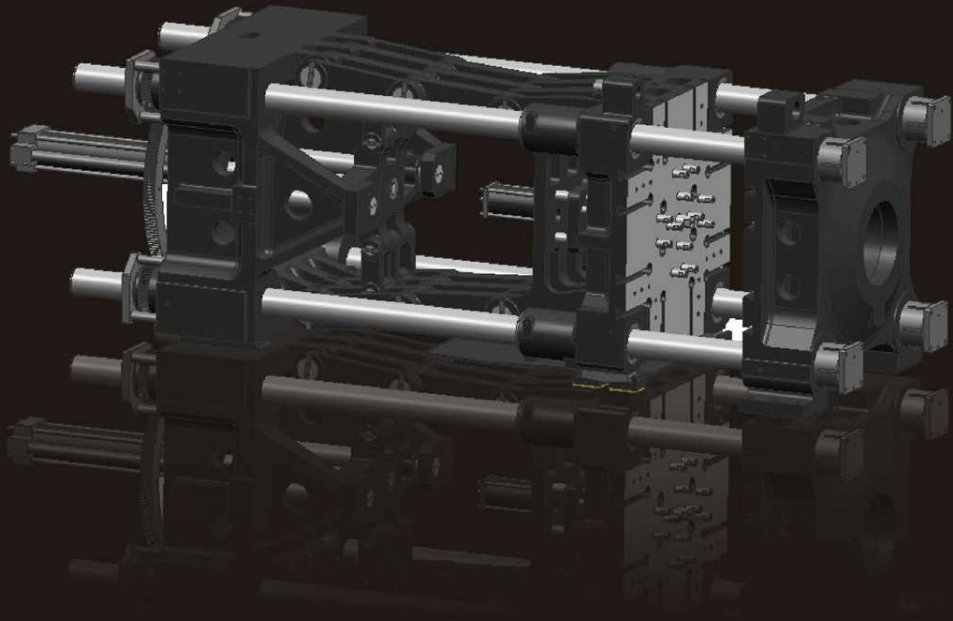


全球24小时服务热线  
Global 24-hour service hotline  
**86-576-84086666**



# DAKUMAR™

## DAKUMAR INJECTION MOULDING MACHINE

German quality made in Huangyan China



**浙江德库玛机械有限公司**  
ZHEJIANG DAKUMAR MACHINERY CO.,LTD.

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**浙江德库玛机械有限公司**  
ZHEJIANG DAKUMAR MACHINERY CO.,LTD.



# Company Profile

Zhejiang Dakumar Machinery Co., Ltd.

Is an injection machinery manufacture base, devoted to injection machine manufacture, research and marketing, located in Huangyan city, China mould town. By bringing in German high-tech injection solution, Dakumar ranks on the top of the international injection machine market, holding its advantage of best elements setting, high technology, superior precision controlling and thorough energy conserve mentality.

浙江德库玛机械有限公司是一家集生产、研发和销售于一体的注塑机生产企业，坐落于中国模具城-黄岩。德库玛通过引进国际注塑机的先进技术，以顶级的配置，高端的技术含量，超强的控制精度，周密的节能理念，跻身于国际注塑机市场顶峰。

追求卓越品质，创造世界品牌。

## German quality made in Huangyan, China

德库玛以先进的注塑机技术，配合高端的模具设计制造理念，成熟高效的注塑工艺，为客户提供全方位的解决方案。DKM provides customers with comprehensive solutions relying on its advanced injection molding machine technology, high-end mold design and manufacturing concepts and mature and efficient injection molding process.







# INDEX

ZHEJIANG DAKUMAR MACHINERY CO.,LTD.

## Striving for excellence

providing complete injection molding strategy  
to meet customers' requirements

追求卓越的注塑机制造，为您提供全方位的注塑方案

一个完善的特殊要求配置体系，用户  
可根据需求选择适合的特殊机型：

*Offering a complete configurations system, users can choose  
a suitable machine in terms of different requirements*

01/

定量泵注塑机  
**Standard Injection  
Moulding Machine**



02/

变量泵注塑机  
**Variable Injection  
Moulding Machine**



03/

伺服节能注塑机  
**Servo Power-save  
injection Moulding Machine**



04/

高速注塑机  
**High Speed Injection  
Moulding Machine**



05/

混双色注塑机  
**Mixed Dual-color Injection  
Moulding Machine**



06/

多组份注塑机  
**Multi-Material Injection  
Moulding Machine**



07/

PVC注塑机  
**PVC Injection  
Moulding Machine**

08/

PET注塑机  
**PET Injection  
Moulding Machine**

德库玛坚信，一流的设备和  
一流的管理是制造一流产品的保证。

**Dakumar firmly believes that first-class  
production facilities and managements  
play an important role in its manufacturing.**

## Advanced Equipments

*Dakumar is carrying out a modern  
production management system.*

We always keep the principle of high starting point, high input, high output and high quality. Dakumar absorbs Flexible Manufacturing System(FMS) from Japan, CNC Milling Machine, Numerical control machine and Double Column CNC Processing Center, they're applied for machine core parts to make sure the high quality and high efficiency of products.

In order to conform to the world markets, recent years, Dakumar keeps on increasing its investment and spends more than 1 million dollars on high precision equipments from Germany, Japan, South Korea and Taiwan. We have more than 70 sets production equipments so far, including FMS, Double Column Machining Center, Vertical and Horizontal machining center and laser automatic cutting machine, etc.

德库玛公司积极推行现代化的生产管理。建厂伊始，本着注塑机企业高起点、高投入、高产出、高品质的宗旨，德库玛从日本引进了FMS柔性制造系统，CNC加工中心群，数控车加工群，龙门CNC加工中心群，用于加工德库玛注塑机的核心零部件，以保证塑机零件的高效产出、优良品质。为了更多、更快、更好地满足市场需求。近年来，德库玛公司加大投入，不惜重金从德国、日本、韩国、台湾购入高精度的更先进的加工中心群。现公司共拥有70多台生产设备，包括FMS柔性加工中心、超大高精度龙门加工中心、立/卧式加工中心、数控车床和程控激光自动切割机。





稳固精密，追求高端

# Stable, precise, excellent and economical.

## 调模系统 Adjustment Unit

Automatic mold height adjustment saves the time and cost during the mold changing.

自动调模，更换不同模具时，可节约换模时间和成本。

## 液压系统 Hydraulic Unit

The hydraulic system using the world famous pump and control valve can control the machine running precisely, ensuring the precision, reliability and durability of whole machine.

液压系统采用世界著名品牌的油泵和控制阀组合，可精确控制机器的运作功能，保证了整机的准确性，可靠性和耐用性。

## 锁模系统 Clamping Unit

The plates were designed using FEM software, ensuring a stable and rigid clamping system. Five-point inward moving double toggle system ensures high rigidity and precision for mould clamping and also reducing stress and strain effects.

内卷式五支点双曲轴锁模机构经有限元分析强化的箱体式模板，有效降低应力和变形量，提高锁模部分结构刚性和精度。

## 注射部分 Injection Unit

Dual-pillar supporting and dual-cylinder injection balance devices ensure the stress on screw balanced during injection.

注射部件采用双导柱支承，双缸平衡注射装置，使螺杆在注射前进过程中受力平衡均匀。

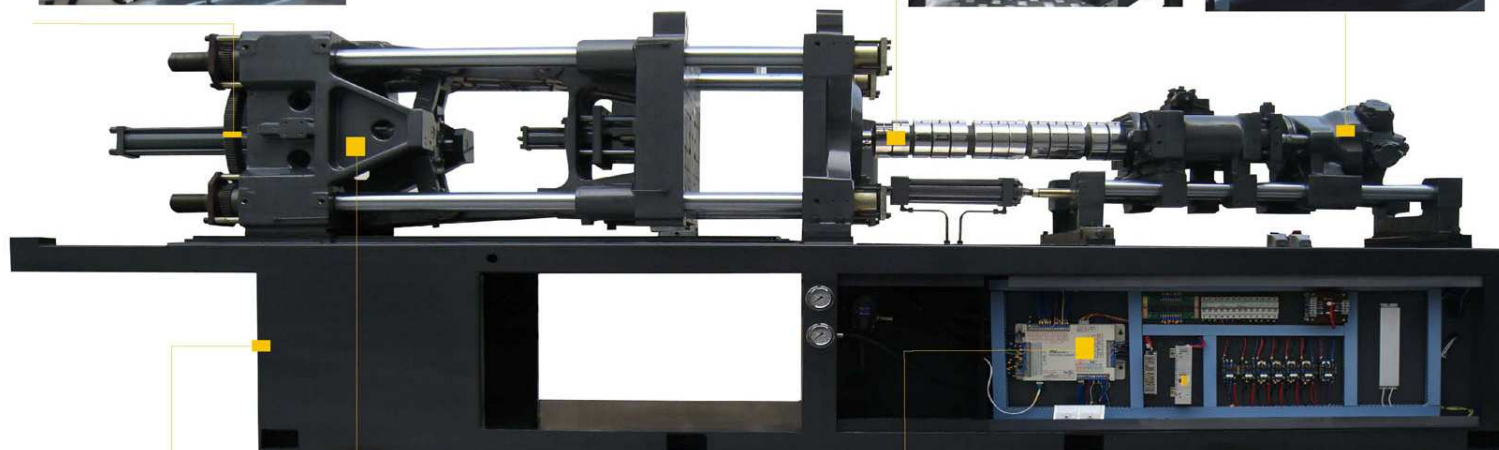
Specific screw and barrel designs are available for processing different material requirements.

针对不同特性原料，可配备专用的螺杆和料筒，确保制品品质。

## 调模系统 Adjustment Unit



## 注射部分 Injection Unit



## 液压系统 Hydraulic Unit



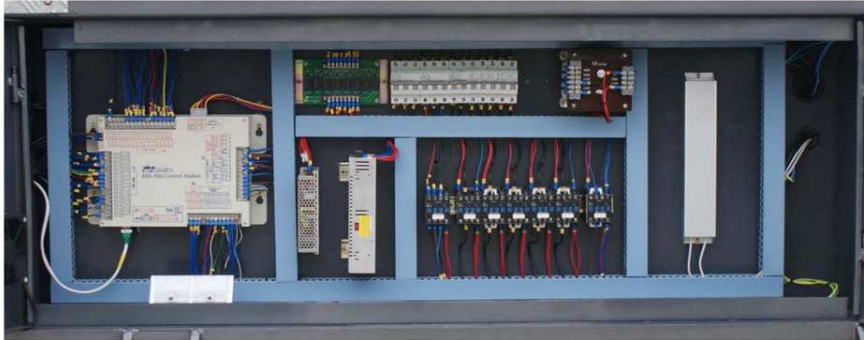
## 锁模系统 Clamping Unit



## 电控部分 Electronically controlled Unit



## 电控部分 Electronically controlled Unit



- > MH9118 computer control system, the clock frequency of 32MHZ, run fast;
- > 8FT color LCD display, showing some independent CPU control;
- > Master control frequency of 140MHZ, scan time 1ms, the progress of fast response, high control accuracy;
- > 120 group mold parameter storage space;
- > Quality control management, the main process parameters and the curve shows a list of statistics;
- > PID barrel temperature control function automatically adjusts the parameters
- > MH9118电脑控制系统, 时钟频率32MHZ, 运行速度快;
- > 8FT彩色LCD显示, 显示部分独立CPU控制;
- > 主机控制频率为140MHZ, 扫描时间1ms, 响应速度快, 控制精度高;
- > 120组工模参数存储空间;
- > 品质监控管理, 主要工艺参数曲线显示和列表统计;
- > 料筒温度控制PID参数自动调整功能



CPU controller and display are independent and reliable. A larger Color LCD screen enhances clear display and supports multi-language compatibility. The control system also supports remote monitor. In the event of a control problem, the machine can be connected to internet through a special interface. Dakumar service can realize remote fault diagnosis and maintenance.

A screen saver function extends the LCD life. Ultra bright LED is provided for Input and Output point inspection. Providing convenient indication of the machine's operation and machine service. A data hardware lock is provided to prevent unauthorized people from modifying the molding parameter and affecting the machine's performance. Closed Loop PID Barrel temperature control. Dust and waterproof control cabinets provide a neat and tidy enclosure all electrical control components.

控制和显示相对独立, 可靠性好。  
彩色大屏幕LCD显示屏, 支持多国语言。  
具备注塑机Internet联网接口, 提高生产效率, 实现远程监控及维修诊断。

屏幕保护功能, 延长显示屏使用寿命。  
超强发光二级管为输入/输出点显示状态, 使操作和维修人员更容易掌握系统的动作状态。  
设置键盘锁功能, 防止操作人员修改成型资料。  
通过电脑设定和PID闭环方式精确控制料筒温度。  
全封闭电气控制箱, 电气元件非布整齐, 互不干扰, 并具有防尘防水功能。

## 螺杆的选择 Screw selection

Apart from the general screw, special design of special screws is provided to satisfy different requirements of plastic resins, such as UPVC, PC, PA, CP, CA, PPS, PET, etc.

### Remarks:

- # Theoretical shot volume = (screw cylinder cross section) × (screw stroke)
- # The injection shot weight should be 91% of the theoretical shot volume for polystyrene (PS)
- # The plasticizing capacity and injection rate are the values for polystyrene (PS)

### Note:

- # When PC (polycarbonate), PVC and other plastic material used engineering are planned for molding, it is necessary to inform us for special designation.
- # There is more detailed documentation for your availability in addition to above specification.
- # The machine pictures are for your reference.

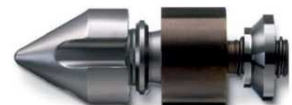
德库玛除了提供通用性螺杆, 满足客户多样化的注塑要求外, 更可针对各种树脂和产品, 设计专用性的螺杆以满足客户高品质注塑的要求, 例如 UPVC, PC, PA, CP, CA, PPS, PET等用性螺杆

### 说明:

- # 理论注射容量 = (注塑机) 料筒截面积 × 螺杆行程
- # 注射重量为PS理论容量的91%
- # 塑化能力、注塑速率为PS值

### 注意:

- # 当你有成型PC、PVC等工程塑料制品的计划, 请让我们知道
- # 除了上述表格中技术规格参数以外, 尚需要详细的资料请垂询
- # 产品照片仅供参考, 与出售实物略有不同





## 标准配件

# Standard fittings auxiliary machine selection

### Famous hydraulic components

1. Hydraulic pump from YUKEN, Japan and VILKERS, America
2. PQ valve from YUKEN, Japan
3. Directional control valve from YUKEN, Japan
4. High pressure rubber pipe from MANULI, Italy
5. Hydraulic motor from INTERMOT, Italy
6. Hydraulic cylinder from HYTARKIWAR, Japan
7. Back pressure valve from YUKEN, Japan

### 名厂液压元件

1. 日本YUKEN、美国VICKERS油泵
2. 日本YUKENPQ阀
3. 日本YUKEN方向阀
4. 意大利MANULI高压管
5. 意大利INTERMOT液压马达
6. 日本HYTARKIWAR液压油缸
7. 日本YUKEN背压阀

### Famous electronic components

1. Breaker, AC contractor, single-phase breaker, three-phase breaker from SCHNEIDER, France
2. Air switch from LG, Korea
3. Stroke switch, photoelectric switch and relay from OMRON, Japan

### 名厂电控元件

1. 法国SCHNEIDER断路器, 交流接触器, 单级、三级自动开关
2. 韩国LG空气开关
3. 日本OMRON行程开关, 光电开关, 继电器

## 选配件

# Standard fittings auxiliary machine selection

### Option feature

1. Nitrogen injection devices.
2. Technological meter device for plasticizing speed indication
3. Prolonged nozzle
4. Hydraulic safety interlock
5. Core pulling or screw
6. Robot interface
7. Special screw
8. Be clear at one glance

### 选择配备

1. 氮气射胶装置
2. 螺杆转速检测
3. 加长喷嘴
4. 液压安全保护
5. 抽芯或旋转脱模
6. 机械手界面
7. 特性螺杆
8. 玻璃管流量计

### Auxiliary equipments

1. Robot
2. Industrial chillers
3. Cabinet dryer
4. Hopper loader
5. Hopper dryer
6. Mould temperature controller

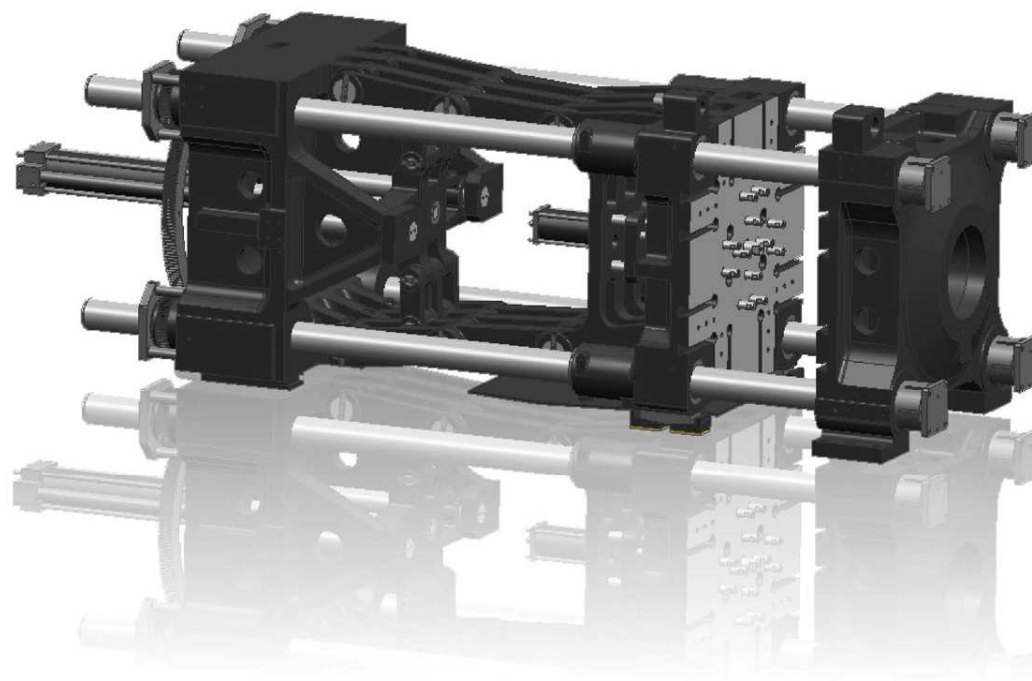
### 选择辅机

1. 机械手
2. 冷水机
3. 塑料除湿机
4. 自动上料机
5. 干燥料斗
6. 模温控制器

## 锁模T型槽 (选配)

# Mold Locking T-Slot (optional)

T-Slot design makes mould installation more convenient and faster.  
T型槽使模具安装更加方便快捷



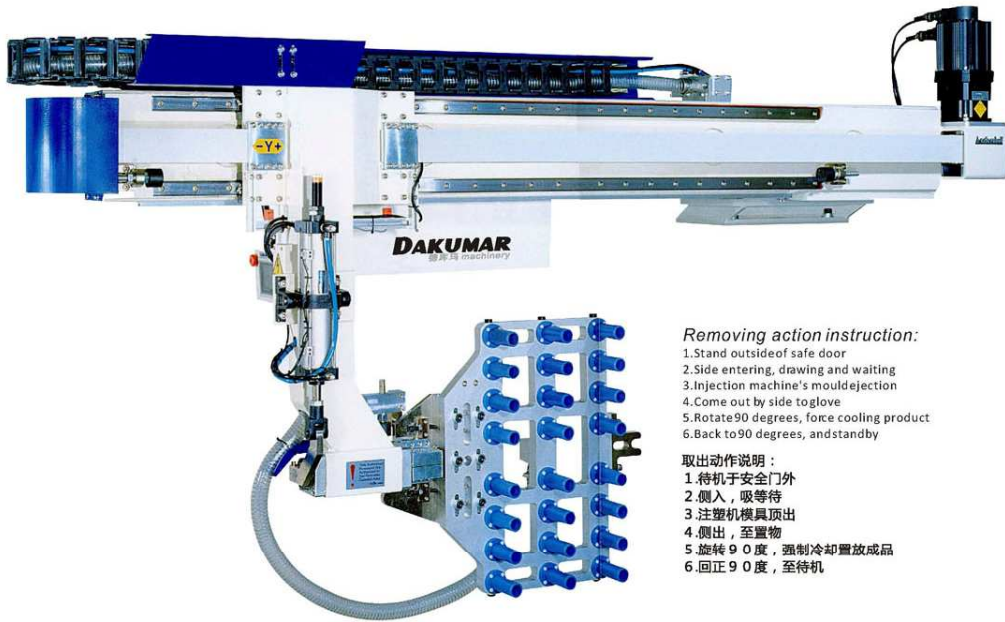
T形槽可以大大方便模具安装, 并且比螺纹安装具有更好的适应性和更高的寿命。

The T-slot makes the adjustment easier, and compare with the screw adjustment, It has better adaptability and longer life-span.

瓶胚专用取出机

# PET Preform Beam Robots

Special fixture take out special preform without any injury, and forced air cooling shorten in-mould cooling time.  
特殊瓶胚专用治具取出时不伤瓶胚，强制风冷，缩短模内冷却时间。



### Removing action instruction:

1. Stand outside of safe door
2. Side entering, drawing and waiting
3. Injection machine's mould ejection
4. Come out by side to glove
5. Rotate 90 degrees, force cooling product
6. Back to 90 degrees, and standby

### 取出动作说明:

1. 待机于安全门外
2. 侧入，吸等待
3. 注塑机模具顶出
4. 侧出，至置物
5. 旋转90度，强制冷却置放成品
6. 回正90度，至待机



PET Preform Beam Robots is dedicated to 350-1500CC PET Preform, applicable to PET Preform machine among 200-600 tons to get preform out, and also suitable for 1.16 cav. 1.48 cav. preform production. Being installed on a fixed plate, take preform out and move to the outside of safe door. It is equipped with cooling system, so the forced air cooling after coming out preform can reduce the in-mould cooling time sharply, so as to increase the production cavity.

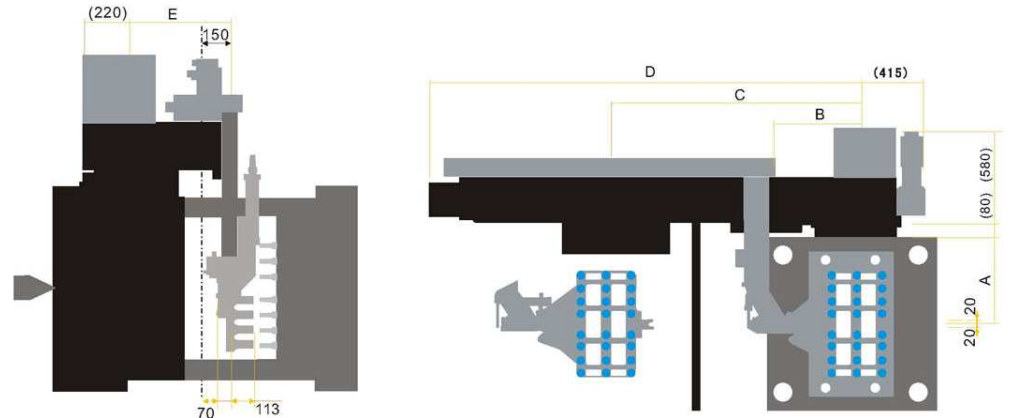
管胚取出机，专用于350-1500CC管胚，可适用于200-600吨各种管胚机器，取出管胚，同时适用于1出16-1出48腔。安装于固定板上，取出管胚至于后安全门外。治具上附冷却系统，管胚取出后强制风冷，大幅缩短在模内的冷却时间，提升产量。

### 一般规格 General Specification

电源 Power supply voltage	电源消耗量 Electric Consumption	电容量(KVA) Power capacity	工作气压 Working Pressure	控制系统 Control system
AC220±10V 3phase,50/60HZ	5.3Kw/hr	6.6	5Kgf/cm <sup>2</sup>	PLC+Touch LCD

### 主要规格 Main Specification

机型 Model	EA-200S1	EA-300S1	EA-500S1
使用成型机(ton) Recommended I.M.M	160~200	250~350 tons	400-600
横行侧入行程(mm) Traverse Stoke (side entry)	1200mm	1500mm	1800mm
最大负荷(含治具) Max.Load(include fixture)	25kg	40Kg	60Kg
真空度 Vacuum mmAq	2000mmAq	2500mmAq	3500mmAq
最大真空吸成品重量 Max. Vacuum Load	2.5KG	4Kg	6Kg
取出时间(SEC) Dry take outtime	1.1	1.5	2
适用瓶胚数 Suitable PET cavity	8~16	16~32	16~48
空气消耗量(liter/cycle) Air Consumption	9	10	11
净重 Net Weight	490	520	520
尺寸 Dimension(L*W*H)	2700*1000*1400	3000*1100*1500	3300*1300*1700



Model	A	B	C	D	E
EA-200S1	430	455	1200	2300	450
EA-300S1	530	530	1500	2600	550
EA-500S1	725	755	1800	2900	750

因机型不断的改良，外观及规格资料变更时，不另行通知。 All state, emts here subject to change without advance notice.

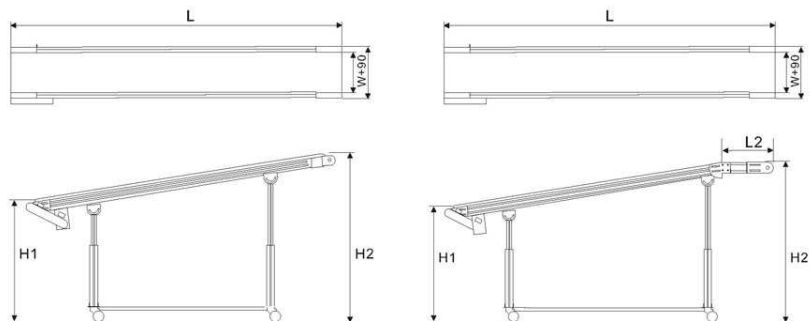


皮带输送带  
**Belt-Conveyor**  
 Maximizes benefits of robots  
 让机械手发挥最大的效益



主要规格 Main Specification

机型 Model	CNA/CNB 200W	CNA/CNB 300W	CNA/CNB 400W	CNA/CNB 500W	CNA/CNB600W
皮带宽度W (mm) Width of belt	200	300	400	500	600
输送带长度L (mm) Length of Conveyor	1500/2000/2500/3000/3500/4000/4500/5000/5500/6000				
低端高度H1 (mm) Height of lower end	700-1000				
高端高度H2 (mm) Height of higher end	1200-1600				
平面长度L2 (mm) Plane	300(only for CNB-)		500(only for CNB-)		700(only for CNB-)
最大荷重 (Kg) Max. Loading	20(平均分散)				
最快速度m/min Max. Speed	12				
皮带 Belt Description	PVC材质 / 2mm厚 / 颜色: 绿色 / 耐温: -10°C ~ +80°C / 防静电, 耐磨, 耐油				
电源 Power Source	Single Phase AC 220V±10V 50/60HZ				
电源容量 (KVA) Power Capacity	0.2KVA				



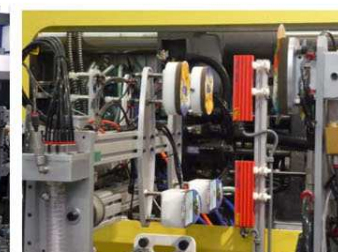
模内贴标机器人  
**IML Robot**  
 IML ROBOT SYSTEM

TOP ENTRY ROBOT SYSTEM

Feature: robot enters into injection machine from top side, to put label and take off product. Net cycle time: from 12second to 20second.

Advantage:

1. Cost save
2. Suitable for middle and big size item, such as chair, table, 10L bucket, 20L bucket...
3. Suitable for slow cycle time, low production volume item
4. Easier handling for the customer, more flexible for different shaped item



# Sales network & Service

## CUSTOMER SERVICE

In order to conform to internet development, we have advanced internet platform, so the customers can communicate with our engineers on line and solve the problem in time.

## BEFORE-SALES SERVICE

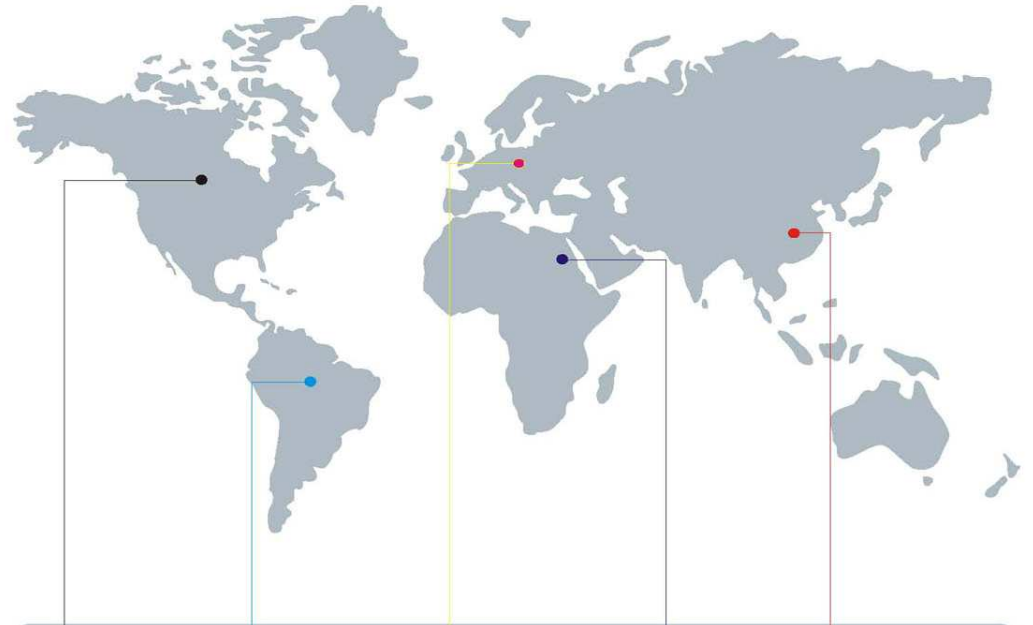
Offer hotline consultation for products and techniques. We can design machines in according to your special requirements.

## MID-SALES SERVICE

Offer installation, adjustment service, and practical training.

## AFTER-SALES SERVICE

24 hours repairing service. Offer one year's guarantee for whole machine, and also offer machine upgrading service.



<b>North America</b> Canada USA Mexico	<b>South America</b> Colombia Brazil Chile Argentina Ecuador	<b>Europe</b> England France Germany Spain Portugal Russia Belarus Ukraine Italy	<b>Africa</b> Egypt South Africa Kenya Morocco Ethiopia Tunisia	<b>Asia</b> India Syria Pakistan Israel Azerbaijan Jordan Palestinian Kyrgyzstan Vietnam Indonesia Iran Kuwait United Arab Emirates Saudi Arabia
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