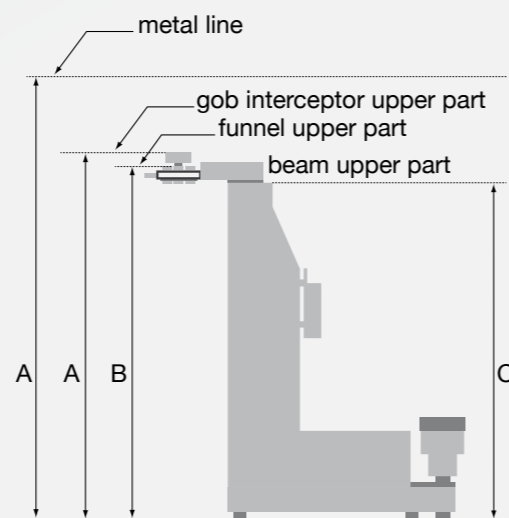
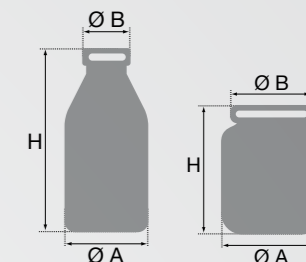


# IS MACHINE MEASURES AND PRODUCTION TIME TABLE



## MEASURES

I.S. MACHINE		4" 1/4				5"- B / 5"- S				5" 1/2				6" 1/4		
POS		6 sect.	8 sect.	10 sect.	12 sect.	6 sect.	8 sect.	10 sect.	12 sect.	6 sect.	8 sect.	10 sect.	12 sect.	8 sect.	10 sect.	12 sect.
A	GOB INTERCEPTOR UPPER PART	3500	3622	3932	4333	3534	3669	3932	4333	3583	3719	4033	4409	3719	4059	4409
B	FUNNEL UPPER PART	3294	3414	3723	4125	3325	3460	3723	4125	3375	3510	3825	4201	3510	3850	4201
C	BEAM UPPER PART	2884	3004	3313	3715	2915	3050	3313	3715	2965	3100	3414	3790	3100	3440	3790
D*	METAL LINE	4600	4800	5000	5400	4600	4800	5000	5400	4600	4800	5200	5500	4800	5200	5500

## PRODUCTION LIMIT TABLE

I.S. MACHINE	4"1/4				5"B			5"S			5"1/2		6"1/4	
	SG	DG	TG 3"	TG 3"1/8	SG	DG	TG 190	SG	DG	TG 85	SG	DG	DG	TG 4"1/4
<b>BLOW-BLOW</b>														
MAX HEIGHT UNDER FINISH (mm)	345	301	276	140	345	340	270	341	325	245	350	343	343	287
MIN HEIGHT UNDER FINISH (mm)	61	57	59	45	61	60	45	74	73	55	61	68	115	105
MAX BODY DIAMETER WITH BLOW AXIAL COOLING (mm)	156	76	51	50	156	95	60	156	95	60	156	102	121	76
MAX BODY DIAMETER WITH STACK-COOLING (mm)	178	90	52	60	178	105	75	178	102	62	178	114	130	90
MAX BODY DIAMETER WITH STACK-COOLING/VACUUM (mm)	170	80	45	50	170	95	65	170	95	54	170	102	121	76
MAX FINISH DIAMETER (mm)	48	48	30	35	48	48	38	48	48	30	48	48	48	48
<b>PRESS-BLOW</b>														
MAX HEIGHT UNDER FINISH (mm)	270	282	268	140	270	290	230	265	290	213	280	302	295	268
MIN HEIGHT UNDER FINISH (mm)	74	40	47	45	74	55	45	74	55	50	74	58	105	86
MAX BODY DIAMETER WITH BLOW AXIAL COOLING (mm)	156	76	51	50	156	95	60	156	95	60	156	102	121	76
MAX BODY DIAMETER WITH STACK-COOLING (mm)	178	90	52	60	178	105	75	178	102	62	178	114	130	90
MAX BODY DIAMETER WITH STACK-COOLING/VACUUM (mm)	170	80	45	50	170	95	65	170	95	54	170	102	121	76
MAX FINISH DIAMETER (mm)	120	83	38	45	120	90	60	120	90	55	120	90	90	70

## STANDARD SERVICE REQUIREMENTS FOR BDF I.S. MACHINES

I.S. MACHINES TYPE 4" 1/4 - 5"										
Application	Pressure		6 sect.		8 sect.		10 sect.		12 sect.	
	p.s.i.	kg/cm <sup>2</sup>	ft <sup>3</sup> /min	Nm <sup>3</sup> /min	ft <sup>3</sup> /min	Nm <sup>3</sup> /min	ft <sup>3</sup> /min	Nm <sup>3</sup> /min	ft <sup>3</sup> /min	Nm <sup>3</sup> /min
L.P. COMPRESSED AIR	30	2.1	283	8	353	10	423	12	493	14
H.P. COMPRESSED AIR	45	3.15	371	10.5	495	14	619	17.5	619	17.5
P&B - PLUNGER COOLING	45	3.15	212	6	283	8	354	10	426	12
NNPB-PLUNGER COOLING *	87	6	212	6	283	8	354	10	426	12
VACUUM BLOW MOULD	25" Hg	635 mm Hg	170	4.8	226	6.4	283	8	339	9.6
VACUUM BLANK SIDE	25" Hg	635 mm Hg	85	2.4	113	3.2	142	4	170	4.8
MACHINE COOLING AIR	42" WC	1050 mm Hg	21190	600	28252	800	35314	1000	42380	1200
CONVEYOR COOLING AIR	26"WC	650 mm H <sub>2</sub> O	4238	120	5650	160	7063	200	8476	240
COOLING WATER	30	2.1	-	10 l/min	-	10 l/min	-	10 l/min	-	10 l/min

- \* For NNPB plunger cooling pressures above 3.15 Kg/cm<sup>2</sup> (if required by the customer)
- Quantities specified are free air (21°C-70°F and 1 Kg/cm<sup>2</sup>-14.7 p.s.i.)
- The operating air supply must be clean and dry (it is required the installation of drying and filter system before the piping connection to the machine with an efficiency of 98% and a nominal retention of 4 ÷ 10 µ)

I.S. MACHINE TYPE 5"1/2 - 6"1/4										
Application	Pressure		6 sect.		8 sect.		10 sect.		12 sect.	
	p.s.i.	kg/cm <sup>2</sup>	ft <sup>3</sup> /min	Nm <sup>3</sup> /min	ft <sup>3</sup> /min	Nm <sup>3</sup> /min	ft <sup>3</sup> /min	Nm <sup>3</sup> /min	ft <sup>3</sup> /min	Nm <sup>3</sup> /min
L.P. COMPRESSED AIR	30	2.1	318	9	424	12	530	15	636	18
H.P. COMPRESSED AIR	45	3.15	424	12	565	16	706	20	848	24
P&B - PLUNGER COOLING	45	3.15	240	6.8	318	9	406	11.5	487	13.8
NNPB-PLUNGER COOLING *	87	6	240	6.8	318	9	406	11.5	487	13.8
VACUUM BLOW MOULD	25" Hg	635 mm Hg	170	4.8	226	6.4	283	8	339	9.6
VACUUM BLANK SIDE	25" Hg	635 mm Hg	85	2.4	113	3.2	142	4	170	4.8
MACHINE COOLING AIR	42" WC	1050 mm WC	21190	600	28252	800	35314	1000	42380	1200
CONVEYOR COOLING AIR	26"WC	650 mm H <sub>2</sub> O	4238	120	5650	160	7063	200	8476	240
COOLING WATER	30	2.1	-	12 l/min	-	12 l/min	-	12 l/min	-	12 l/min

- Maximum temperature of compressed air supply to the machine = 80°C
- Minimum temperature of compressed air supply to the solenoid valve block = 10°C
- Pilot air (Valve Block) 0.5 m<sup>3</sup>/min of free air at 21°C (clean, oil and water free)
- Dew point of compressed air: -5 ÷ -2 °C
- Water hardness 100 parts CaCO<sub>3</sub> per 1,000,000 parts of water (P.P.M.)