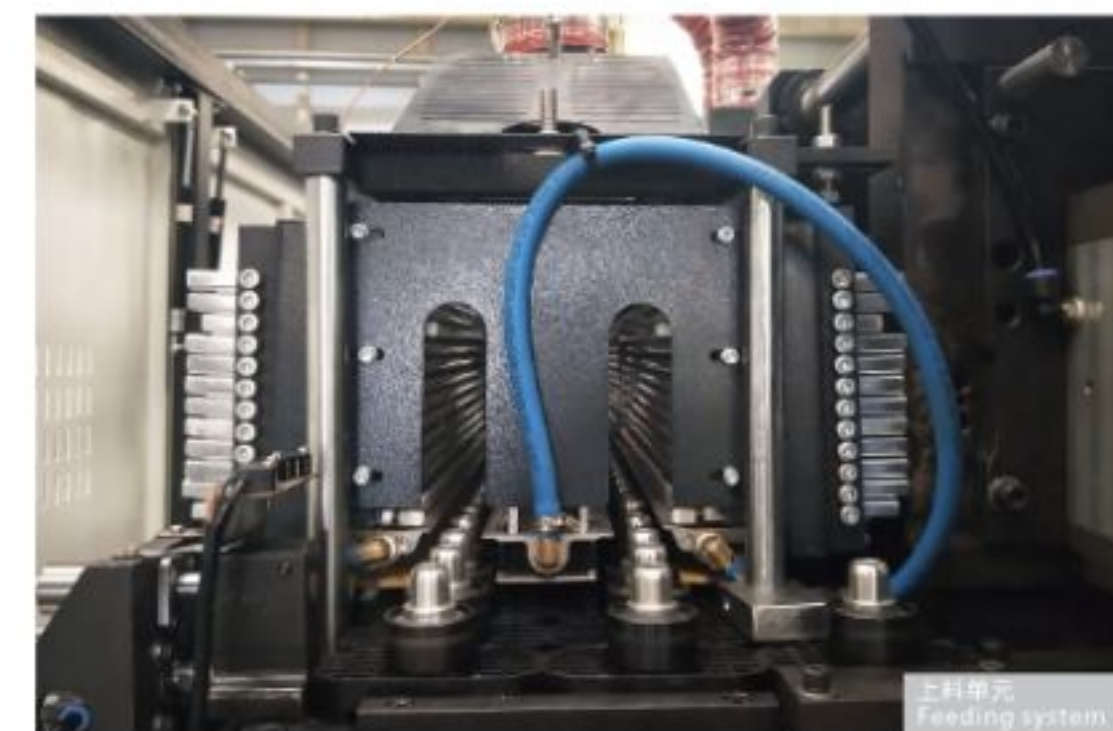


C 加热系统

瓶胚滑块并列式进入加热单元，并以俩瓶胚之最小中心距排列，已达到节约能耗的目的瓶胚座以自转方式边加热边风冷水冷，确保瓶胚里外受热均匀加热

C The Heating System

Preforms are feeding to the heating system in a parallel, together with minimum center between two preforms, in order to make shortest distance to heat, saving more energy Preforms go with rotation mode heat and cooling, to ensure heating averagely

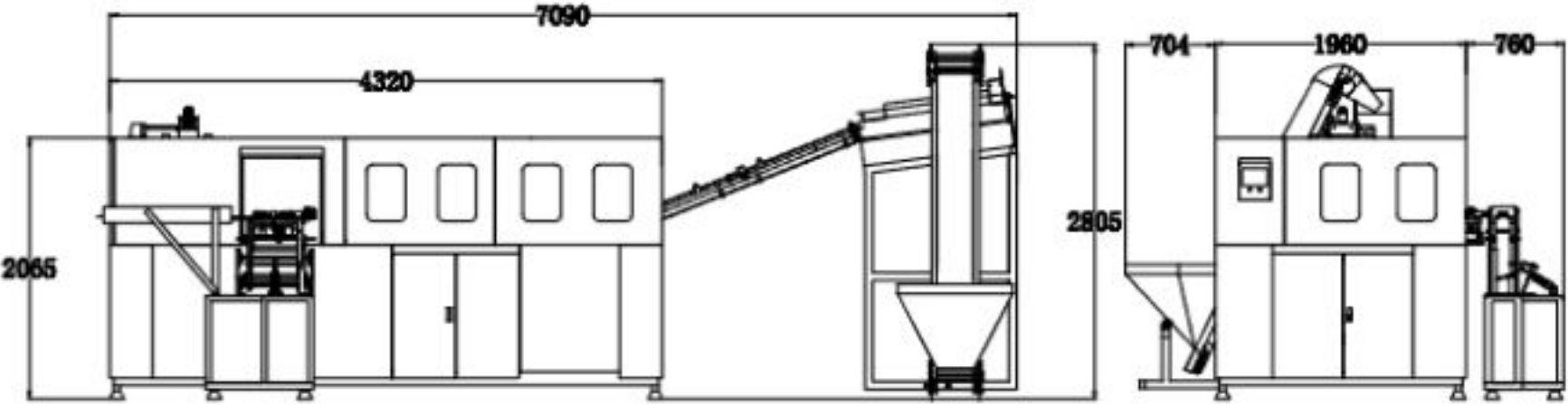


AOK-20L 全自动吹瓶机
Full Automatic Blow Molding Machine

- 机器全自动操作
- 专利单通道上胚机构
- 开关模采用油电混合驱动，锁模力大
- 采用铝合金制造的高压吹气组合阀，可有气体回收装置，减少能源消耗，保护环境
- 触摸式操作简单方便
- 模块化设计拆装便捷
- 采用PID恒定控制烤箱瓶胚加热和风机排风
- 采用高级米汉纳铸铁的开关模系统
- Use senior Mihana cost iron of clamping unit and moving system
- Use hydrid drive for clamping, clamping strong
- Use PID constant control heating unit of the wind motor
- Touch scree human-machine interface for easy operation
- Modular component design for easy maintenance
- Use module type of the high pressure blowing valve combined with air recycling system, saving energy and protecing theenvironment



机台规格配置表
Machine Specification



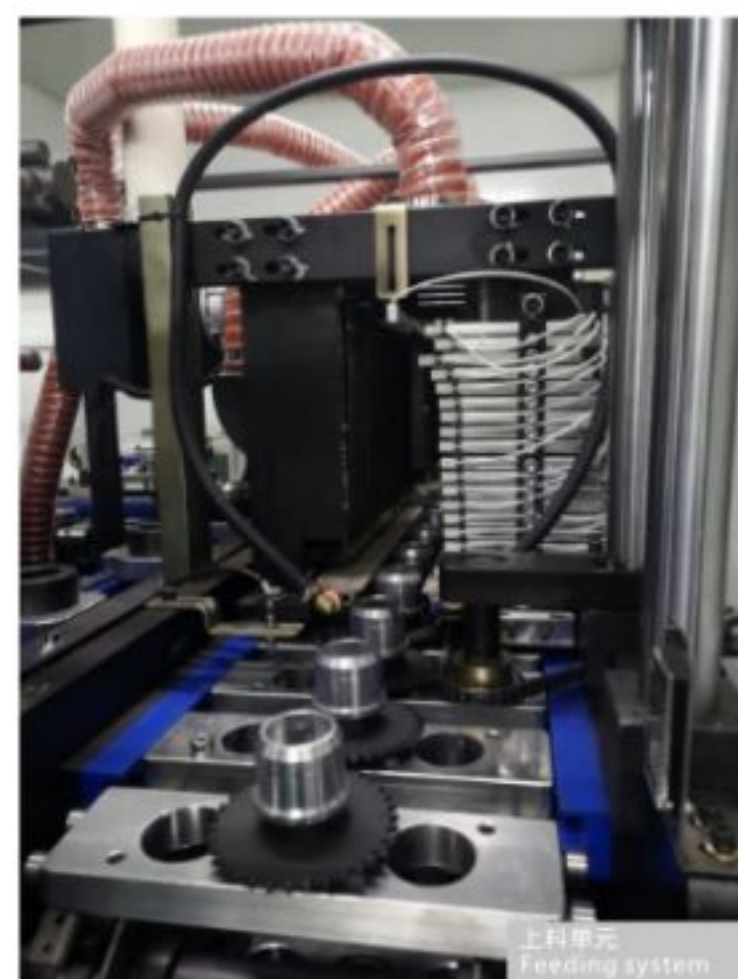
型号Model		单位Unit	AOK-5L	AOK-10L	AOK-20L	AOK-30L KEG
成型组规格 Clamping System	模穴数 (Number of cavity)	cavities	2	2	1	1
	锁模力 (calmping unit)	KG	48000	55000	65000	6500
	模具行程 (mold stroke)	mm	200	240	300	300
	拉杆行程 (stretch stroke)	mm	360	320	400	400
	底模行程 (Bottom stroke)	mm	50	50	50	50
	瓶子间距 (Cavity pitch)	mm	200	200	300	320
	加热间距 (heating pitch)	mm	75	75	75	75
	胚头数 (Number of holder)	PCS	66	66	70	70
瓶型规格 Container	瓶子最大容量 (Max.container volume)	ltr	5	10	20	30
	牙部尺寸 (外径) (Max. neck diameter)	mm	45	55	72	80
	最大瓶胚高度 (Max.prefrom height)	mm	140	250	250	250
	最大瓶身直径 (Max.container diameter)	mm	180	210	250	430
	最大瓶身高度 (Max.container height)	mm	360	430	430	310
电控规格 Electrical System	※理论产能 (theoretical output)	B.PH	1200	900	500	200
	加热箱数量 (heating oven)	UNITS	2	3	4*4	4
	(箱数*灯管道数) (box*channel)		2*12	3*12	4*17	4*17
	灯管数量 (Number of lamp)	pcs	24	72	68	68
	加热配置功率 (heating power)	KW	48	78	81	81
	电力总容量 (installed power)	KW	56	50	92	92
	电压 (voltage)	Voltage	220v/380V/3phase	220v/380V/3phase	220v/380V/3phase	220v/380V/3phase
空压规格 Air System	操作压力 (operating pressure)	kg/cm2	7	7	7	7
	吹瓶压力 (blowing pressure)	mpa	3.5	3.5	3.5	3.5
	高压空气耗氧量 (high pressure air consuming)	L/min	3600	5000	5000	5000
	配置功率 (power)	KW	32	44	44	44
冷却水规格 Chiller System	温度范围 (temperature)	°C	10-15	10-15	10-15	10-15
	压力 (pressure)	Mpa	0.4	0.4	0.3-0.5	0.3-0.5
	流量 (flow rate)	L/min	90	200	250	250
	额定功率 (heating power)	HP	5	5	5	5
机台规格 Machine	主机尺寸 (L×W×H) (machine dimension)	M	3.5*2.0*2.0	4.8*2.0*2.0	5.6*2.9*2.2	5.6*2.9*2.2
	机台重量 (machine weight)	KG	4500	6500	7000	7000

A 入胚系统

输送带将瓶胚从料筒至整列机，再将瓶胚自动排列成序单道送胚，采用伺服电机单通道上胚，进行分胚动作及定位，入胚夹爪将瓶胚至公转滑块上，减少卡胚造成停机或者浪费瓶胚

A Preform Feeding System

The conveyor put the preform from the barrel to the entire machine, then the preform are automatic arranged in order for feeding in a single way, uses servo drive chain feeding system Adopt FESTO rodless cylinder to divide into blank movement and positioning The clipper picks preforms and place them on the transfer system The way will avoid preforms jamming or wasting preforms



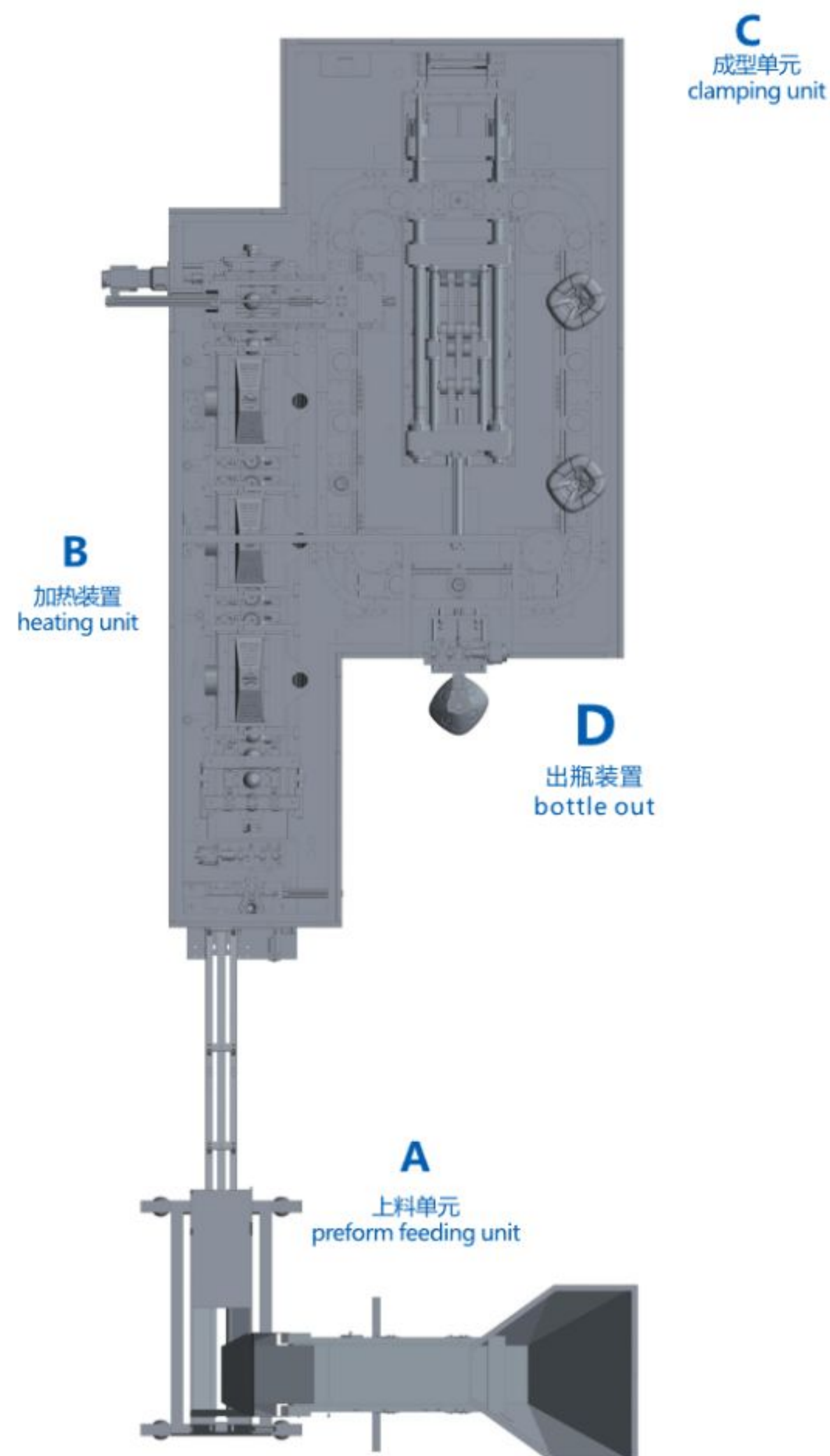
上料单元
Feeding system

B 公转系统

传统直线机公转采用链条转动或者气缸驱动，气缸驱动时，往返动作，速度缓慢，导致效率低，链条驱动时，噪音较大，AOK系列采用铸压尼龙滑块组成，并有伺服电机驱动，噪音小，磨损小，环保卫生

B Transfer System

The traditional linear machine is normal transmitted by chain or air cylinder, when cylinder drives, the speed is slow, efficiency is down, when chain drives, it is too noisy, AOK series composed of the casting nylon slider with servo motor drive, providing fast and which can meet environmental requirements



B
加热装置
heating unit

C
成型单元
clamping unit

D
出瓶装置
bottle out

A
上料单元
preform feeding unit



成型单元
Clamping unit

C 加热系统

瓶胚滑块并列式进入加热单元，并以俩瓶胚之最小中心距排列，已达到节约能耗的目的瓶胚座以自转方式边加热边风冷水冷，确保瓶胚里外受热均匀加热

C The Heating System

Preforms are feeding to the heating system in a parallel, together with minimum center between two preforms, in order to make shortest distance to heat, saving more energy Preforms go with rotation mode heat and cooling, to ensure heating averagely



加热单元
Heating unit

AOK-6000E 全自动吹瓶机
Full Automatic Blow Molding Machine

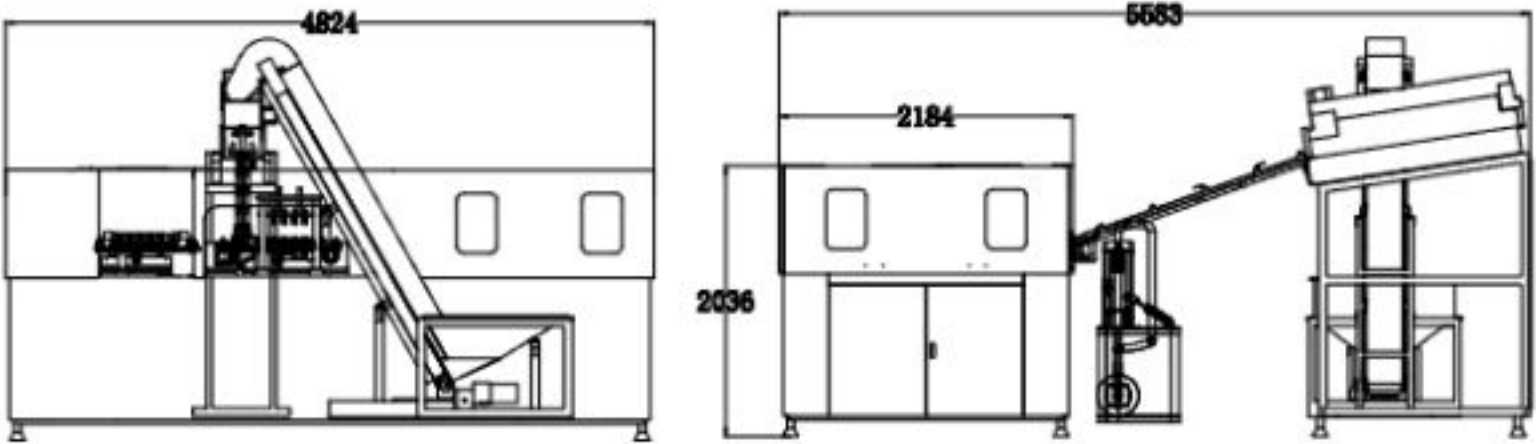
- 采用伺服电机驱动环形链条
- 采用伺服单通道上胚
- 采用液压锁模加上高压补偿锁模
- 采用美铝合金制造的高压吹气组合阀，可有气体回收装置，减少能源消耗，保护环境
- 采用PID恒定控制烤箱瓶胚加热和风机排风
- 采用高级米汉纳铸铁的开关模系统
- Use double heating oven, heating densed, saving more energy
- Automatic feeding, heating, blowing with air system
- Patented preform feeding system for easy and safety
- Heating system for each lamp adjustment and constant voltage control system
- Touch scree human-machine interface for easy operation
- Modular component design for easy maintenance
- Compact design for effective usage of floor space
- Intelligence flow control with high pressure valve



结构示意图
Structure Diagram



机台规格配置表
Machine Specification



型号Model		单位Unit	AOK-6000E	AOK-6000	AOK-4000E	AOK-4000
成型组规格 Clamping System	模穴数 (Number of cavity)	cavities	6	6	4	4
	锁模力 (calmping unit)	KG	56000	65000	5600	56000
	模具行程 (mold stroke)	mm	90	130	130	130
	拉杆行程 (stretch stroke)	mm	250	320	320	320
	底模行程 (Bottom stroke)	mm	30	30	30	30
	瓶子间距 (Cavity pitch)	mm	76.2	114.3	114.3	114.3
	加热间距 (heating pitch)	mm	76.2	114.3	114.3	114.3
	胚头数 (Number of holder)	PCS	114	114	114	76
瓶型规格 Container	瓶子最大容量 (Max.container volume)	ltr	0.6	1.5	1.5	1.5
	牙部尺寸 (外径) (Max. neck diameter)	mm	38	38	38	38
	最大瓶胚高度 (Max.preform height)	mm	100	140	100	160
	最大瓶身直径 (Max.container diameter)	mm	65	95	65	95
	最大瓶身高度 (Max.container height)	mm	250	320	320	320
※理论产能 (theoretical output)		B.PH	9000	6000	6000	4000
电控规格 Electrical System	加热箱数量 (heating oven)	UNITS	8*8	8*8	8*8	8*8
	(箱数*灯管道数) (box*channel)		8*7	8*9	8*9	8*10
	灯管数量 (Number of lamp)	pcs	56	72	72	80
	加热配置功率 (heating power)	KW	67.5	86.4	86.4	96
	电力总容量 (installed power)	KW	75	95	95	106
	电压 (voltage)	Voltage	220v/380V/3phase	220v/380V/3phase	220v/380V/3phase	220v/380V/3phase
空压规格 Air System	操作压力 (operating pressure)	kg/cm2	7	7	7	7
	吹瓶压力 (blowing pressure)	mpa	3.5	3.5	3.5	3.5
	高压空气耗氧量 (high pressure air consuming)	L/min	5600	6400	8000	5600
	配置功率 (power)	KW	66	88	88	66
冷却水规格 Chiller System	温度范围 (temperature)	°C	10-15	10-15	10-15	10-15
	压力 (pressure)	Mpa	0.4	0.4	0.3-0.5	0.4
	流量 (flow rate)	L/min	80	80	100	80
	额定功率 (heating power)	HP	5	5	5	5
机台规格 Machine	主机尺寸 (L×W×H)(machine dimension)	M	4.8*2.2*1.8	5.6*2.2*1.8	6.2*2.2*2.0	4.8*2.2*1.8
	机台重量 (machine weight)	KG	5500	6500	5500	5500

A 入胚系统

输送带将瓶胚从料筒至整列机，再将瓶胚自动排列成序单道送胚，采用伺服电机单通道上胚，进行分胚动作及定位，入胚夹爪将瓶胚至公转滑块上，减少卡胚造成停机或者浪费瓶胚

A Preform Feeding System

The conveyor put the preform from the barrel to the entire machine, then the preform are automatic arranged in order for feeding in a single way, uses servo drive chain feeding system Adopt FESTO rodless cylinder to divide into blank movement and positioning The clipper picks preforms and place them on the transfer system The way will avoid preforms jamming or wasting preforms



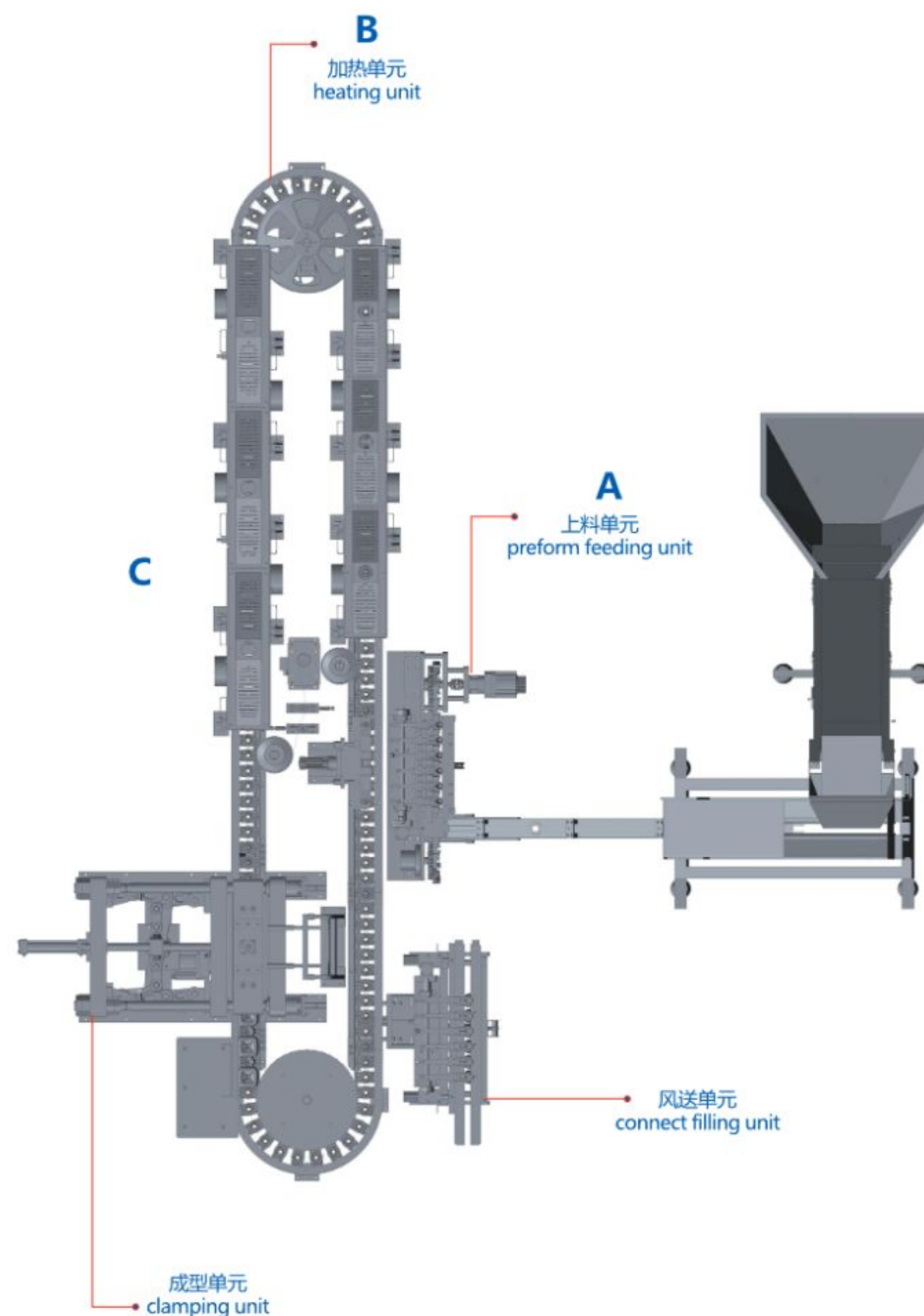
上料单元
Feeding unit

B 公转系统

传统直线机公转采用链条转动或者气缸驱动，气缸驱动时，往返动作，速度缓慢，导致效率低，链条驱动时，噪音较大，AOK系列采用铸压尼龙滑块组成，并有伺服电机驱动，噪音小，磨损小，环保卫生

B Transfer System

The traditional linear machine is normal transmitted by chain or air cylinder, when cylinder drives, the speed is slow, efficiency is down, when chain drives, it is too noisy, AOK series composed of the casting nylon slider with servo motor drive, providing fast and which can meet environmental requirements



主轴伺服驱动
Spindle servo motor drive



吹塑模
blow mold



伺服拉伸
Servo Stretching