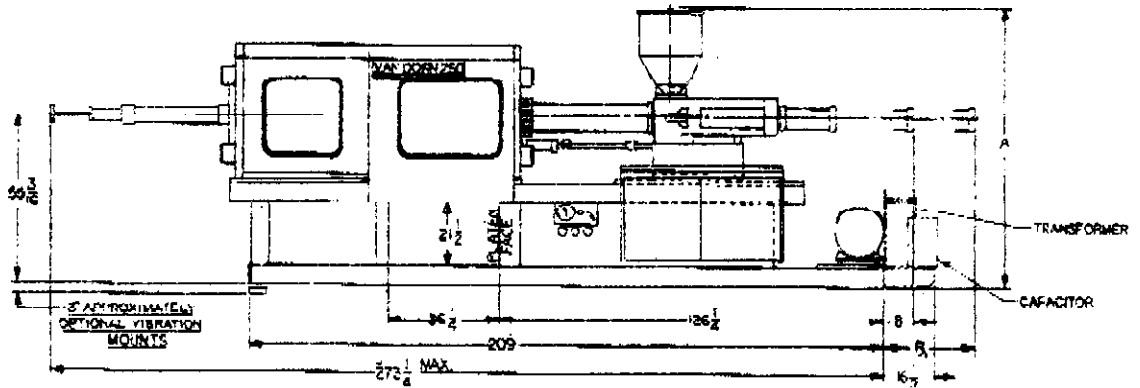
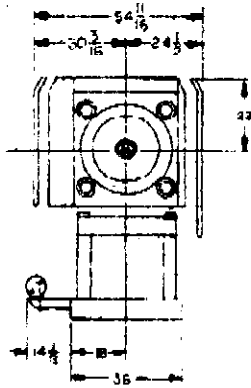
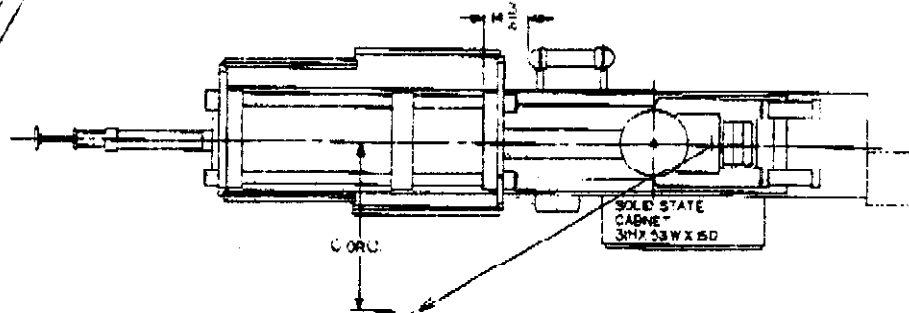


VAN DORN

TOGGLE CLAMP

250-RS-14/20/30/35F

MACHINE	STANDARD BARREL		VERTICAL BARREL	
	A	B	C	D
250-RS-14F	93 3/16	—	2 3/4	42 3/8
250-RS-20F	94 1/16	—	3 3/8	44
250-RS-30F	94 3/8	2 3/8	3 8/16	41 3/8
250-RS-35F	94 3/8	6 1/2	4 1/2	44 1/4



Injection Unit

	14F	20F	30F	35F
Inject Capacity—Calculated (cu. in.)	25.9	37.6	55.3	65.2
Inject Capacity—G.P. Polystyrene (Oz.)*	14	20	30	35
Recovery Rate—G.P. PS (oz./sec.)†	1.65	2.00	2.20	2.45
Injection Pressure—Max. (p.s.i.)	19,800	19,900	19,800	17,500
Inject Rate—at 10,000 p.s.i. (cu. in./sec.)	24.5	24.5	24.5	27.5
Inject Stroke (in.)	8.50	9.50	10.75	11.25
Screw Diameter (in.)	1.97	2.24	2.56	2.72
Barrel L/D Ratio	20:1	20:1	20:1	20:1
Screw Speed Range (R.P.M.)	30-350††	30-300††	30-235	30-235
Back Press. Adjust (screw rotating—p.s.i.)	75-300	75-300	75-300	75-300

Clamping Unit

Clamp Force (tons)	250
Clamp Stroke—Adjustable (in.)	8-19
Open Daylight—Max. (in.)	42
Mold Thickness—Min./Max. (in.)	8-23
Platen Size—Standard—HxV (in.)	33 x 36
Dist. Between Rods—Std. HxV (in.)	22 x 22
Tie Rod Diameter (in.)	4
Clamp Speeds:	
Closing (in./sec.)	34
Opening (in./sec.)	47
Ejector Force (tons)	5
Ejector Stroke (in.)	4

General Specifications

Pump Motor—Hydraulic System (HP)	50	50	50	50
System Pressure (p.s.i.)	2000	2000	2000	2000
Total Heating Wattage (KW)	12.7	13.9	10.9	16.3
Number of Heat Control Zones	4	4	4	4
Comp. Pump Capacity (G.P.M. @100 p.s.i.)	68	68	68	68
Oil Capacity (Gal.)	170	170	170	170
Hopper Capacity (Lb.)	145	145	145	145
Machine Weight (Lb. approx.)	23,500	23,700	23,900	24,200
Machine Dimensions—Length (ft.)	19.6	19.6	20.7	20.9
—Width (ft.)	5.0	5.0	5.0	5.0
—Height (ft.)	8.1	8.1	8.1	8.1

*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.

