

BP-8170-D2

DOUBLE STATION VULCANIZING MACHINE/PLC CONTROL

This machine applies to the compression and moulding of rubber, plastics, resins and other polymer materials. The machine is equipped with PLC programmable LCD display, which can set pressure, temperature, time, exhausting frequency and the number of seconds. Human-machine interface operating system, real-time display and monitoring of vulcanization process (curve variation), and fully automatic completion of molding program. It has the characteristics of strong pressure and wide application.

1. Capacity: 100T
 2. Working mode: Manual and automatic modes
 3. Maximum working pressure: 25Mpa
 4. Controller: PLC programmable color touch screen, man-machine interface operating system, vulcanization curve interface intuitively, dynamic display and monitoring of mold pressure process, can control all mold pressure circulation.
 5. Temperature range: Normal temperature \sim 300 $^{\circ}$ C
 6. Temperature accuracy: \pm 2 $^{\circ}$ C
 7. Heating type: Electric heating tube
 8. Vulcanization time: 0-999, 3 sections
 9. Pressure plate layers: Left and right double molded combination structure, single layer working area, can choose left and right molded plate heating or cooling
 10. Pressure plate size: 400 \times 400mm/500 \times 500mm, other sizes can be customized
 11. Distance of pressure plate: 300mm
 12. Pressure plate surface: HRC60 hard chrome treatment
 13. Gradient pressure: 3 stages, each stage pressure can be preset
 14. Sensor: Specially configured
 15. Valve plate in special type: Specially configured
 16. Double proportional valve: Specially configured
 17. Exhausting frequency: 0 \sim 10 times can be set.
 18. Exhausting pause: Yes
 19. Oil pressure system: Closed loop control system of electro-hydraulic proportional servo valve has the functions of automatic pressure compensation, pressure maintaining and oil pump delayed shutdown. Dual speed working mode, which uses high approach speed for low pressure and low approach speed for high pressure. Multiple exhaust times can be set to ensure that the template pressure reaches saturation.
 20. Oil pressure media: Mobil 32# anti-freezing hydraulic oil (provided by the customer)
 21. Cylinder speed: 11 \sim 50mm/s with two-speed working mode: fast rise, slow lock, fast fall function
 22. Dimension: About 2000*980*1650(W*D*H)mm
 23. Weight: About 2T
 24. Power supply: 3 ϕ , AC380V, 60A, three-phase and five-line (The connection port is provided by the customer.)
- Accessories: Stainless steel mirror retainer plate *2 pieces
Manual and Product quality assurance card

■ PLC programmable controller function introduction:

This machine has two modes: manual and automatic.

1) Standard automatically mode:

Set the required parameters for the molding action:

→ Heating temperature and cooling temperature;

→ The first stage pressure (pre-pressure) and the second stage pressure (pressurization);

→ The time of the first pressure operation and the time of the second pressure operation;

→ Exhaust number N and exhaust time S.

2) Standard operating procedure:

Start the program (only when the temperature rises to the requirement) → the mold plate is automatically clamped → the first stage of pressure (pre-pressure) starts → this period of time is reached → automatic exhaust (the number and time of exhaust can be arbitrarily set) → the second section pressure (supercharging) starts → this period of time is reached → water cooling → cooling time is reached → the molding plate is automatically opened, and the operation is over.

3) Time setting: vulcanization time is in minutes, exhaust time is in seconds, both have optional functions

Feature

1. Fast rising, slow locking, fast falling function of the moving template, fast turning slow of the mold closing and fast turning slow of the exhaust can be adjusted respectively.
2. The oil circuit configuration is more reasonable and reliable. When the product is vulcanized and formed, the oil pump motor stops working and has automatic pressure replenishment function and oil pump shutdown delay.
3. The deflation time, deflation frequency, heating temperature, and vulcanization time can all be set, making operation convenient. It has two working modes: manual and semi-automatic.
4. To meet the process requirements of special rubber materials, there are two programming modes: Program I, the working mode of the conventional plate vulcanization machine; Program II, the working mode of transferring mold.
5. The seal ring of original imported hydraulic cylinder, reliable sealing, long service life.
6. The electrical system adopts full computer control, which is more convenient, accurate and reliable. Users can choose PLC control imported from Siemens in Germany or Japanese PLC control touch screen.
7. Adopting original imported high-pressure oil pump and proportional pressure flow compound valve control, with low noise and low energy consumption.
8. The fuel tank adopts an open fuel tank with a flap plate structure, which saves time and effort in maintenance and is more user-friendly.

