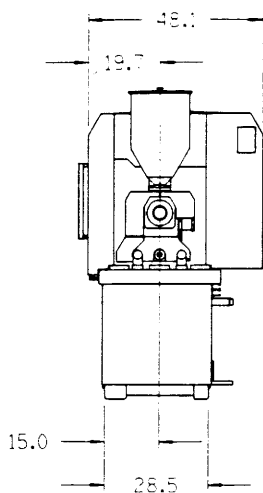
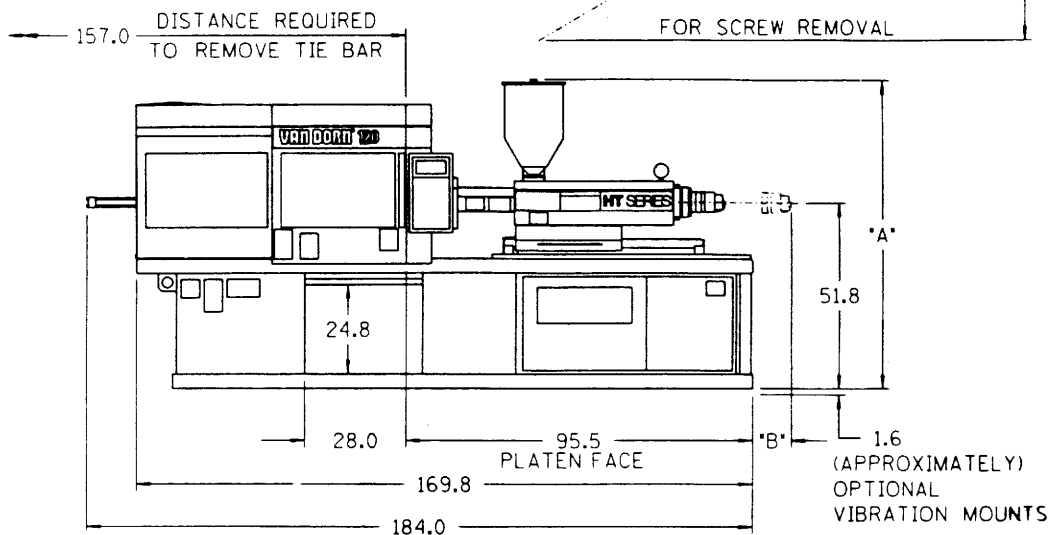
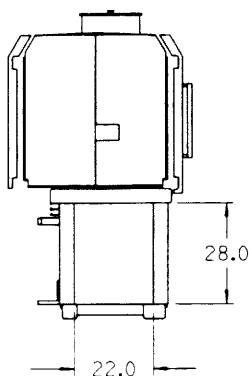
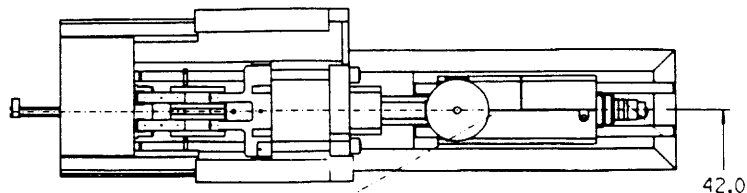


VAN DORN®

HT SERIES TOGGLE CLAMP 120-RS-6/8F



	"A"	"B"
STANDARD BARREL		
6F	73.5	-----
8F	86.00	7.25
VENTED BARREL		
8F	86.00	29.30



INJECTION UNIT		120-RS 6F	120-RS 8F
Inject Capacity—Calculated	(cu. in.)	11.9	14.8
Inject Capacity—G.P. Polystyrene	(oz.)*	6	8
Recovery Rate—G.P. Polystyrene	(oz./sec.)+	0.80	0.80
Injection Pressure—Max.	(p.s.i.)	19,900	20,000
Inject Rate—at 10,000 p.s.i.	(cu.in./sec.)	11.5	11.5
Inject Stroke	(in.)	6.75	7.62
Screw Diameter	(in.)	1.50	1.58
Screw Diameter	(mm)	38	40
Barrel L/D Ratio		20:1	20:1
Screw Speed Range	(R.P.M.)	30-360++	30-330
Back Press Adjust (screw rotating)	(p.s.i.)	75-300	75-300
CLAMPING UNIT			
Clamp Force	(tons)	120	120
Clamp Stroke—Adjustable	(in.)	14	14
Open Daylight—Max.	(in.)	30	30
Mold Thickness—Min./Max.	(in.)	6-16	6-16
Platen Size—HxV	(in.)	25 x 25	25 X 25
Dist. Between Rods—HxV	(in.)	17 X 17	17 X 17
Tie Rod Diameter	(in.)	2.75	2.75
Clamp Speeds: Closing	(in./sec.)	28	28
Opening	(in./sec.)	37	37
Ejector Force	(tons)	5.0	5.0
Ejector Stroke	(in.)	3.0	3.0
POWER			
Pump Motor, Hydraulic System	(HP)	20	20
Power (Supply)	(V)	460	460
Total Heating Wattage	(KW)	8.1	8.9
Number of Heat Control Zones		3	4

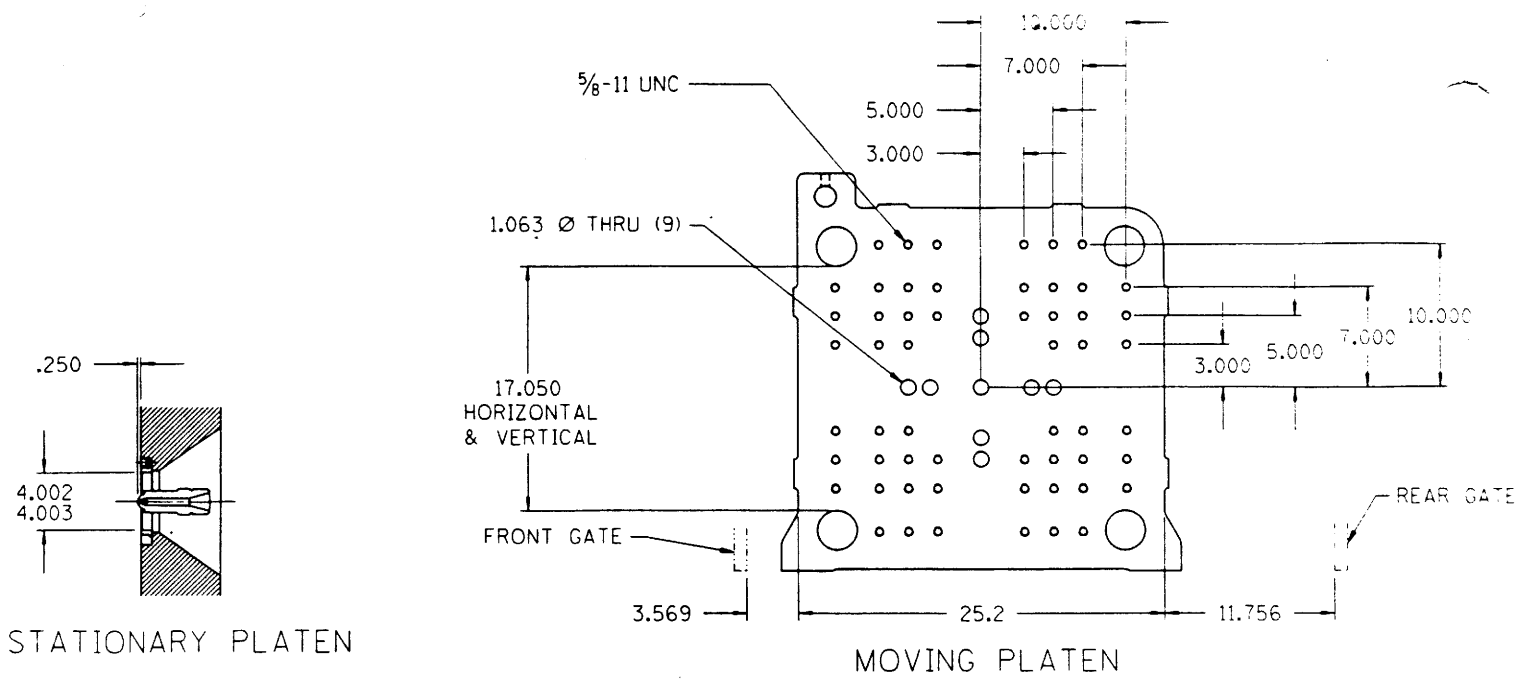
CONTROL		120-RS 6F	120-RS 8F
Multi-Microprocessor W/Display Screen		Yes	Yes
Closed Loop Process Control		Yes	Yes
Control Voltage	(V)	110	110
Control Voltage (Solenoids)	(Vdc)	24	24
HYDRAULIC			
Variable Volume Pump Type		Piston	Piston
Screw Motor Type		Gear	Gear
GENERAL SPECIFICATIONS			
System Pressure	(p.s.i.)	2,000	2,000
Comb. Pump Capacity (@ 100 p.s.i.)	(G.P.M.)	31	31
Oil Capacity	(Gal.)	80	80
Hopper Capacity	(lb.)	40	85
Machine Weight	(lb. approx.)	9,500	9,700
Machine Dimensions	Length (ft.)	15.3	15.9
	Width (ft.)	4.3	4.3
	Height (ft.)	6.6	7.3

* 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.

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



STANDARD FEATURES

Injection Unit

- In-line injection unit, non-rotating piston
- Gear screw drive motor
- 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

Clamp Unit

- Hardened steel toggle pins
- Self-lubricating bushings requiring only periodic lubrication
- Adjustable moving platen supports on hardened steel ways
- Full SPI knockout pattern
- Multiple eject sequences
- Pushbutton, motorized die height and tonnage adjustment with automatic power lock
- Ratchet type safety stop bar

Hydraulics

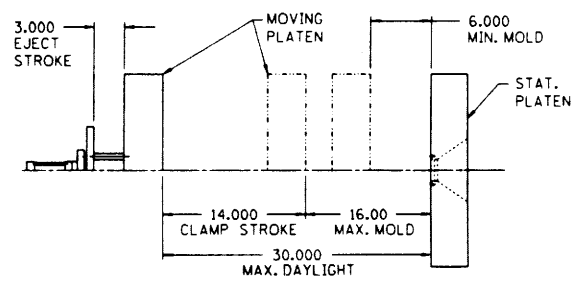
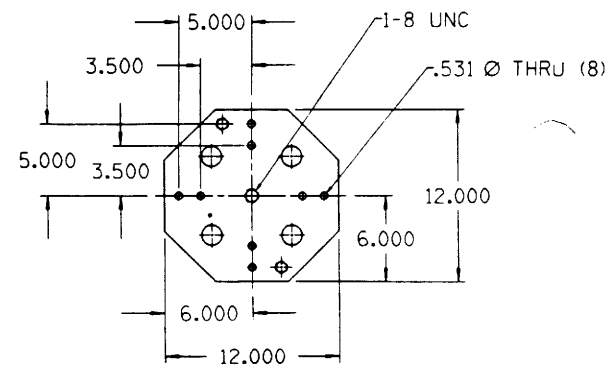
- Energy efficient variable volume pump system
- Proportional and cartridge valve hydraulics
- 24 V DC solenoids

General

- Closed-loop oil temperature control
- High oil temperature and low oil level alarms
- Selectable oil preheat sequence
- Full-time oil filtration with alarm
- Large 3-way part drop area

Control

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



See your Van Dorn Sales Agent for available options.



Committed to the future of plastics

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

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Effective October, 1989 • Litho in U.S.A