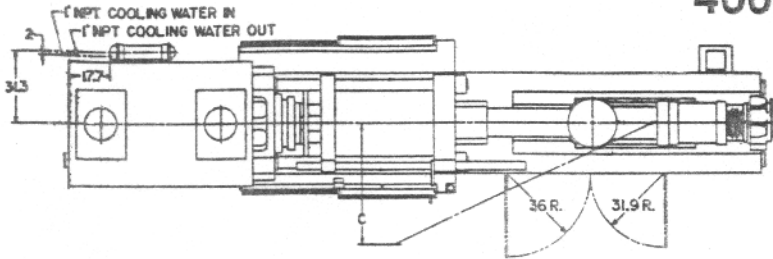
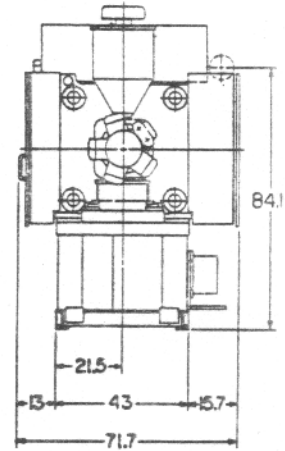
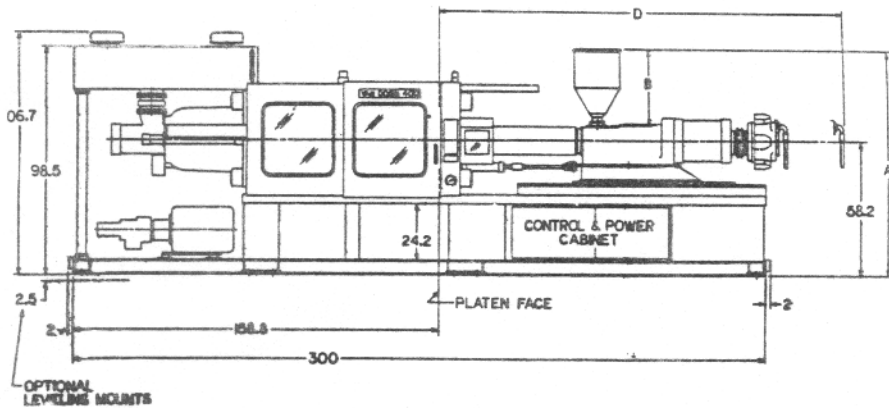


VAN DORN®

HP SERIES-HYDRAULIC CLAMP 400H-RS-30/48/60F



MACHINE	STD. BARREL VENTED BARREL				
	A	B	C	D	D
400H-RS 30F	98	33.5	60	155	191
400H-RS 48F	98	33.5	62	173	206
400H-RS 60F	100	35.5	64	175	219



INJECTION UNIT	400-RS 30F	400-RS 48F	400-RS 60F
Inject Capacity-Calculated (cu. in.)	59.2	89.0	111.5
Inject Capacity-G.P. Polystyrene (oz.)*	30	48	60
Recovery Rate-G.P. Polystyrene (oz./sec.)+	2.65	3.00	2.65
Injection Pressure-Max. (p.s.i.)	20,100	20,000	20,400
Inject Rate-at 10,000 p.s.i. (cu.in./sec.)	28.5	28.5	28.0
Inject Stroke (in.)	11.50	13.00	14.31
Screw Diameter (in.)	2.56	2.95	3.15
Screw Diameter (mm)	65	75	80
Barrel L/D Ratio	20:1	20:1	20:1
Screw Speed Range (R.P.M.)	30-290	30-220	30-180
Back Press Adjust (screw rotating) (p.s.i.)	75-300	75-300	75-300
CLAMPING UNIT			
Clamp Force (tons)	400	400	400
Clamp Opening Force (tons)	17.7	17.7	17.7
Clamp Stroke-Max. (in.)	32	32	32
Open Daylight-Max. Ejector Box removed (in.)	54++	54++	54++
Mold Thickness-Min. Ejector Box installed (in.)	10++	10++	10++
Ejector Box Thickness (in.)	12	12	12
Platen Size-Std-HxV (in.)	41.5X41.5	41.5X41.5	41.5X41.5
Platen Size-Opt-HxV (in.)	47.75X47.75	47.75X47.75	47.75X47.75
Dist. Between Rods-Std-HxV (in.)	28X28	28X28	28X28
Dist. Between Rods-Opt-HxV (in.)	34.25X34.25	34.25X34.25	34.25X34.25
Tie Rod Diameter (in.)	5	5	5
Clamp Speeds: Closing-Fast (in./sec.)	25.2	25.2	25.2
Opening-Fast (in./sec.)	29.0	29.0	29.0
Ejector Force (tons)	8.3	8.3	8.3
Ejector Stroke (in.)	6	6	6
Ejector Speed: (fwd/retract) (in./sec.)	16/26	16/26	16/26

POWER	400-RS 30F	400-RS 48F	400-RS 60F
Pump Motor (Motors/HP)	60	60	60
Barrel Heating Wattage (KW)	20	29.8	28.3
Number of Heat Control Zones	4	4	4
CONTROL			
Multi-Microprocessor W/Display Screen	Yes	Yes	Yes
Closed Loop Process Control	Yes	Yes	Yes
Control Voltage (V)	110	110	110
Control Voltage (Solenoids) (Vdc)	24	24	24
HYDRAULIC			
Variable Volume Pump Type	Piston	Piston	Piston
Screw Motor Type	Piston	Piston	Piston
GENERAL SPECIFICATIONS			
System Pressure (Inject/Clamp) (p.s.i.)	2000/2500	2000/2500	2000/2500
Comb. Pump Capacity (@ 100 p.s.i.)(G.P.M.)	83	83	83
Oil Capacity (Gal.)	300	300	300
Hopper Capacity (lb.)	145	145	225
Machine Weight (lb. approx.)	36,700	36,900	37,200
Machine Dimensions -Length (ft.)	26.3	27.6	27.8
-Width (ft.)	6.0	6.0	6.0
-Height (ft.)	8.9	8.9	8.9

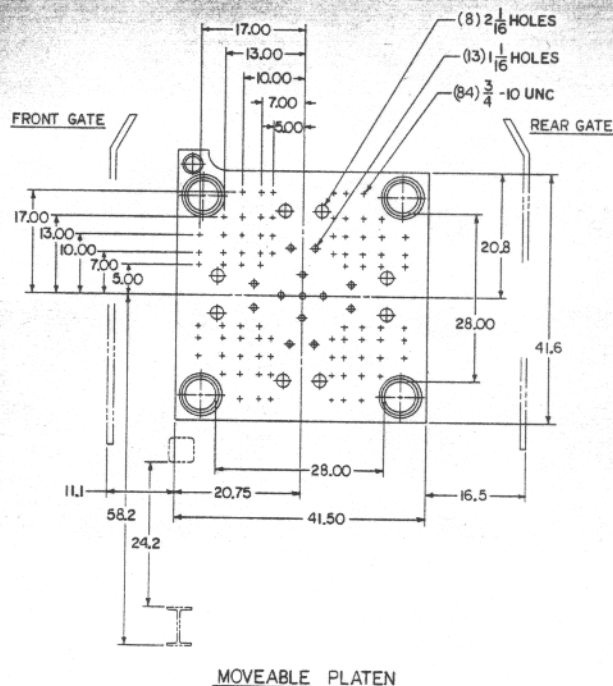
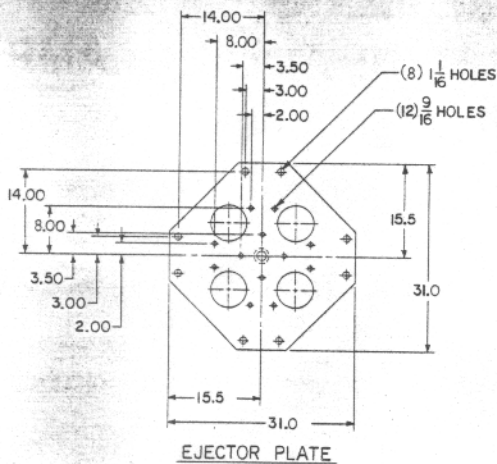
* Dependent upon mold, material and conditions.

+ Average value based on S.P.I. Test Procedures.

++ Extended tie bar spacing option reduces minimum mold thickness and maximum open daylight by 1/2".

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

Power Cabinet is furnished with Pathfinder EL Control System.



STANDARD FEATURES

Injection Unit

- In-line injection unit, non-rotating piston
- Radial piston screw drive motor, dual torque
- Screw speed tachometer with digital set and display
- Cold screw startup protection
- Sprue break with 2 selectable sequences and OFF
- Screw pullback before and/or after screw rotate
- Pivoting injection unit
- Swing-away hopper
- Bimetallic barrel (30 oz. only)

Clamp Unit

- Single acting main ram with twin outboard cylinders
- Self-lubricating bushings requiring only periodic lubrication
- Adjustable moving platen supports on hardened steel ways
- Full SPI knockout pattern
- Independently powered hydraulic ejection
- Multiple eject sequences
- Eject forward hold
- Ratchet type safety stop bar

Hydraulics

- Energy efficient variable volume pump system
- Proportional and cartridge valve hydraulics
- 24 V DC solenoids

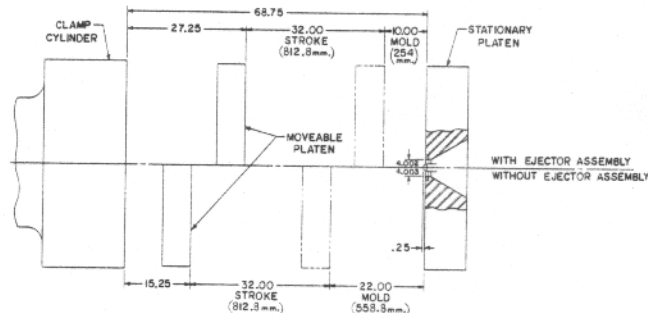
General

- Closed-loop oil temperature control
- High oil temperature and low oil level alarms
- Selectable oil preheat sequence
- Full-time oil filtration with alarm
- Drip pans under manifolds

Control

- Multi-microprocessor system
- Closed-loop process control
- PID temperature control
- Self-diagnostics with automatic troubleshooting
- Precision position sensing for clamp, inject, and eject
- Digital setup of all speeds, pressures, and positions

See brochure for available options.



VAN DORN®

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 Effective June, 1991 • Litho in U.S.A