

FE Series



The Passionate Pursuit of Perfection

en.bole-machinery.com

BOLE Customer Service Center

BOLE MACHINERY

ADD: No.99 Weisan Road, Xiaogang, Ningbo, China

P.C: 315821

TEL: +86-574-86188007

FAX: +86-574-86188008

E-mail: bole-sales@bole-machinery.com

THIS CATALOGUE ARE PROTECT BY LAW OF COPY RIGHT.
ANY USE WITHOUT THE EXPRESS PERMISSION OF THE LAW OF COPY RIGHT,
MUST GET APPROVAL OF BOLE IN ADVANCE.

THIS VERSION WAS PRINTED IN MARCH 2022,
ANY DIFFERENCE SPECIFICATION FROM OLD VERSION SHOULD BE SUBLICT TO THIS VERSION.

FE Series

Electrical Injection Moulding Machine



Injection Moulding Machine



Advantage Of Full Electrical Injection Moulding Machine

Compared to the traditional hydraulic injection moulding machine



Energy Saving

Efficient energy conversion,
Reduce power consumption.
No need water for hydraulic
oil cooling.

Efficient

Synchronous machine
movement is possible to
achieve a short cycle time

Precise

Up to 0.01 mm high position
control accuracy, ensure
product quality

Clean

No pressure hydraulic oil, keep
a clean production environment

High Speed

High-speed & smart movement
control for mold and injection,
fulfill different application

Quiet

Low noise level, create
comfortable environment


BOLE Electrical Injection Moulding Machine


Precise


High-speed

Common


Reliable


 Fast & close loop control system excellent repeatability performance

 Patented central clamping toggle system create uniform clamping force. reduces platen deflection

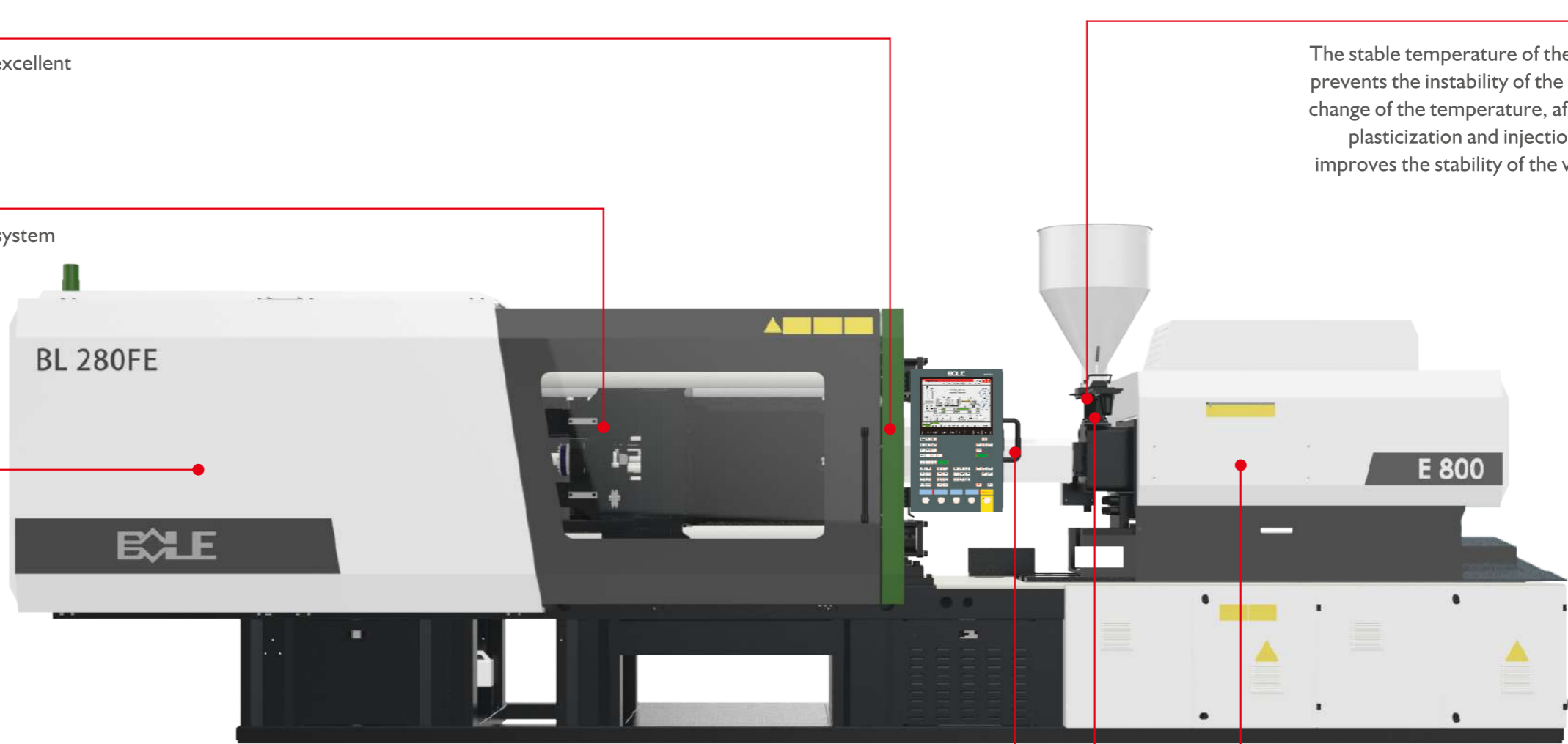
 Platen drive by servo motor and ball screw.

 German design of plasticizing system increase efficiency of plasticizing over 20%

 Nozzle contact force protecting mould avoiding leakage

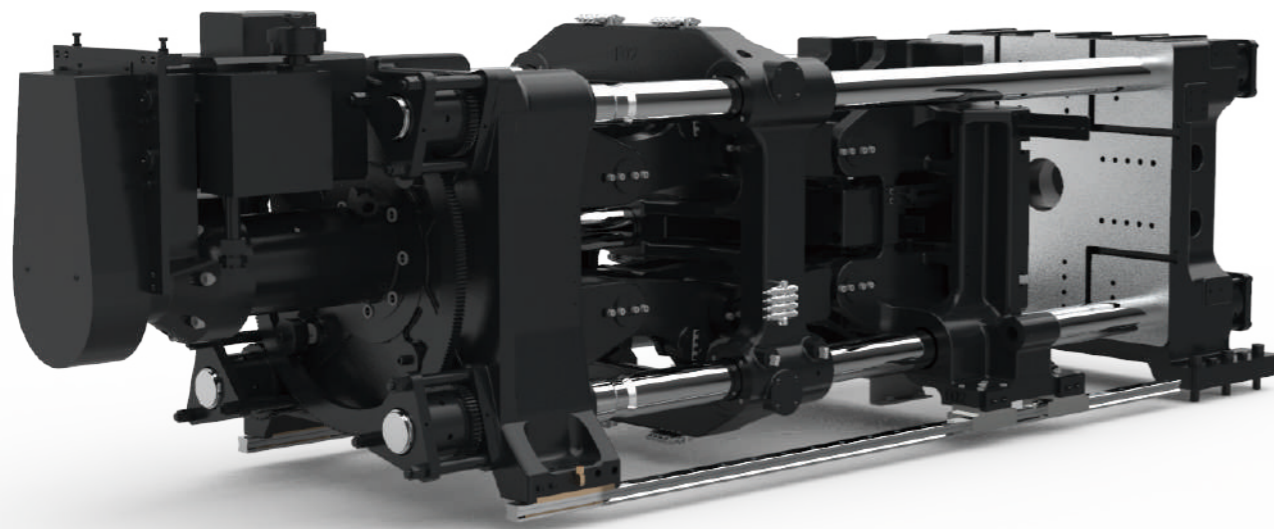
 The stable temperature of the feeding throat prevents the instability of the feed due to the change of the temperature, affects the screw plasticization and injection accuracy, and improves the stability of the whole machine.

 Patented encapsulated ball screw



E-version Of Central Clamping Toggle System

Central locking toggle, inventional patent in China
(Patent No.: ZL2011 10250342.5)



- **Saving**

- Save material
- Save electricity
- Save nr. Of machine
- Save maintenance

- **Precise**

- Precise position
- Precise speed
- Reliable mold protection
- Precise parallelism

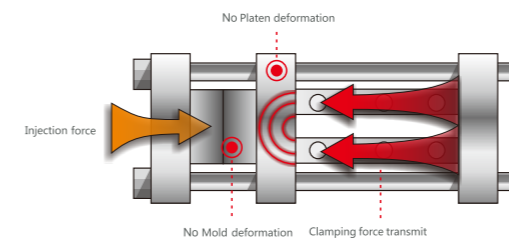
- **Large**

- Large space between tie-bars
- Large open stroke

- **Clean**

- The product area is free of oil

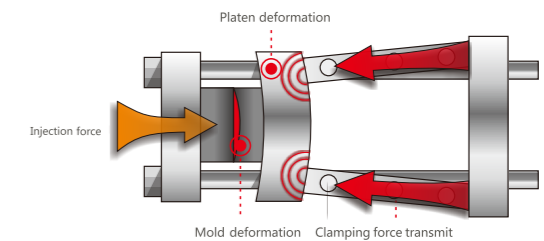
Toggle System Comparison



BOLE

BOLE centre clamping structure

- **100%**
Clamping force efficiency
- **2-5%**
Material saving
- Reduces mold wear, platen deflection
- Less possibility of flash, save flash trim work

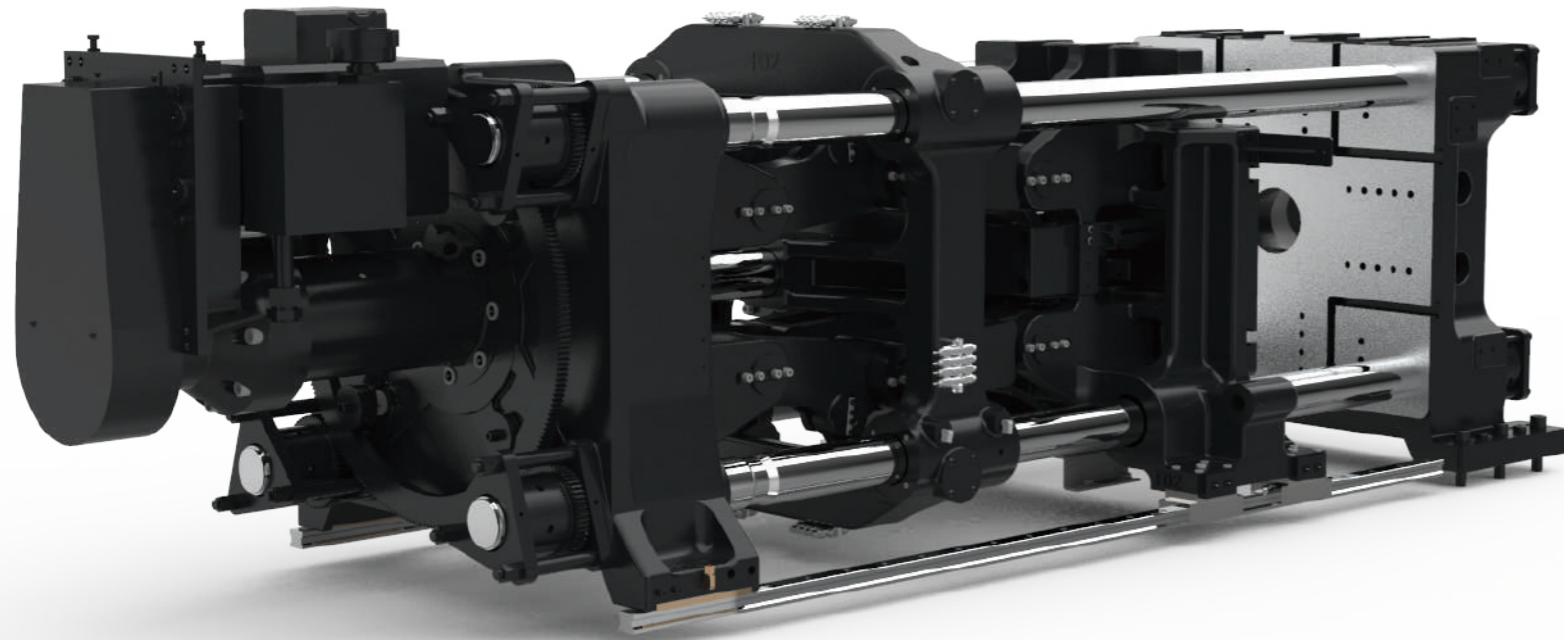


Others

Tradition Toggle system

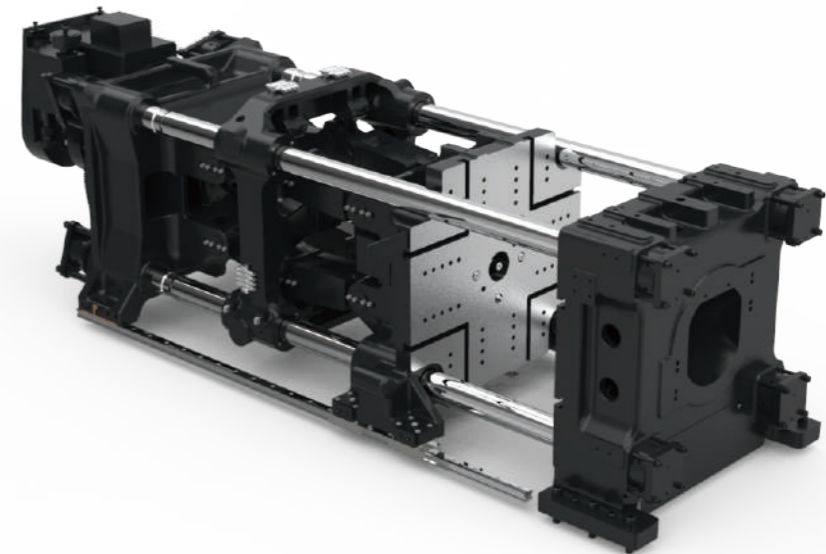
- **80-85%**
Clamping force efficiency
- Moving platen with obvious deformation, cause flashes, waste of material and labor of trim the flashes.

Central Clamping Toggle System Driven By Servo Motor & Ball Screw



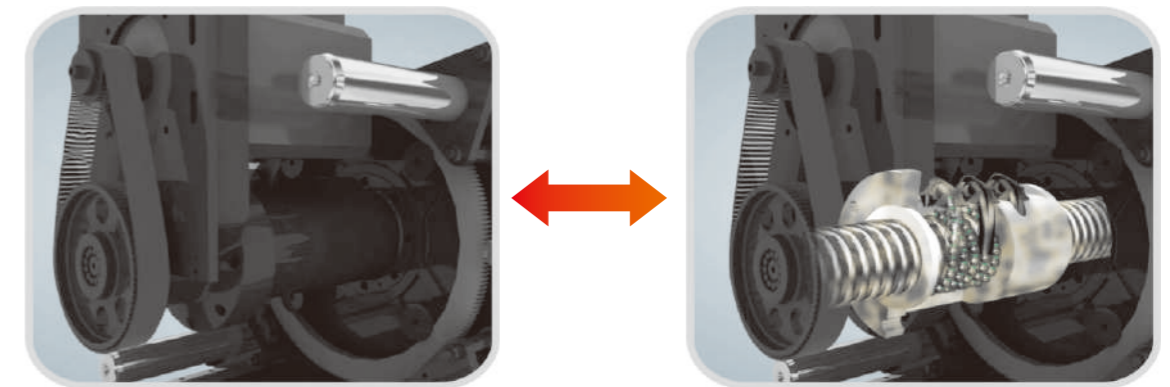
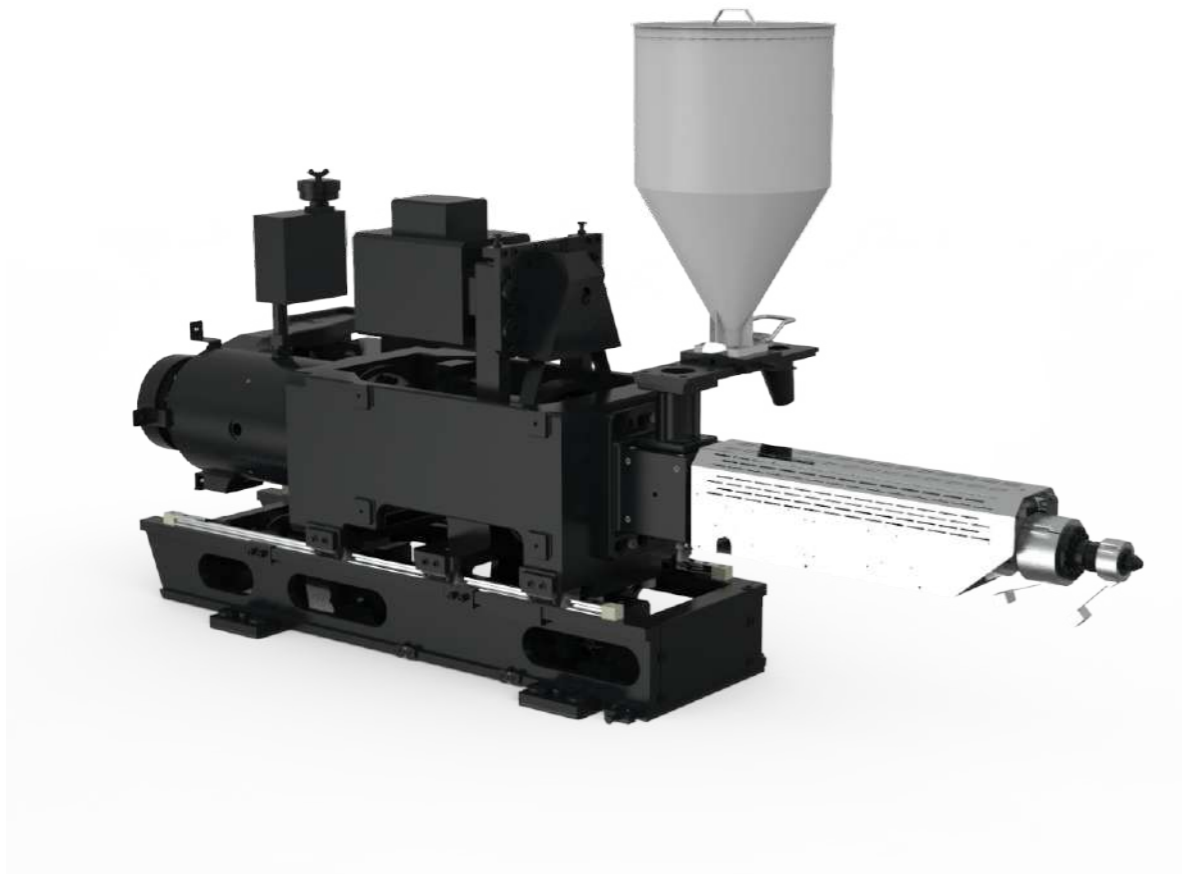
- Precise control for mold movement, repeatability up to 0.01 mm, fit for IML or automation.
- Flexible control curve, fast and smooth mold movement
- Sensitive mold pretention function
- Tie bar no touch with moving platen, no lubrication, ensure the mold area clean.

Platen Supported By Linear Guide

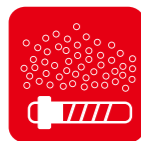


- High platen parallelism
- No lubrication on movable platen
- Keep clean around Part-drop-area

Patented Encapsulated Ball Screw Structure



Tradition



Traditional design of ball screw structure is open to the air; dust will stick on the ball screw surface



Friction will increase ball screw temperature



Lubrication condition become worse

Breakthrough



Encapsulated ballscrew, reduce the requirement of workshop environment



The heat created by friction is taken by oil bath, Ballscrew is well kept cool.



Lubrication is kept on the friction surface by oil bath

- Take away friction heat rapidly, reduce ball screw temperature and abrasion.
- Obstruct dust pollution, request of using environment is low.
- Expensive and imported ball screw lubrication grease is unnecessary.
- More easy for maintenance, no need to clean fatlute.
- Special design of enclosed electric clamping cylinder which is anti-dust immersion type good lubrication. It will improve the ball screw lifetime.

Control System

- 12
Inches
- I/O
Module
- PC
Port
- 4.0
Germany
- XFC
Control
- 0.01
Precision



- KEBA controller as standard with 12 inch touchscreen, user friendly interface

- EtherCAT fieldbus control system, utilize superspeed I/O module with real time function.

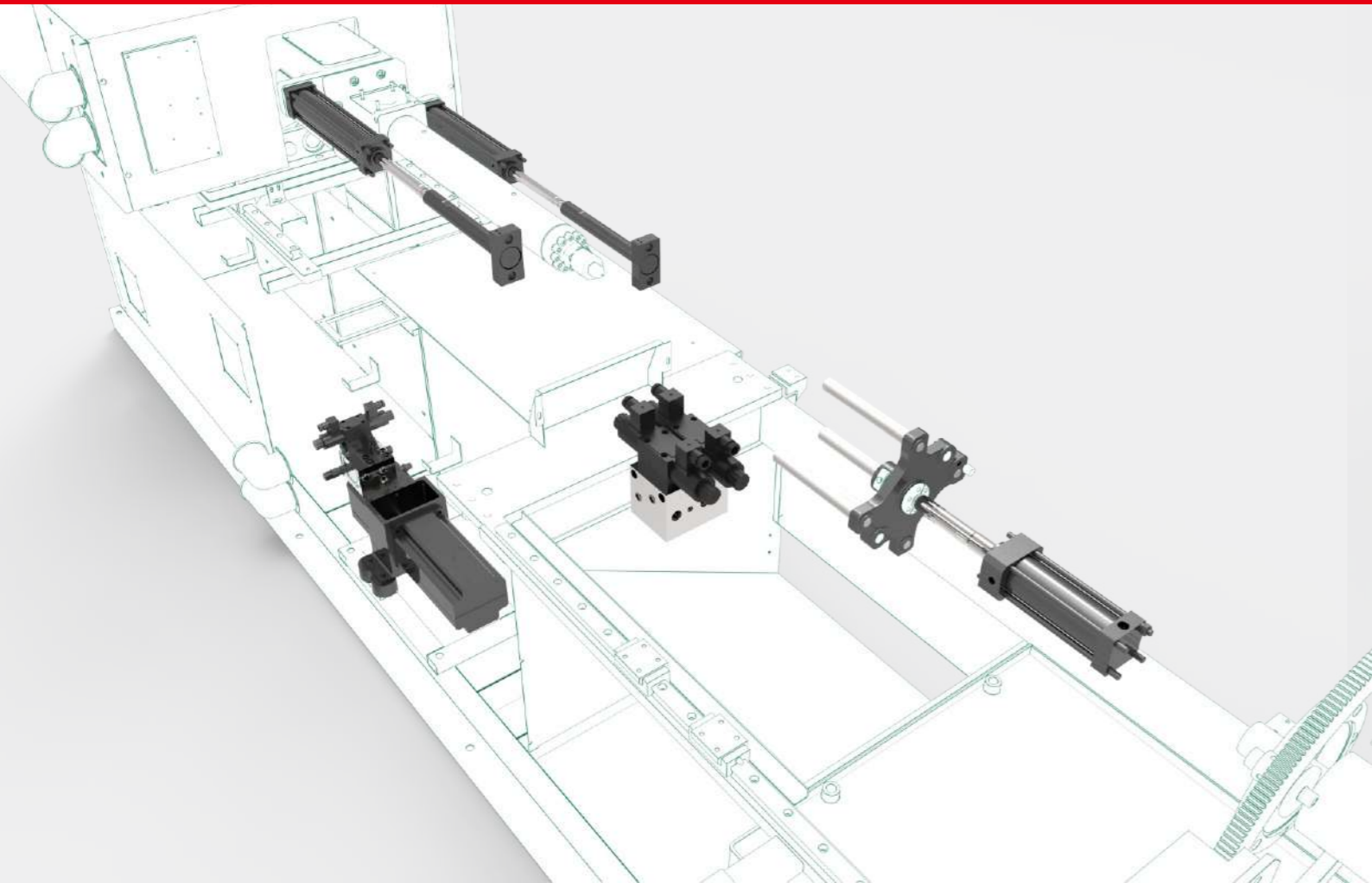
- PC-based control platform, windows system, easy operation, easy to be extended.

- Germany industry 4.0 standard, intelligent manufacturing technology which is easy to implement.

- Unique XFC topspeed control technology, can reduce the materials consumption properly, improve the product quality.

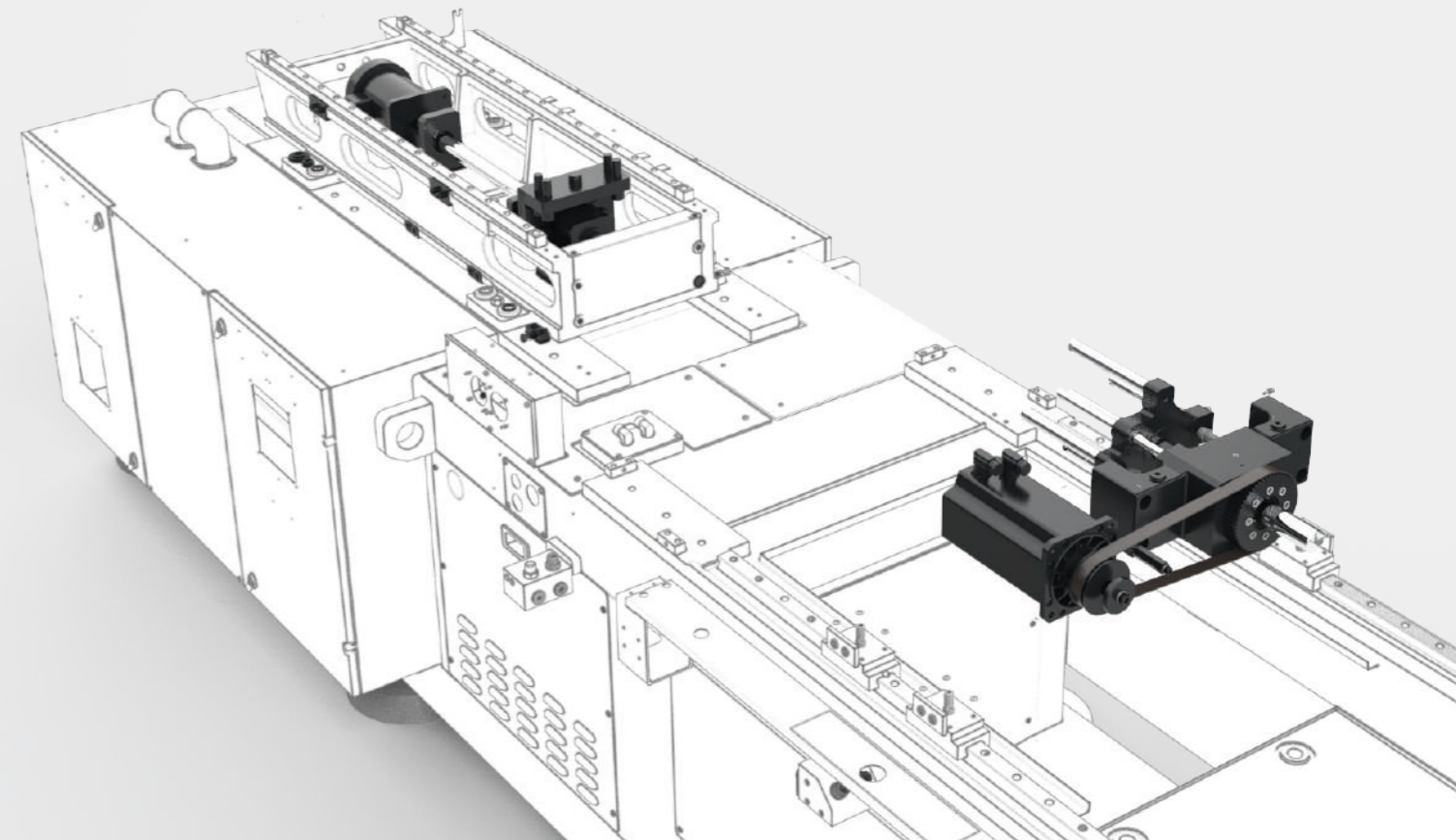


Embedded Servo Hydraulic Pump Station



- Symmetrical cylinder arrangement for injection carrier, offer reliable and balance nozzle contact
- Servo drive hydraulic pump station, power saving and effectively

Embedded Servo Hydraulic Pump Station



- Option for Full-electrical version: without hydraulic pump station and corepull, electrical drive for carrier movement and ejector.



German Designed Plasticizing System

- Excellent plasticizing efficiency
- Options for different application

Various Application

- Adopt low inertia&high response structure for injection, quiet conveyor, meet various condition
- Higher injection precision repeatability, stabilize in product
- Meet various condition, thin wall packing and wall thick lens can be applied
- Injection position repeatability ± 0.01 mm

Technical Data

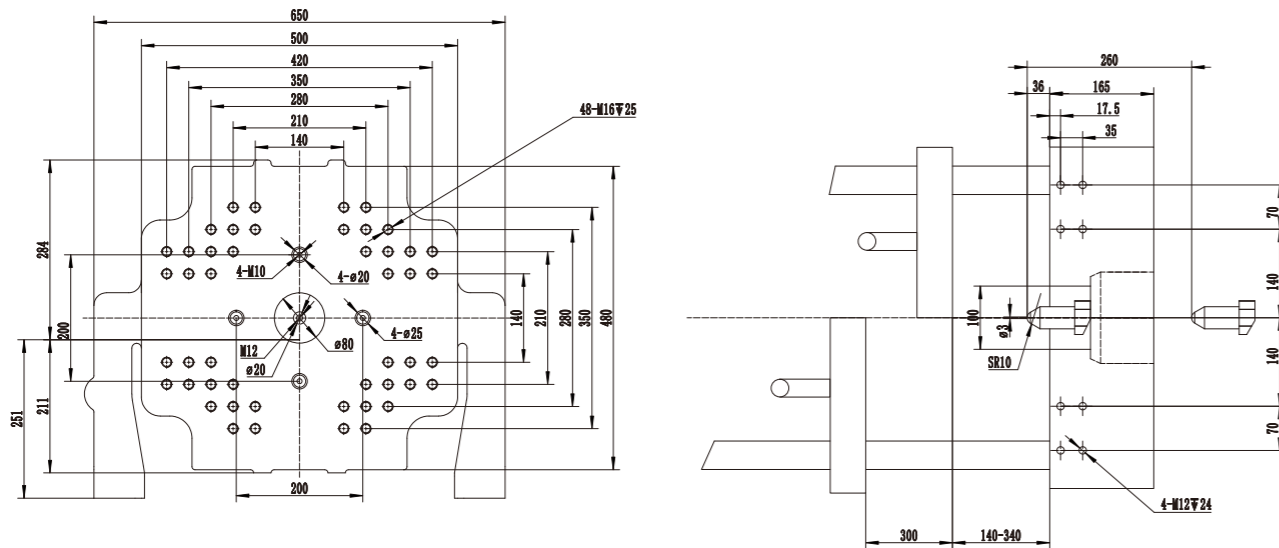
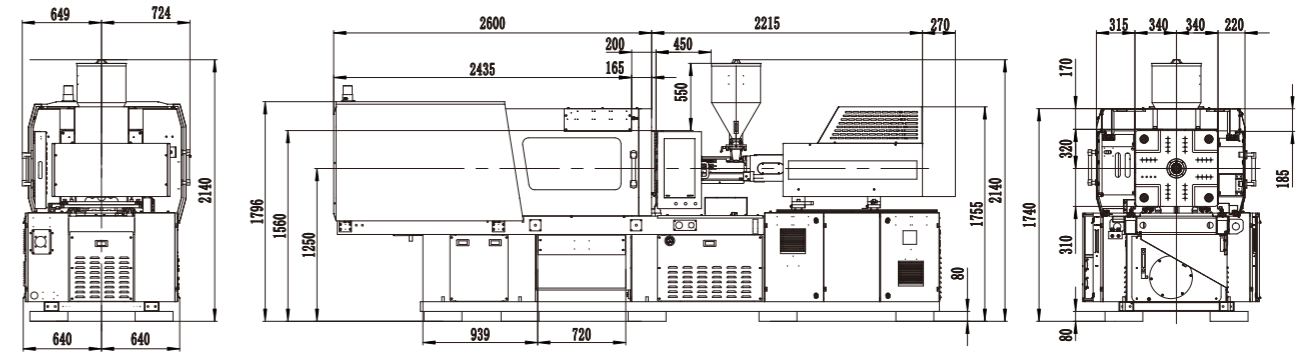
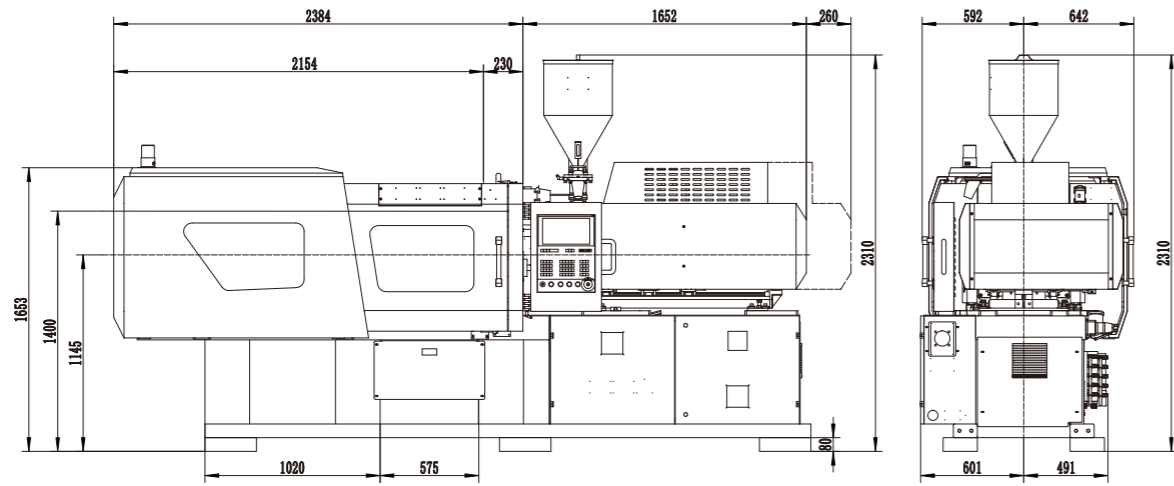
		BL50FE/BL50FE-A			BL110FE/BL110FE-A				BL150FE/BL150FE-A				BL180FE/BL180FE-A				BL230FE/BL230FE-A				BL280FE/BL280FE-A				BL350FE/BL350FE-A				BL450FE/BL450FE-A							
Screw Specification		A	B	C	AA	A	B	C	AA	A	B	C	AA	A	B	C	AA	A	B	C	AA	A	B	C	AA	A	B	C	A	B	C	D	A	B	C	D
Screw Diameter	mm	22	25	28	25	28	32	36	28	32	36	40	32	36	40	45	36	40	45	50	40	45	50	55	45	50	55	60	60	65	70	75	70	75	80	85
Screw L/D Ratio		23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	23	21.3
Plasticizing ability	g/s	9	12	18	9	12	18	24	11	15	21	25	15	21	25	40	18	24	34	45	24	34	45	59	34	45	59	74	49	62	76	91	76	91	110	126
Screw Stroke	mm	100			140				160				180				200				230				260				325				370			
Injection Capacity	cm ³	38	49	62	69	86	113	143	99	129	163	201	145	183	226	286	204	251	318	393	289	366	452	546	414	511	618	735	919	1078	1251	1436	1424	1635	1860	2100
Shot Weight Ps	g	35	45	56	63	78	102	130	90	117	148	183	132	167	206	261	185	229	289	357	263	333	411	497	376	465	562	669	836	981	1138	1307	1296	1487	1692	1911
standard injection unit		E100			E225				E325				E400				E570				E800				E1100				E2150				E3250			
Injection Speed	mm/s	200	200	200	200	200	200	200	200	200	200	200	200	200	200	200	190	190	190	190	190	190	190	190	165	165	165	165	165	165	165	165	165	165	165	165
Injection Pressure	MPa	284	220	175	328	261	200	158	331	253	200	162	313	247	200	158	313	253	200	162	313	247	200	165	269	218	180	151	235	200	172	150	230	200	176	156
Holding Pressure	MPa	232	180	143	262	209	160	126	264	203	160	130	250	198	160	126	250	203	160	130	250	198	160	132	239	194	160	134	188	160	138	120	184	160	141	125
high speed injection unit		E100H			E225H				E325H				E400H				E570H				E800H				E1100H				E2150H				E3250H			
Injection Speed	mm/s	330	330	330	330	330	330	330	330	330	330	330	330	330	330	330	250	250	250	250	250	250	250	250	250	250	250	250	250	250	250	250	250	250	250	250
Injection Pressure	MPa	284	220	175	328	261	200	158	331	253	200	162	313	247	200	158	313	253	200	162	313	247	200	165	269	218	180	151	235	200	172	150	230	200	176	156
Holding Pressure	MPa	232	180	143	262	209	160	126	264	203	160	130	250	198	160	126	250	203	160	130	250	198	160	132	239	194	160	134	188	160	138	120	184	160	141	125
Screw Speed	rpm	400			400				350				350				300				300				300				200				200			
Clamping Force	kN	500			1100				1500				1800				2300				2800				3500				4500							
Tie-bar Distance (h×v)	mm	360×330			460×410				510×460				560×510				660×610				710×660				810×760				910×860							
Opening Stroke Max	mm	300			400				450				500				600				650				750				820							
Mold Height Min	mm	140			150				180				200				200				220				240				350							
Mold Height Max	mm	390			450				500				550				650				700				800				830							
Max Daylight	mm	690			850				950				1050				1250				1350				1550				1650							
Ejector Stroke	mm	70			100				120				130				130				150				150				180							
Ejector Force	kN	20			30				35				45				45				50				60				98							
Number of ejector rods	PCS	5			5				5				5				13				13				13				17							
Dry cycle time	S	1.2			1.3				1.4				1.6				1.8				2.1				2.3				3							
Total electrical capacity(High speed)	KW	25.4(36.8)			52.6 (69.6)				59.6 (71.6)				60.5 (76.5)				70.2 (82.2)				110.3 (132.3)				156 (178)				220.9 (244.9)				233.1 (277.7)			
Heater power	KW	5.4	6.2	7.2	5.6	6.4	7.4	8.4	7	7.9	8.85	9.8	7.8	8.65	9.6	10.7	9.7	11.7	13.6	15.5	13.3	15	16.9	18.8	17.2	19.1	21.9	24.5	21.8	24	26.2	26.2	29	33	37	37
Number of temp. control zones		3+1			3+1				3+1				3+1				3+1				3+1				3+1				4+1				4+1			
Hopper capacity	L	25			25				25				25				25				50				50				50				50			
Min. platen size(L×W)	mm	250×250			320×320				360×360				390×390				460×460				500×500				570×570				640×640							
Platen size(L×W)	mm	530×500			660×610				730×680				820×770				940×890				1020×970				1130×1080				1270×1220							
Stationary platen load	kg	153			323				459				612				935				1173				1700				2170							
Moving platen load	kg	297			627				891				1188				1815				2277				3300				4210							
Machine dimensions(LXWXH)	m	4.26×1.33×1.82			5.085×1.37×2.14				5.809×1.48×2.3				6.064×1.48×2.33				6.829×1.792×2.478				7.376×1.865×2.684				7.922×1.952×2.544				8.4×2.374×2.033				8.84×2.374×2.033			
Net weight(appro.)	ton	3.5			4.2				5.7				6.9				8.5				11.5				15				20				21			

.17. Due to the continuous product improvement, we reserve the right to adjust the individual parameters, without notice.

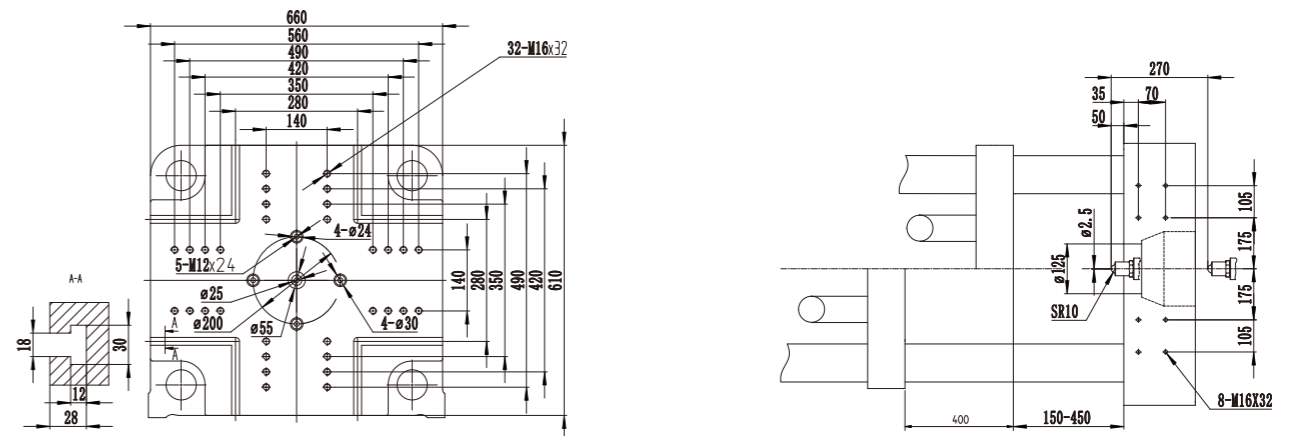
Due to the continuous product improvement, we reserve the right to adjust the individual parameters, without notice.

.18.

Platen Dimensions & Machine Dimensions

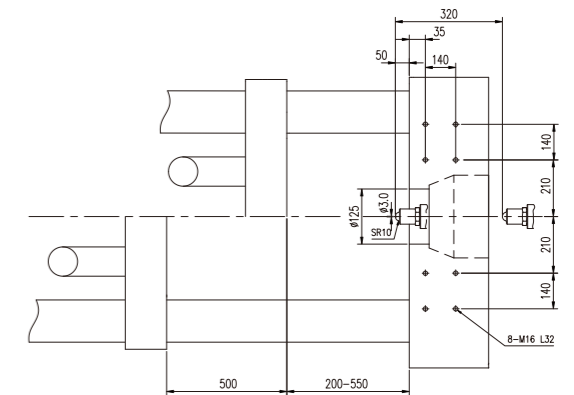
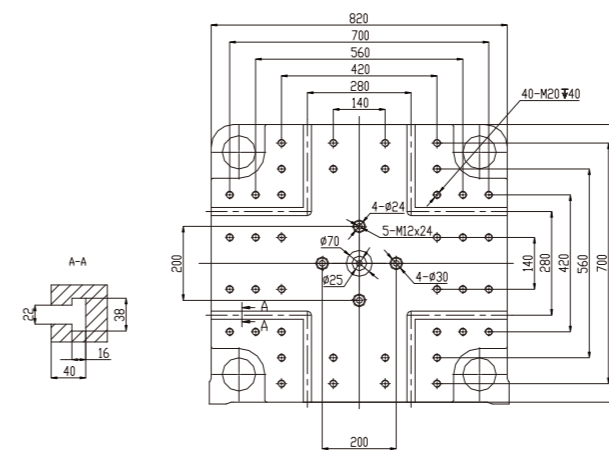
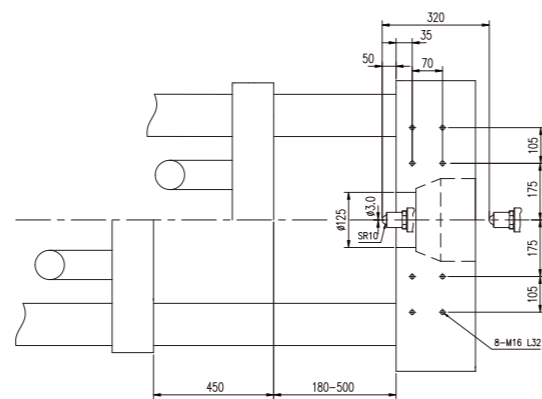
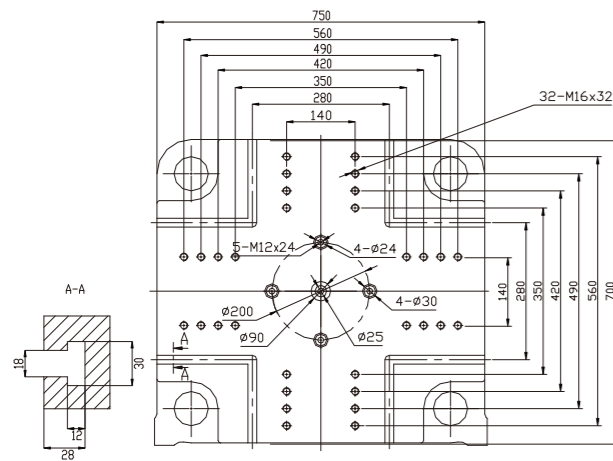
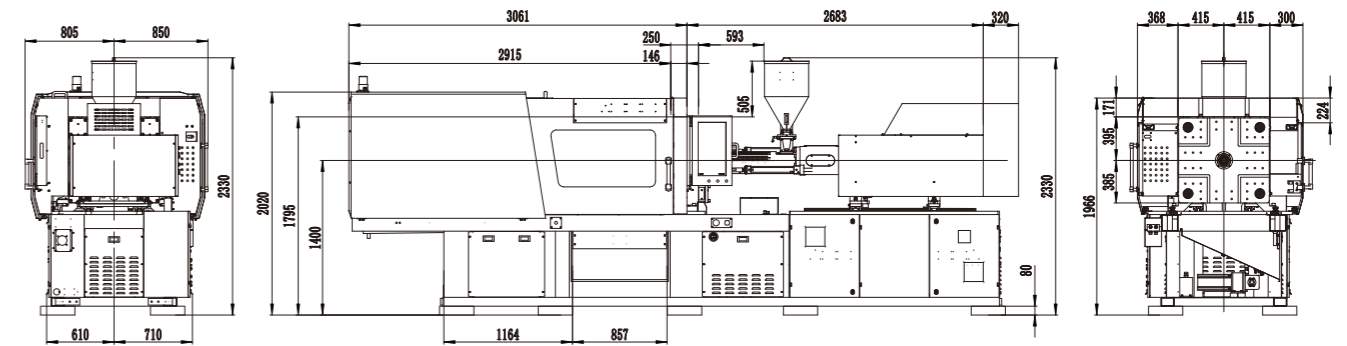
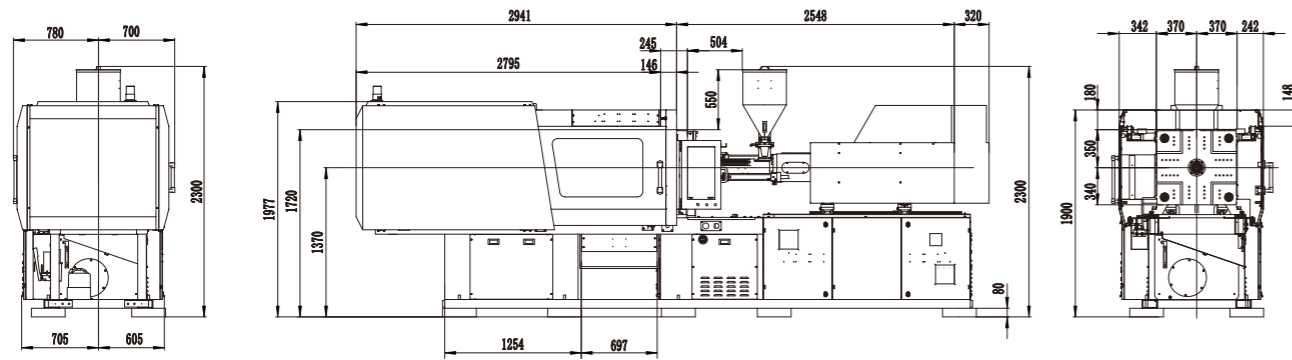


BL50FE



BL110FE

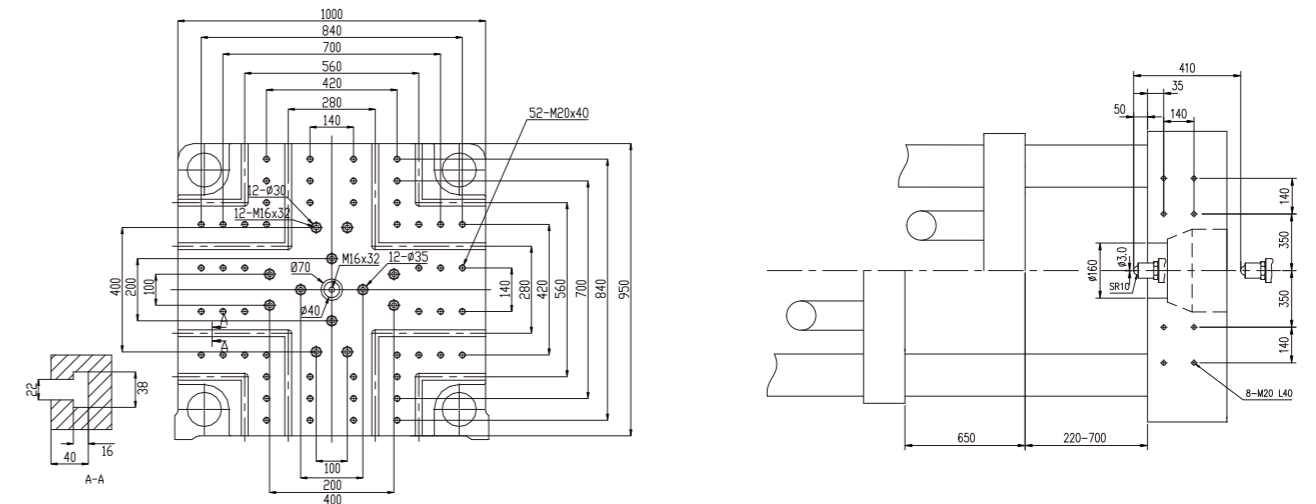
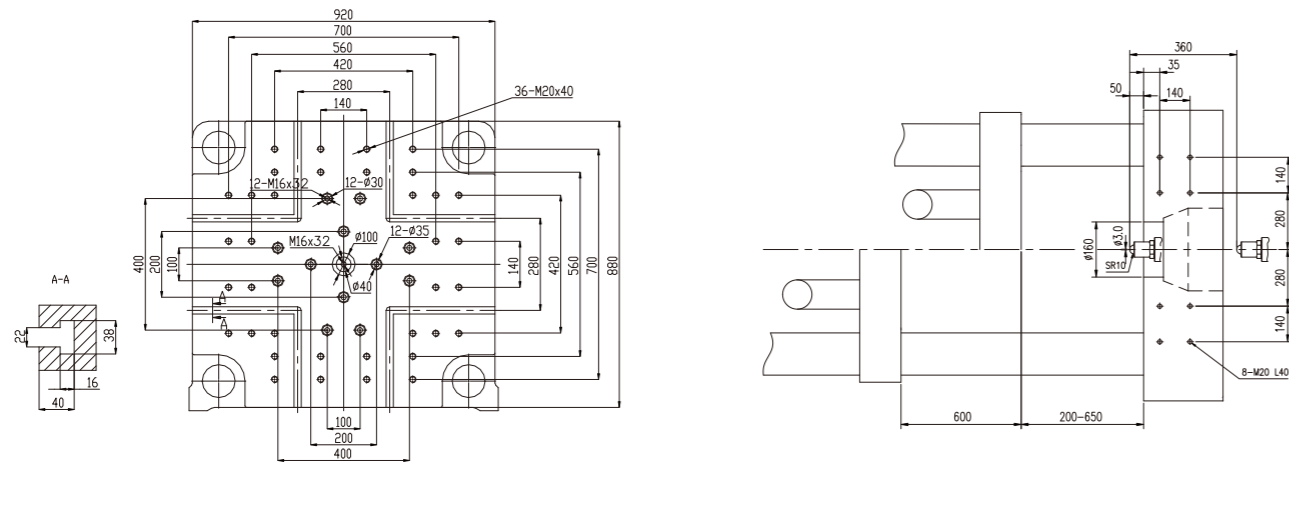
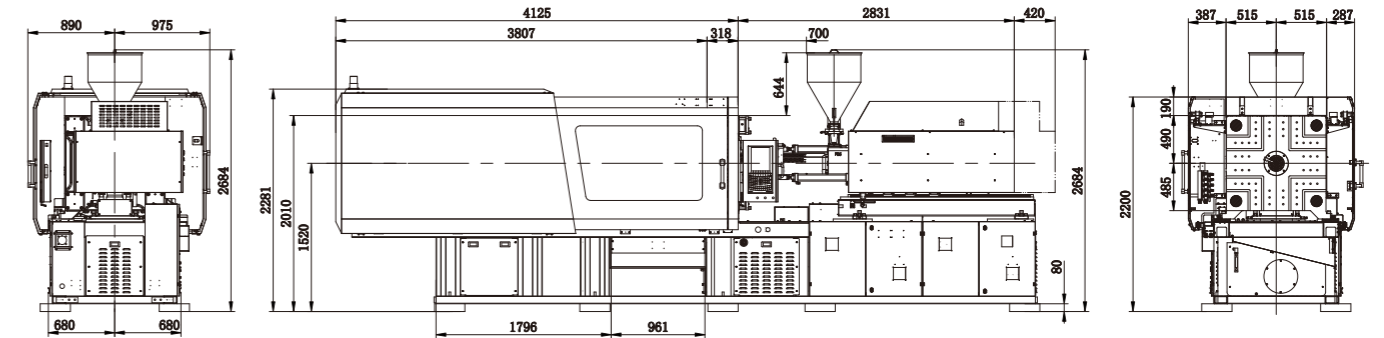
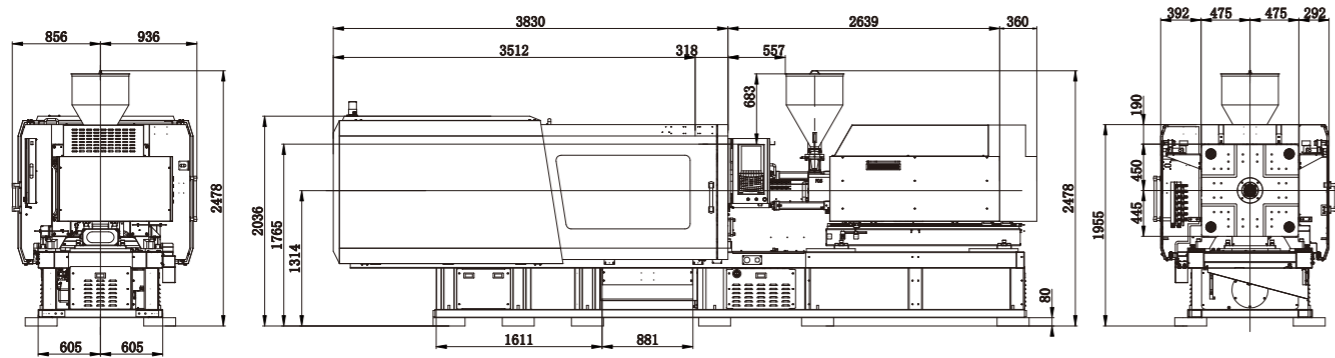
Platen Dimensions & Machine Dimensions



BLI50FE

BLI80FE

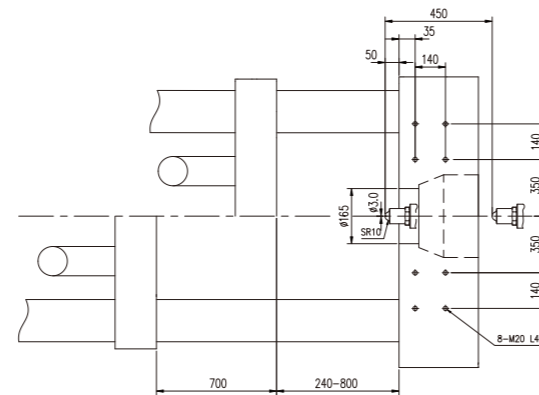
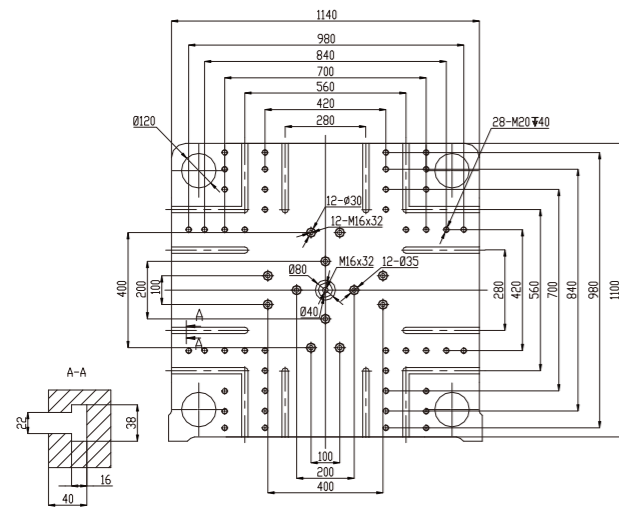
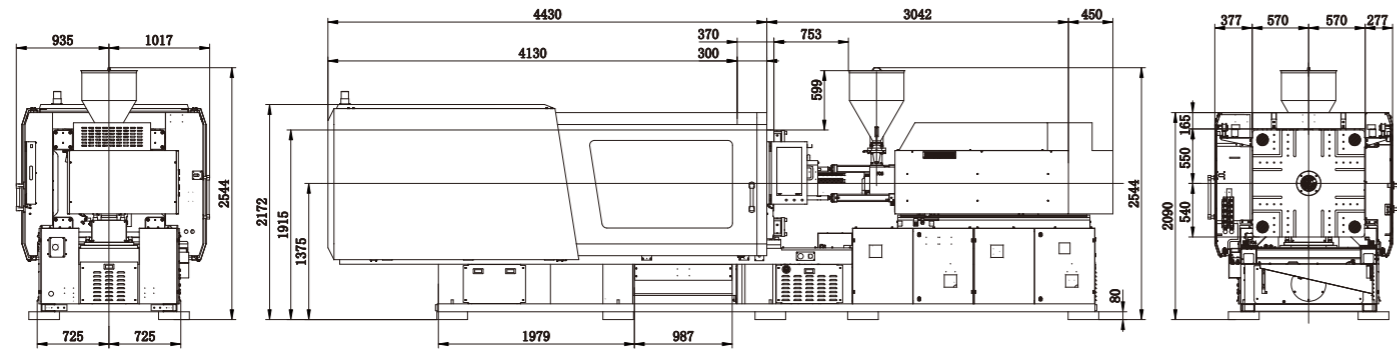
Platen Dimensions & Machine Dimensions



BL230FE

BL280FE

Platen Dimensions & Machine Dimensions



BL350FE

Configuration List

Standard Configuration Menu of BL110-450FE

Injection Unit			
Anti-resistant screw set (straight nozzle)	Low pressure&velocity mold open	International unit switch	
Nozzle safety cover(with limit switch)	Injection compress function	I/O display	
Injection 5 stage control	High pressure release during cooling time function	Printer interface(USB)	
Holding 5 stage control	Injection during mold close	Cycle monitor	
Charge 3 stage control	Twice mold close function	Production management	
Back pressure 5 stage control	Mold inside cut function	Product data record(5000 cycle display,100 thousands cycle saving)	
Suck back optional	Safety device for clamping(mechanical&electrical)	Product data graph	
Time delay for suck back	Adjustable support for moving platen	Product quality judgment	
Time delay before injection	Clamping force set	Product quality fail alarm	
Time delay before charging	Ejection device(compulsory rest optional)	Cycle counter	
Flow increase injection	Ejection detail function	Machine main status display	
V/P switch(position,time,pressure,velocity)	Ejection 3 stage control	Parameter fast set	
Injection speed response model selection	Ejection time delay	Maintenance management	
Injection pressure multi control	Ejection shake mode	Clamping force curve monitor	
Holding speed control	Variable ejection position mode	Barrel heat monitor	
Auto purge function	Synchronized ejection	Action cycle sequence display	
Charge speed control	Eject back check	Three color alarm light (red/yellow/green)	
Anti-cold start screw	Water flow5 sets	Buzzer	
Mold open while charge	Locating ring	Over injection protection(HPM pressure abnormal protection)	
Close loop temp control for barrel(K&J type)	Mold ejector protect interface	Real value display	
Barrel keep warm	Low speed mold movement	Trouble shooting selection	
Barrel temp optimization	Air blow (2 sets)		
Barrel temp preheat	Emergency stop(operate&non operate side)	Other	
Barrel temp synchronous warming	Mounting Holes of robot installation	Bole standard color	
Carriage move set(limit switch,moving time)	Central lubrication system	Enclosed safety door	
Suck back mode(3 mode)	Mold open&close flexible control	Adjustable level pad	
High contact force nozzle device		Socket 4 sets (380V 16A 2 set, 220V 10A 2 set)	
Nozzle centre adjustment equipment	Operation&Monitor		Tool box
Hopper temp control close loop	12 inch color touch screen		Spare parts,machine shield
Injection base rotation	Mold data saving(max200)		
Nozzle temp control	Alarm history		
	Modifying records		
	3 set USB interface		
	Injection pressure /speed curve display		
Clamp Unit			
Mold 5 stage control	EUmap I2		
Low pressure protection	Multi-language		

Optional Configuration Menu of BL110-450FE

Charge,Injection			
Chrome plated screw&barrel set	Hydraulic core (programmable)	Quality pick device	
Anti-wear and corrosion screw&barrel set	Pneumatic core(programmable)	Product falling sensor	
High power heating band for nozzle	ValveGate control device	Operation&Monitor	
Extending nozzle	Water flow meter	Mold temp control	
Mold pressure V/P switch function	Special platen(T slot,screw hole)	Quality pick electrical interface	
Air shut off nozzle	Electrical circuits for gear driving	Heating break detector	
Spring shut off nozzle	Enlarged max mold height	Add cooling water line	
Special head nozzle	Mold slider protection function	External transformer	
Standard hopper	Ejector compression function	Eu67 robot interface	
Stainless hopper	Mold auto clampdevice(pneumatic/hydraulic)	Gas assisted injection	
	Ejector with brake	Magnetic template interface	
Clamp Unit			
Air blast for fix and moving platen	Inner hot runner	Mold inner pressure detector interface	
Air ejector	Product fall plate	Other	
Hydraulic station(for core and valve gate)	Electrical door	Infrared heating for barrel	
	Close loop clamping force	Energy saving cover for barrel	