

**AKRON EXTRUDERS, INC.**  
**2 1/2" 24:1 L/D PAK 250 RPVC EXTRUDER**

**BARREL DESIGN**

24:1 L/D, non-vented, bimetallic hard lining, 10,000 psi maximum operating pressure, recess for breaker plate and one (1) plugged hole, one (1) pressure tap and rupture disc rated at 7500 psi located at discharge end.

**BARREL HEATING**

Resistance aluminum band heaters, arranged in four separate zones, wired for individual instrument control, 4 kW per zone.

**BARREL COOLING**

Four separate zones of air cooling, wired for individual instrument control, including heavy duty motor driven blower for each zone.

**FEED SECTION**

Water cooled feed throat with 2 1/2" x 4" rectangular feed opening.

**GATE**

Heated four bolt swing gate, breaker plate and blank die adapter.

**FEED SCREW**

4140 heat treated alloy steel, No.6 Stellite flight lands, chrome plate, hollow bored and tapped for cooling, single stage with four ~~(4) rows of mixing pins~~. **Designed to process virgin RPVC pellets. (SEE OPTIONS)**

**100-1500  
GEAR REDUCER**

Double reduction, heat treated high capacity helical gears, heavy duty radial bearings, and heavy duty integral thrust bearing. Unrestricted high capacity oil flow provided to all gears and bearings, including integral thrust arrangement. Overall ratio is 13.9:1 giving a 125 screw RPM. Actual reducer ratio is 13.9:1. AGMA Class II rating at 1750 input speed is 72 HP.

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**CONTROL CABINET**

- 4 - Digital control instruments for the barrel zone, three position solid state Eurotherm programmable Model 808 (1/8 Din).
- 1 - Digital control instrument for the gate zone, two position solid state Eurotherm programmable Model 808 (1/8 Din).
- 1 - Digital control instrument for the die zone, two position solid state Eurotherm programmable Model 808 (1/8 Din). *plus (3) additional (see options) total (4)*
- 1 - Digital motor load ammeter.
- 1 - Digital screw RPM indicator.
- 1 - Screw speed control rheostat (10 Turn).
- 1 - Screw RPM Start-Stop push button.
- 1 - Digital melt temperature indicator.

Cabinet wired to NEC standards for 460 volts, 3 phase, 60 hz. electrical service.

Heater burn-out ammeters furnished for all zones as standard.

Die zone is wired 240 volts with 7.5 KVA transformer.

Cabinet is prewired and mounted to the extruder base and includes cabinet door interlock, disconnect and mercury contactors.

**PRESSURE INDICATOR**

Externally mounted Dynisco PG-442 melt pressure indicator.

**RESIN HOPPER**

Fabricated from carbon steel, including sight glass, resin stop and dump port. Hopper capacity is 4.2 cubic feet.

**DRIVE**

**Reliance Flexpak 3000** solid state variable speed DC drive system including:  
40 HP DC drive motor, 460 volts, 3 phase, 60 Hz., dripproof enclosure, with blower/filter package mounted. **.01% speed regulation.** Drive package mounted in a NEMA enclosure. The maximum allowable operating temperature of the cabinet is 130 degrees F. Price includes sheaves, belts, guard and adjustable motor base to provide proper belt tension.

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**OTHER**

Complete testing of extruder prior to shipment including the processing of material.

Two extruder manuals complete including Start-Up information, Bill of Materials, Layout Drawing, Electrical Schematics and Preventive Maintenance brochure.

Extruder warranty is for twelve (12) months on all parts unless otherwise specified by component manufacturer.

**EXTRUDER/DRIVE PACKAGE PRICE.....**  
**RIGHT HAND CONFIGURATION**

In order to protect you and Akron Extruders from possible insurance problems resulting from an accident while an extruder is in transit, we will ship all machines FOB destination point, and shipping costs will be added to the price of the extruder.

**PAK 250 RPVC OPTIONS**

Powder seal .....	
Single bolt clamp front end with die blank .....	\$
Screw rotary union assembly .....	
Panel mounted digital melt pressure indicator .....	
Isolation Mounts (set of four) .....	
Hour Meter .....	
3x One additional die zone (each).....	\$ 780..
2 HP Nash model MHC-25 Vacuum system .....	
Screw pusher .....	

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**OPTIONS (cont.)**

Bunting Model FF 4400 Drawer Type Hopper Magnet .....

**Cast Finned heaters and shrouds c/w heavy duty blowers .....**

On sight barrel alignment including travel and expenses ..... \$1:

Special paint color, (AE standard is Process Blue);

STD/Enamel, Price .....

Epoxy, Price .....

**\* Adder to supply a barrier screw with Maddock mixer .....**  
**in place of "pin screw" as quoted above**

