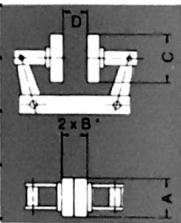


| BLASEINHEIT / BLOWING UNIT               |                                                                                   |                 | 60 / 20                             | 60 / 24 | 60 / 20 S | 60 / 24 S | 70 / 20 | 80 / 20 | 90 / 20 |
|------------------------------------------|-----------------------------------------------------------------------------------|-----------------|-------------------------------------|---------|-----------|-----------|---------|---------|---------|
| Artikelgröße max.<br>Container size max. | 1-fach / 2-fach / 3-fach / 4-fach<br>single / double / triple / quadruple         | cm <sup>3</sup> | 5.000 / 2.000 / 1.000 / 500         |         |           |           |         |         |         |
| Arbeitsweise<br>Operation                |  | —               | hydraulisch / hydraulic             |         |           |           |         |         |         |
| Formschließkraft<br>Mould locking force  |                                                                                   | kN              | 100                                 |         |           |           |         |         |         |
| Trockentaktzeit<br>Dry cycling time      |                                                                                   | sec             | 2,3                                 |         |           |           |         |         |         |
| Formöffnungsweg<br>Mould opening stroke  |                                                                                   | mm              | 215                                 |         |           |           |         |         |         |
| Formmaße<br>Mould dimensions             | Breite "A" / Tiefe "B" / Höhe "C"<br>Width "A" / Depth "B" / Height "C"           | mm              | 340 / 2 x 130 (2 x 155) / 450 (525) |         |           |           |         |         |         |

## EXTRUDER Antrieb stufenlos / EXTRUDER Infinitely variable drive

|                                                                          |                                        |                                 |         |         |           |           |              |               |             |
|--------------------------------------------------------------------------|----------------------------------------|---------------------------------|---------|---------|-----------|-----------|--------------|---------------|-------------|
| Schnecken-Durchmesser D / -Länge<br>Screw diameter D / -length           | L/D x 20                               | mm                              | 60 / 20 | 60 / 24 | 60 / 20 S | 60 / 24 S | 70 / 20      | 80 / 20       | 90 / 20     |
| Gleichstrom-Motor<br>DC Motor                                            | DC                                     | kW                              | 22      | 22      | —         | —         | —            | —             | —           |
| Drehstrom-Motor<br>AC-Motor                                              | AC                                     | kW                              | 18.5    | 18.5    | —         | —         | —            | —             | —           |
| Drehstrom-Nebenschlußmotor<br>Commutator motor                           |                                        | kW                              | 22      | 22      | 22 / 32   | 26 / 32   | 26 / 32 / 38 | 32/45/45/55   | 38/45/65    |
| Plastifizierleistung<br>Plasticizing capacity                            | PE-Standard                            | kg/h                            | 55      | 55      | 70        | 40        | 80           | 105/105/—/—   | 125/125/—/— |
|                                                                          | PE-WT / Heat separation                | kg/h                            | 70      | —       | 70 / 100  | —         | 225          | —/—/5/180     | —/—/215     |
|                                                                          | HM-WT / Heat separation                | kg/h                            | 60      | —       | 70 / 100  | —         | —/—/125      | —/—/145/180   | —/—/215     |
|                                                                          | PVC                                    | kg/h                            | 50      | 65      | 50        | 65        | 65 / 65 / —  | 80 / 80 / —/— | 90 / 90 / — |
| Heizleistung<br>Heating capacity                                         | PVC / PE / HMPE                        | kW                              | 12      | 16      | 12        | 16        | 15           | 18.5          | 24          |
| Heizzonen<br>Heating zones                                               |                                        | —                               | 3       | 4       | 3         | 4         | 5            | 3             | 3           |
| Kühlwasserbedarf für Einzugszone<br>Cooling water requirements feed zone | Δ p = 3 bar<br>nur für / only for HMPE | $\frac{\text{kJ}}{\text{kg/h}}$ |         |         |           |           |              |               |             |

## EXTRUSIONSKÖPFE / EXTRUSION HEADS

|                                                                                                               |      |                     |                           |  |  |  |  |  |  |
|---------------------------------------------------------------------------------------------------------------|------|---------------------|---------------------------|--|--|--|--|--|--|
| Einfachkopf, Düsen-Durchmesser<br>Single head, die diameter                                                   | mm   | 80 / 120 / 160      |                           |  |  |  |  |  |  |
| Zweifachkopf, Düsen-Durchmesser/Mittenabstand<br>Double head, die diameter/die centre distance                | mm   | 43 / 125 60 / 150   |                           |  |  |  |  |  |  |
| Dreifachkopf, Düsen-Durchmesser/Mittenabstand<br>Triple head, die diameter/die centre distance                | mm   | 35 / 85 35 / 100    |                           |  |  |  |  |  |  |
| Vierfachkopf, Düsen-Durchmesser/Mittenabstand<br>Quadruple head, die diameter/die centre distance             | mm   | 20 / 60 und 20 / 70 |                           |  |  |  |  |  |  |
| Heizleistung 1-fach / 2-fach / 3-fach / 4-fach PE<br>Heating capacity single / double / triple / quadruple PE | max. | kW                  | 3,15 / 3,31 / 2,79 / 5,16 |  |  |  |  |  |  |
| Heizleistung 1-fach / zweifach PVC<br>Heating capacity single / double PVC                                    | max. | kW                  | 4,35 / 6,86               |  |  |  |  |  |  |

## LUFT-, WASSER- UND ENERGIEVERBRAUCH / AIR, WATER AND ELECTRICITY CONSUMPTION

|                                                                                                                                         |                                                                      |                                                |           |           |         |         |              |              |           |
|-----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------|------------------------------------------------|-----------|-----------|---------|---------|--------------|--------------|-----------|
| Luftbedarf (Ansaugleistung) bei 10 bar Kompressordruck<br>Air requirements (Intake capacity) at 10 bar compressor pressure              | l/min                                                                |                                                |           |           |         |         |              |              |           |
| Effektiver Luftverbrauch max. Artikelgröße in PVC und 8 bar **)<br>Effective air consumption at a max. size of article in PVC and 8 bar | m <sup>3</sup> /h                                                    | 48 - 90 hydr. kalibrieren<br>hydr. calibrating |           |           |         |         |              |              |           |
| Arbeitsdruck<br>Working pressure                                                                                                        | bar                                                                  | 8 - 10                                         |           |           |         |         |              |              |           |
| Erforderliche Kühlleistung, Extruder + Form<br>Cooling capacity requirement, Extruder + mould                                           | PVC / PE / HMPE<br>$\frac{\text{kJ}}{\text{kg/h}}$                   | 420                                            |           |           |         |         |              |              |           |
| Erforderliche Kühlleistung Hydraulik<br>Cooling capacity requirements hydraulic                                                         | min. / max.<br>kJ / h                                                | 12.600                                         |           |           |         |         |              |              |           |
| Elektrische Anschlußwerte<br>Power connection                                                                                           | Hydraulik / Zusatzhydr. f. Servo<br>Hydraulic / Hydr. for programmer | kW                                             | 7,5       |           |         |         |              |              |           |
|                                                                                                                                         | Extruder<br>Extruder                                                 | kW                                             | 18.5 / 22 | 18.5 / 22 | 22 / 32 | 26 / 32 | 26 / 32 / 38 | 32 / 45 / 55 | 38 / 45   |
|                                                                                                                                         | Heizung<br>Heating                                                   | max.<br>kW                                     | 19        | 21        | 19      | 23      | 22           | 26           | 31        |
|                                                                                                                                         | Gesamt-Anschlußwert<br>Overall connected value                       | kW                                             | 46 / 49   | 47 / 51   | 53 / 59 | 57 / 63 | 56 / 62 / 68 | 66 / 79 / 89 | 77 / 84 / |
| Mittlerer Energieverbrauch<br>Average power consumption                                                                                 | ca. approx. min. / max.                                              | kWh                                            | 30 / 32   | 31 / 33   | 35 / 38 | 37 / 41 | 36 / 40 / 44 | 43 / 51 / 58 | 50 / 55   |

\*) Werte in Klammern gelten für VK1-10S  
Figures in brackets only for VK1-10S

\*\*) incl. Luftdusche + Schneckenkühlung  
incl. air shower and screw cooling