

Ref. no. 15824 // Status: January 2017

Technische Daten / Technical data

- PET STRECKBLASMASCHINE - - PET STRETCH BLOW MOULDING MACHINE -

SIG Corpoplast Blomax 10 Serie II



Beschreibung / Description

Gebrauchte und überholte PET Streckblasmaschine für die Verarbeitung von PET-Preforms

Second hand reconditioned PET stretch blow moulding machine for the processing of PET preforms

Maschinendaten / Machine data

Hersteller / <i>Manufacturer</i>	SIG Corpoplast
Typ / <i>Type</i>	Blomax 10 Serie II
Baujahr / <i>Year of manufacture</i>	1999
Material / <i>Material</i>	PET
Ausstoßleistung (1,5l) / <i>Output (1,5l)</i>	ca. 12.000-14.000 Stk/h
Bodenfläche mit Schrägförderer (L x B) / <i>Floor space with vertical conveyor (l x w)</i>	9.400 mm x 8.400 mm
Höhe / <i>Height</i>	3.600 mm
Blasrad-Modul / <i>Blowing wheel module</i>	9.420 kg
Heizrad-Modul / <i>Heating wheel module</i>	3.190 kg
Schaltschrank / <i>Control cabinet</i>	1.000 kg
Anzahl d. Blasstationen / <i>No. of blowing stations</i>	10 Stk. / pcs.
Anzahl d. Transportdorne / <i>No. of transport mandrel</i>	145 Stk. / pcs.
Anzahl Dornhalterung im Heizband / <i>No. of mandrel supports on the heating wheel</i>	135 Stk. / pcs.
Anzahl Transportdorne im Heizrad / <i>No. of transport mandrels on the heating wheel</i>	125 Stk. / pcs.
Übergabearme Station I / <i>No. of transfer arms station I</i>	4 Stk. / pcs.
Übergabearme Station II / <i>No. of transfer arms station II</i>	4 Stk. / pcs.
Übergabearme Station III / <i>No. of transfer arms station III</i>	4 Stk. / pcs.
Stationen Beladerad / <i>Stations on loading wheel</i>	6 Stk. / pcs.
Stationen Entladerad / <i>Stations on unloading wheel</i>	6 Stk. / pcs.
Stationen Wenderad / <i>Station turning wheel</i>	6 Stk. / pcs.
Heizkästen / <i>Heater boxes (+ 3 pcs. optional)</i>	14 Stk. / pcs.

Flaschengröße / Bottle dimension

min. Volumen / <i>min. volume</i>	200 ml
max. Volumen / <i>max. volume</i>	3.000 ml
max. Länge / <i>max. length</i>	350 mm
max. Durchmesser / <i>max. diameter</i>	126 mm

Preformgröße / Preform dimension

<i>min. Länge / min. length</i>	200 mm
<i>max. Länge / max. length</i>	60 mm
<i>max. Ø Neckring / max. Ø of support ring</i>	48 mm
<i>min. Ø Innenkörper / min. internal Ø of body</i>	16 mm
<i>min. Ø Innenöffnung / min. Ø of orifice</i>	21 mm
<i>max. Ø Innenöffnung / max. Ø of orifice</i>	30 mm

Druckluft (sauber, trocken und Ölfrei) / Compressed Air (clean, dry and free of oil)

<i>Steuerluft / Plant air pressure</i>	7 bar
<i>Steuerluftverbrauch / Service air consumption</i>	ca. 140 Nm³/h
<i>Blasluft Druck / Blowing air pressure</i>	max. 40 bar
<i>Blasluftverbrauch für 1,5l Flasche, 40 bar, 12.000 Flaschen / Blowing air consumption for 1,5l bottles, 40 bar, 12.000 bottles</i>	ca. 1.127 Nm³/h
<i>Geräuschemission im Arbeitsbereich (Bedienteil) / Sound emission in the working area (operating panel)</i>	< 85 dbA

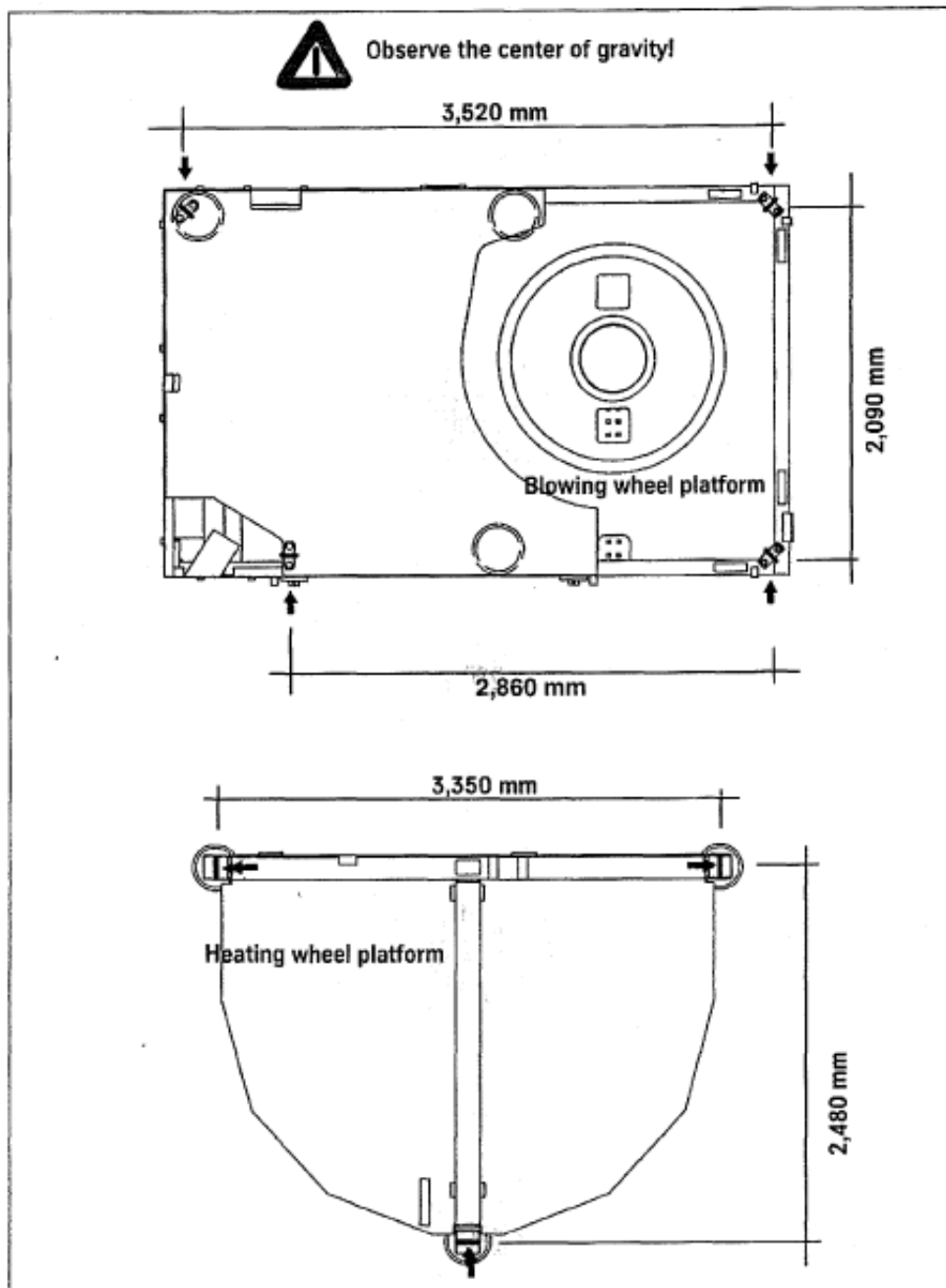
Kühlwasser (mit Rostschutzmittel) / Cooling water (incl. corrosion preventing agent)

<i>Wasserdruck / Water pressure</i>	6 bar
<i>Wassertemperatur / Water temperature</i>	10° C
<i>Durchflussrate / Flow rate</i>	10 m³/h
<i>Abzuführende Wärmemenge / Dissipated heat</i>	40,2 kW

Elektrische Daten / Electrical data

<i>Versorgungsspannung 3-Phasen + Neutralleiter + Schutzleiter / Supply voltage + 3-Phase + neutral conductor + protective conductor</i>	3 x 400 V / 50 Hz + N + PE
<i>Interne Steuerspannung / Internal control voltage</i>	110 / 220 / 50 V / HZ 24; 12 V DC
<i>Gesamtanschlussleistung / Total capacity</i>	210 kVA
<i>Antriebe und Steuerung / Drives and controls</i>	14,2 kVA
<i>Installierte Heizleistung / Installed heating capacity</i>	179,2 kW
<i>Durchschnittsverbrauch / Average total consumston</i>	127 kW

Weitere Informationen / Further information



2 Transportation of the Machine

- For transportation of the machine, the hoses, the cable duct, air channel, bottle discharge, and preform supply rails are dismantled. Thereafter, the blow moulding machine can be transported including the machine cover.
- The electrical cabinet, the roller conveyor, vertical conveyor, and the dismantled assemblies are packed into one container.
- The machine must be fastened by means of a sling gear (fig. 1).
- The crane must have a minimum capacity of 12.5 t.
- If the machine is not fastened as shown in fig. 2, please consider that the weight of the machine is not equally distributed.



Observe the center of gravity!

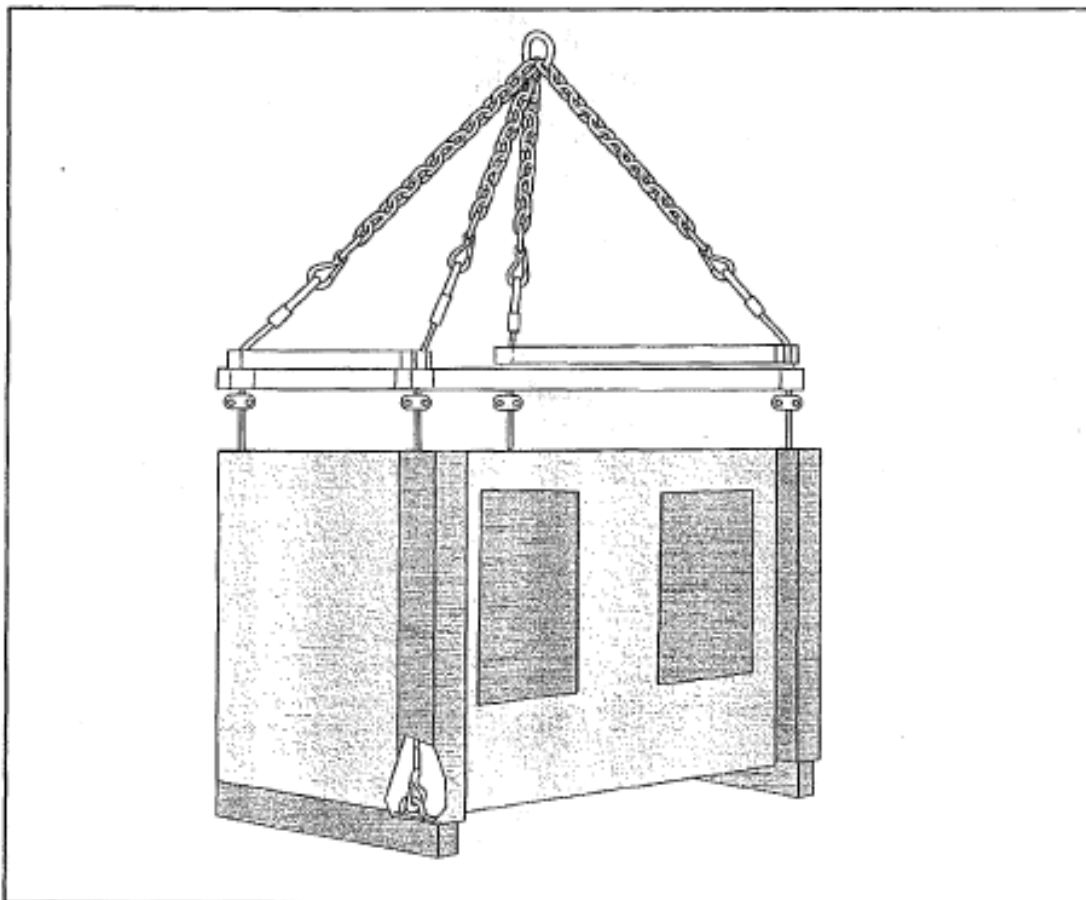


- In order to check the stable position tentatively lift each module for a few centimeters.

Intermediate storage

If the blow moulding machine is not mounted right after delivery, special preparations for the storage have to be met:

- Store the machine in a safe, vibration-free area.
- Cover the machine in such a way that it is protected from dust.
- Protect the machine from humidity.



3 Setting up the Machine

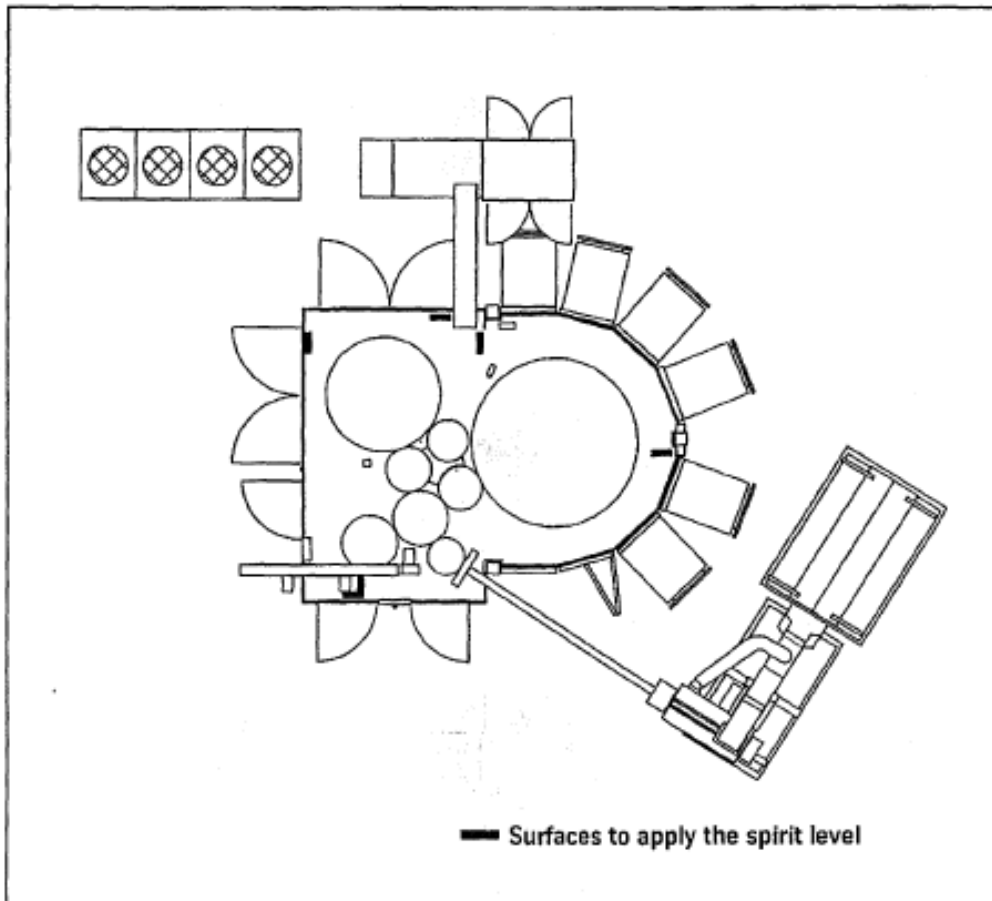


Fig. 1

Aligning the Machine

- A special foundation for the installation of the plant is not required. A flat concrete floor carrying the static weight of the plant is sufficient.
- If the machine is installed onto an intermediate ceiling, the carrying capacity of the ceiling must be checked.
- Align the blowing wheel platform by means of the six adjusting feet. Apply the spirit level in the marked position (tolerance: 0.1 mm per m).
- The heating wheel platform is aligned to the blowing wheel platform by means of three adjusting feet, and screwed and bolted.
- All other components of the plant are assigned according to the individual installation plan.

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