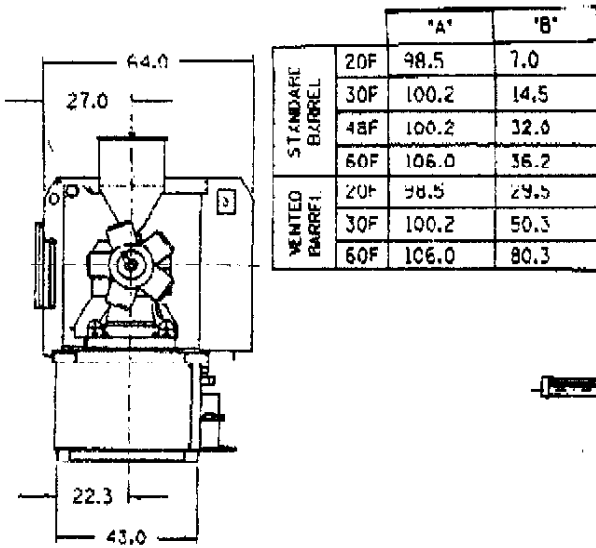


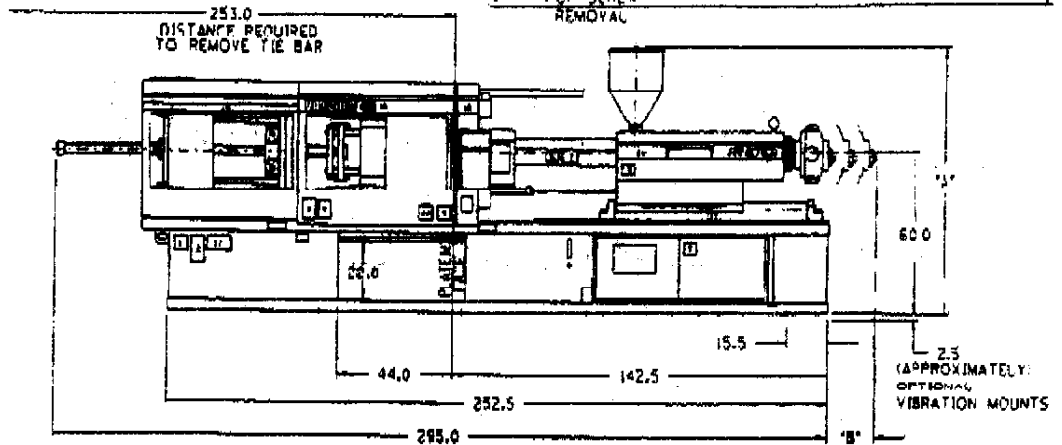
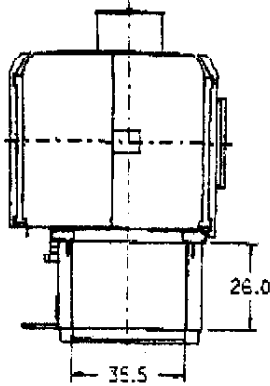
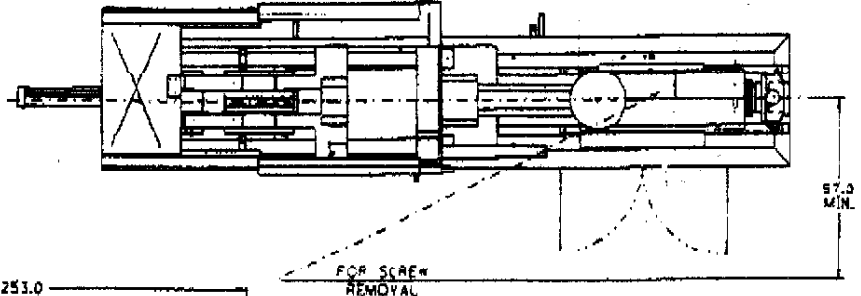
VAN DORN®

HT SERIES TOGGLE CLAMP

400-RS-30/48/60/24/36F



		'A'	'B'
STANDARD BARREL	20F	98.5	7.0
	30F	100.2	14.5
	48F	100.2	32.0
	60F	106.0	36.2
VENTED BARREL	20F	98.5	29.5
	30F	100.2	50.3
	60F	106.0	80.3



INJECTION UNIT	400-RS-30F	400-RS-48F	400-RS-60F	400-RS* 24F HPI	400-RS* 36F HPI
Inject Capacity-Calculated (cu in)	59.2	89.0	111.5	45.5	66.9
Inject Capacity-G.P. Ps (oz)**	90	49	80	24.8	86.4
Recovery Rate-G.P. Ps (oz/sec)+	2.95	3.30	3.16	2.00	2.20
Injection Pressure-Max. (p.s.i.)	20,100	20,000	20,400	26,100	26,800
Inject Rate @ 10,000 p.s.i. (cu in/sec)	30.0	30.0	29.5	29.0	22.5
Inject Stroke (in)	11.80	13.00	14.21	11.80	13.00
Screw Diameter (in)	2.56	2.96	3.15	2.24	2.56
Screw Diameter (mm)	65	75	80	57	65
Barrel L/D Ratio	20:1	20:1	20:1	20:1	20:1
Screw Speed Range (rpm)	30-320	30-240	30-215	30-300	30-240
Back Press (screw rotating) (psi)	75-300	75-300	75-300	75-300	75-300

CLAMPING UNIT					
Clamp Force (tons)	400	400	400	400	400
Clamp Stroke-Adjustable (in)	26	26	26	26	26
Open Daylight-Max. (in)	52	52	52	52	52
Mold Thickness-Min./Max. (in)	8/28	8/28	8/28	8/28	8/28
Platen Size-H & V (in)	42X42	42X42	42X42	42X42	42X42
Dist. Between Rods-H & V (in)	28X28	28X28	28X28	28X28	28X28
Tie Rod Diameter (in)	5	5	5	5	5
Clamp Speeds: Closing (in/sec)	24	24	24	24	24
Opening (in/sec)	32	32	32	32	32
Ejector Force (tons)	12.5	12.5	12.5	12.5	12.5
Ejector Stroke (in)	6	6	6	6	6

POWER					
Pump Motor, Hyd. System (HP)	60	60	60	60	60
Power (Supply) (V)	460	460	460	460	460
Total Heating Usage (KW)	20.0	29.8	28.3	18.2	25.5
Number of Heat Zones	4	4	4	4	4

CONTROL	400-RS-30F	400-RS-48F	400-RS-60F	400-RS* 24F HPI	400-RS* 36F HPI
Multi-Microprocessor++	Yes	Yes	Yes	Yes	Yes
Closed Loop Process Control	Yes	Yes	Yes	Yes	Yes
Control Voltage (V)	110	110	110	110	110
Control Voltage (Dc) (Vdc)	24	24	24	24	24

HYDRAULIC					
Variable Volume Pump Type	Piston	Piston	Piston	Piston	Piston
Screw Motor Type	Piston	Piston	Piston	Piston	Piston

GENERAL SPECIFICATIONS					
System Pressure (psi)	2,000	2,000	2,000	2,000	2,000
Comb. Pump Capacity +--+ (gpm)	82	82	82	82	82
Oil Capacity (gal)	170	170	170	170	170
Hopper Capacity (lbs)	145	145	225	145	145
Machine Weight (lbs approx)	37,800	38,200	38,600	34,600	34,900
Machine Dimensions: Length (ft)	25.8	27.3	27.6	25.8	27.0
Width (ft)	5.6	5.6	5.6	5.6	5.6
Height (ft)	8.4	8.4	8.9	8.4	8.4

* HPI Injection Units shown are high pressure injection units utilizing a 30 oz drive with 20 oz screw and barrel and a 48 oz drive with 30 oz screw and barrel, respectively. With the added stroke of the injection cylinder, the 20 oz screw becomes 24 oz and the 30 oz screw becomes 36 oz. Please note specifically the recovery rate and inject speed specifications, which you will want to know is satisfactory for your needs.

** General purpose polystyrene. Dependent upon mold, material and conditions.
 + General purpose polystyrene. Average value based on S.P.I. test procedures
 +--+ With display screen
 +--+ At 100 psi

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