Extruder

Technical data

Melting capacity	ca. 5 kg/h (depending on material)
Heating zones	6 separately controllable
Temperature range	max. 250 °C
Temperature range feed zone	max. 30°C
Heat-up time	< 60 min (depending on material)
Material handling	Extruder screw with downstream plunger unit
Screw speed	max. 130/min
Volume plunger unit	20/ 60g
Control	Siemens 1200 SPS slave – controlled by main machine
Material pressure plunger unit	max. 40 bar
Extruder pressure limited to	100 bar
Noise emission at 1 m distance	62 dB(A)
Dimension	B 500 x T 1370 x H 905 mm

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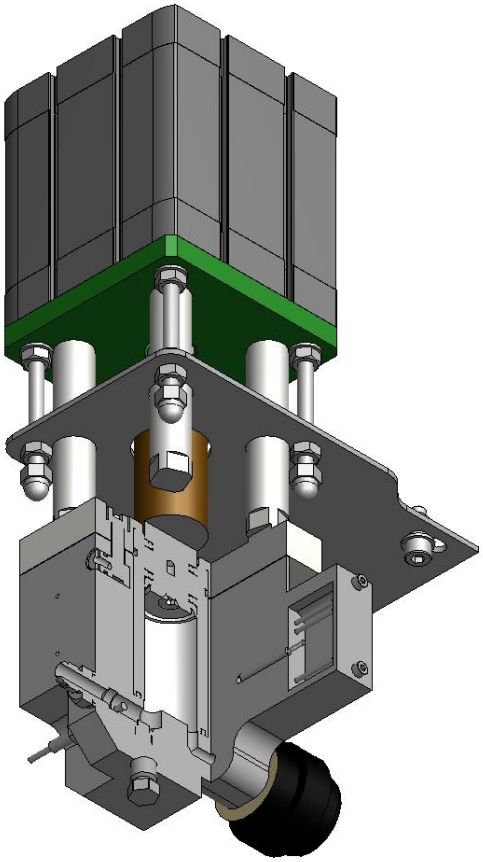
Plunger unit



The plunger unit has been specially designed to getting hot-melt molding materials injected under best controlled and reliable process conditions.
Independently of the way the hot-melt molding material is going to be melted this technology brings a full monitored constant injection pressure during injection stage. This technology eliminates the damageable peaks of injection pressure related to extruder direct injection.
The plunger is moved by a pneumatic cylinder including monitored travel.

Refilling of the chamber occurs after each or several injections depending of the left quantity of the chamber. With this technology the melting unit can be sized smaller in according to the high instantaneous material output which are mandatory in case of direct injection.

Technical data

Chamber capacity:	60g*
Injection pressure:	max. 40bar*
Heating power:	1200 W
Pressure sensor:	0-100 bar / 4-20 mA
Travel sensor:	analog 4-20 mA
Pressure factor:	I = 6,35

* other values available

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