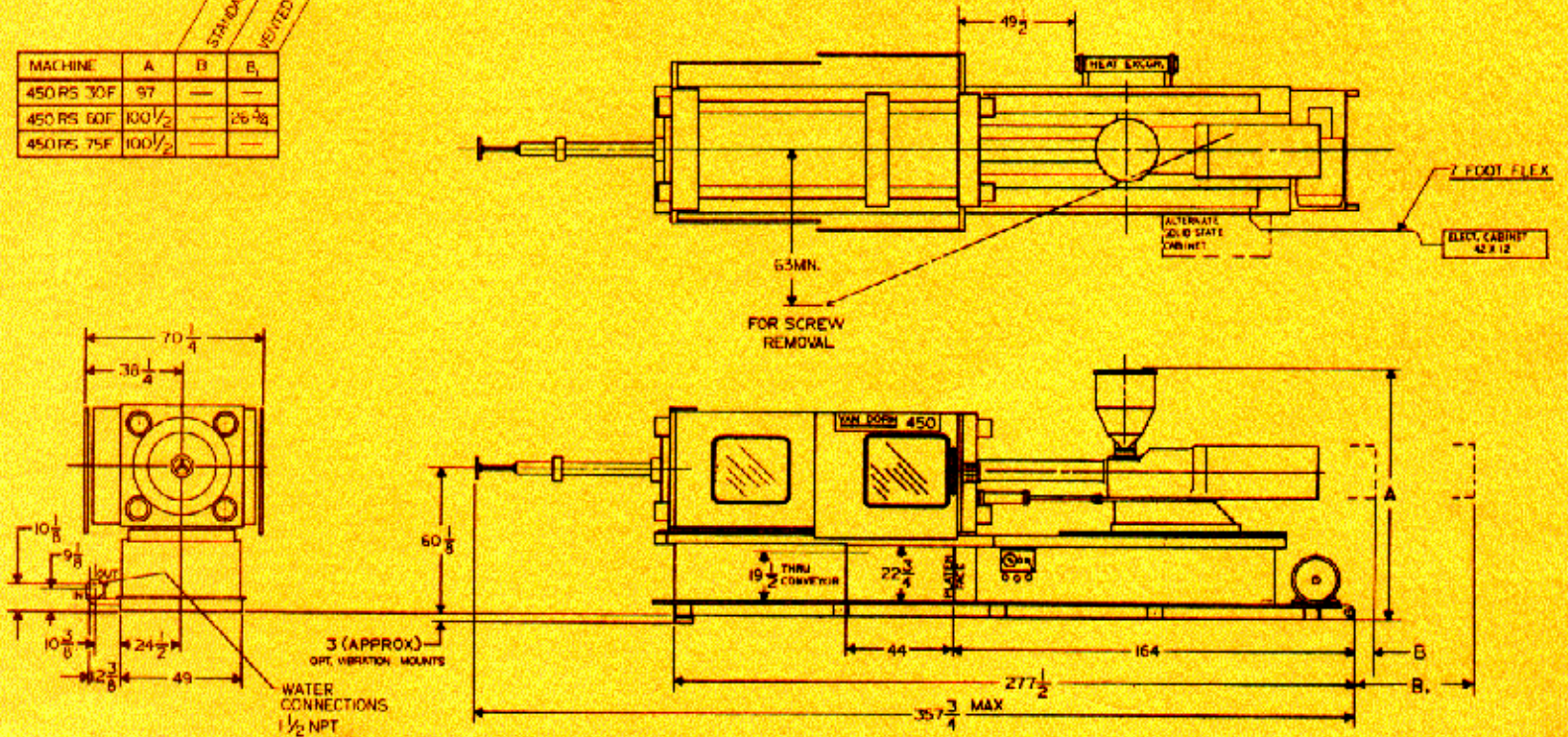


VAN DORN®

TOGGLE CLAMP

450-RS-30/60/75F

MACHINE	STANDARD BARREL			VENTED BARREL		
	A	B	B ₁	A	B	B ₁
450 RS 30F	97	—	—	—	—	—
450 RS 60F	100 1/2	—	26 3/8	—	—	—
450 RS 75F	100 1/2	—	—	—	—	—



Injection Unit

	450 RS 30F	450 RS 60F	450 RS 75F
Injection Capacity—Calculated (cu.in.)	55.3	111.5	141.1
Injection Capacity—G.P. Polystyrene (Oz.)*	30	60	75
Recovery Rate—G.P. PS (oz./sec.)†	2.30	2.95	3.85
Injection Pressure—Max. (p.s.i.)	19,800	20,400	16,100
Injection Rate—at 10,000 p.s.i. (cu. in./sec.)	25.5	25.0	30.5
Injection Stroke (in.)	10.75	14.51	14.31
Screw Diameter (in.)	2.56	3.15	3.54
Barrel L/D Ratio	20:1	20:1	20:1
Screw Speed Range (R.P.M.)	30-250	30-200	30-200
Back Press. Adjust (screw rotating—p.s.i.)	75-300	75-300	75-300

General Specifications

	450 RS 30F	450 RS 60F	450 RS 75F
Pump Motor—Hydraulic System (HP)	75	75	75
System Pressure (p.s.i.)	2000	2000	2000
Total Heating Wattage (KW)	13.9	18.8	22.3
Number of Heat Control Zones	4	4	4
Comb. Pump Capacity (G.P.M. @ 100 p.s.i.)	69	69	69
Oil Capacity (Gal.)	280	280	280
Hopper Capacity (Lb.)	145	225	225
Machine Weight (Lb. approx.)	42,600	46,000	46,400
Machine Dimensions—Length (ft.)	30.0	30.0	30.0
—Width (ft.)	6.0	6.0	6.0
—Height (ft.)	8.5	8.5	8.5

Clamping Unit

Clamp Force (tons)	450
Clamp Stroke—Adjustable (in.)	12-26
Open Daylight—Max. (in.)	55
Mold Thickness—Min./Max. (in.)	10-29
Platen Size Standard—HxV (in.)	46.5 x 47
Dist. Between Rods—Std. HxV (in.)	30 x 30
Tie Rod Diameter (in.)	5
Clamp Speeds:	
Closing (in./sec.)	19
Opening (in./sec.)	27
Ejector Force (tons)	11.3
Ejector Stroke (in.)	5

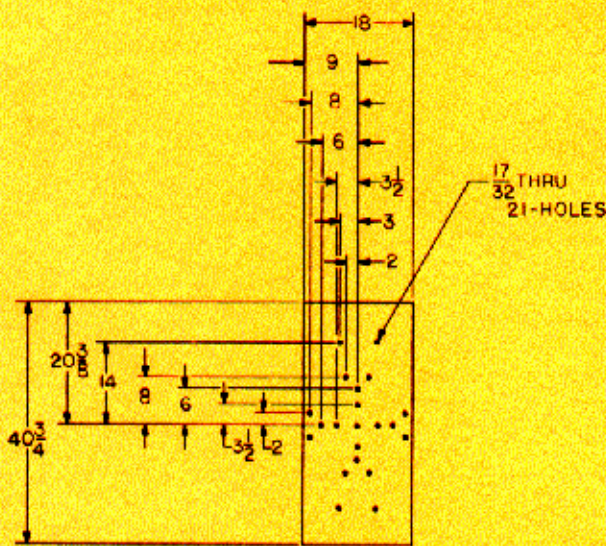
Since continuous improvement is Van Dorn's policy, we reserve the right to change specifications, designs and performance data without prior notice or obligation.

* Dependent upon mold, material and conditions.

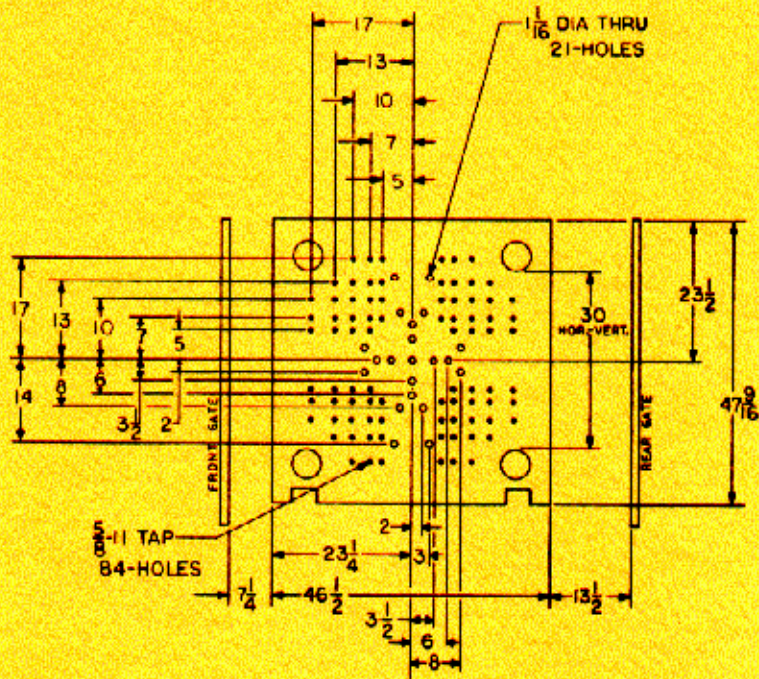
† Average value based on S.P.I. test procedures.

‡ Higher torque motor available with lower R.P.M. and recovery rate.

‡‡ Consult factory for PVC and PC applications.



HYD. K.O. PLATE



MOVABLE PLATEN

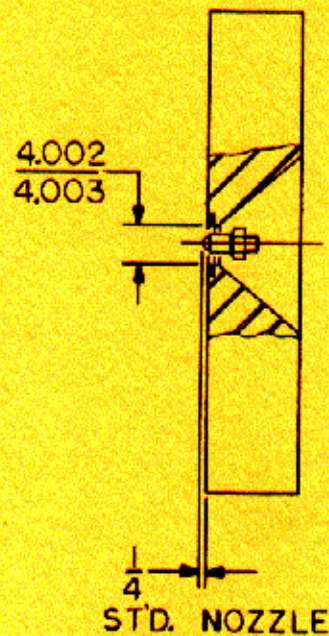
450-RS-30/60/75F

Van Dorn's fluid drive, or F-Series, toggle clamp machines feature hydraulically driven screws that generate high-quality homogeneous melts at high rates. Stable screw speeds and precise, infinitely variable back pressure control are features contributing to outstanding molding output.

Add faster set-ups, improved molding speeds and minimal maintenance and you have the injection molding capability molders identify with the name, Van Dorn.

STANDARD FEATURES

- Large part removal clearance • Purge guard with interlock • Swing away material hopper • Integral-base drip pan • Full-floating hardened toggle pins • Automatic oil lubrication.



STATIONARY PLATEN

VAN DORN®

Committed to the future of plastics

VAN DORN PLASTIC MACHINERY CO., | A Division of Van Dorn Company

11792 Alameda Dr. • Strongsville, Ohio 44136 • Write: P.O. Box 8848 • Strongsville, Ohio 44136 • Telephone: (216) 238-8960 • Telex: 980887

Effective May 1, 1982 • Litho in U.S.A.