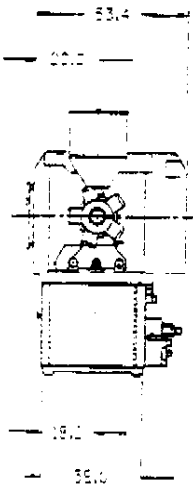
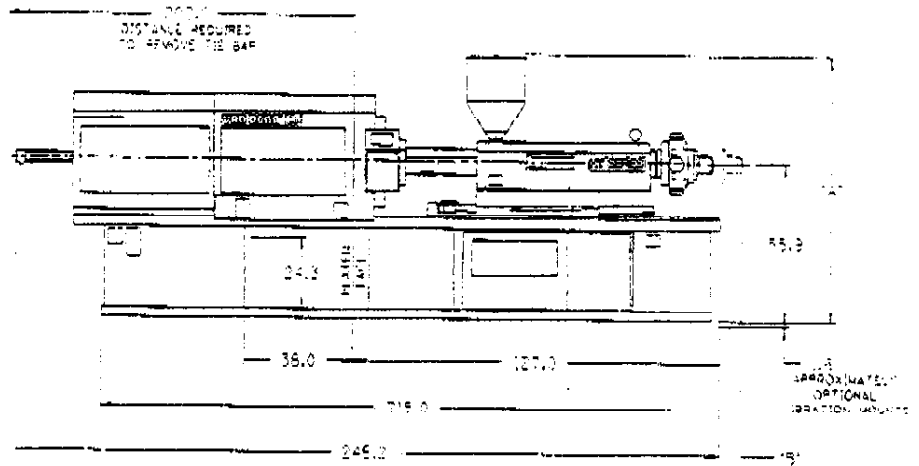
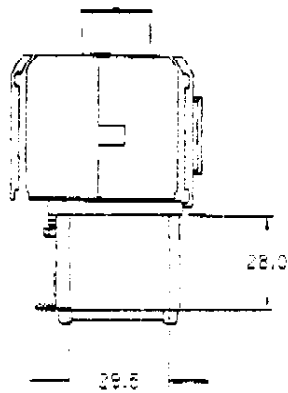
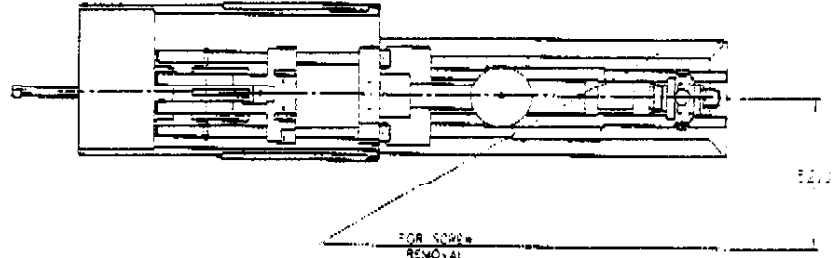


VAN DORN®

HT SERIES TOGGLE CLAMP 230-RS-14/20/30F



	'A'	'B'
STANDARD BARREL		
14F	93.5	9.3
20F	93.5	22.5
30F	94.5	34.0



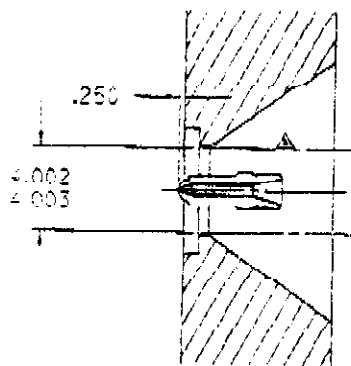
INJECTION UNIT		230-RS 14F	230-RS 20F	230-RS 30F
Inject Capacity—Calculated	(cu. in.)	27.0	40.0	59.2
Inject Capacity—G.P. Polystyrene	(oz.)*	14	20	30
Recovery Rate—G.P. Polystyrene	(oz./sec.)†	1.65	2.15	2.05
Injection Pressure—Max.	(p.s.i.)	20,000	20,000	20,000
Inject Rate—at 10,000 p.s.i.	(cu.in./sec.)	21.0	21.0	21.0
Inject Stroke	(in.)	8.88	10.12	11.50
Screw Diameter	(in.)	1.97	2.24	2.56
Screw Diameter	(mm)	50	57	65
Barrel L/D Ratio		20:1	20:1	20:1
Screw Speed Range	(H.P.M.)	30-350	30-325	30-225
Back Press Adjust (screw rotating)	(p.s.i.)	75-300	75-300	75-300
CLAMPING UNIT				
Clamp Force	(tons)	230	230	230
Clamp Stroke	(in.)	20	20	20
Open Daylight	Adjustable (in.)	42	42	42
Mold Thickness	Min./Max. (in.)	7-22	7-22	7-22
Platen Size	HxV (in.)	32 X 32	32 X 32	32 X 32
Dist. Between Rods	HxV (in.)	22 X 22	22 X 22	22 X 22
Tie Rod Diameter	(in.)	3.75	3.75	3.75
Clamp Speeds:	Closing (in./sec.)	29	29	29
	Opening (in./sec.)	39	39	39
Ejector Force	(tons)	5.0	5.0	5.0
Ejector Stroke	(in.)	4.5	4.5	4.5
POWER				
Pump Motor, Hydraulic System	(HP)	40	40	40
Power (Supply)	(V)	460	460	460
Total Heating Wattage	(KW)	16.7	19.4	21.2
Number of Heat Control Zones		4	4	4

CONTROL	230-RS 14F	230-RS 20F	230-RS 30F
Multi-Microprocessor W/Display Screen	Yes	Yes	Yes
Closed Loop Process Control	Yes	Yes	Yes
Control Voltage	(V)	110	110
Control Voltage (Solenoids)	(Vdc)	24	24
HYDRAULIC			
Variable Volume Pump Type	Piston	Piston	Piston
Screw Motor Type, Dual Torque	Gear	Piston	Piston
GENERAL SPECIFICATIONS			
System Pressure	(p.s.i.)	2,000	2,000
Comb. Pump Capacity (@ 100 p.s.i.)	(G.P.M.)	56	56
Oil Capacity	(gal.)	120	120
Hopper Capacity	(lb.)	145	145
Machine Weight	(lb. approx.)	20,000	20,100
Machine Dimensions	Length (ft.)	21.2	22.3
	Width (ft.)	4.7	4.7
	Height (ft.)	7.8	7.8

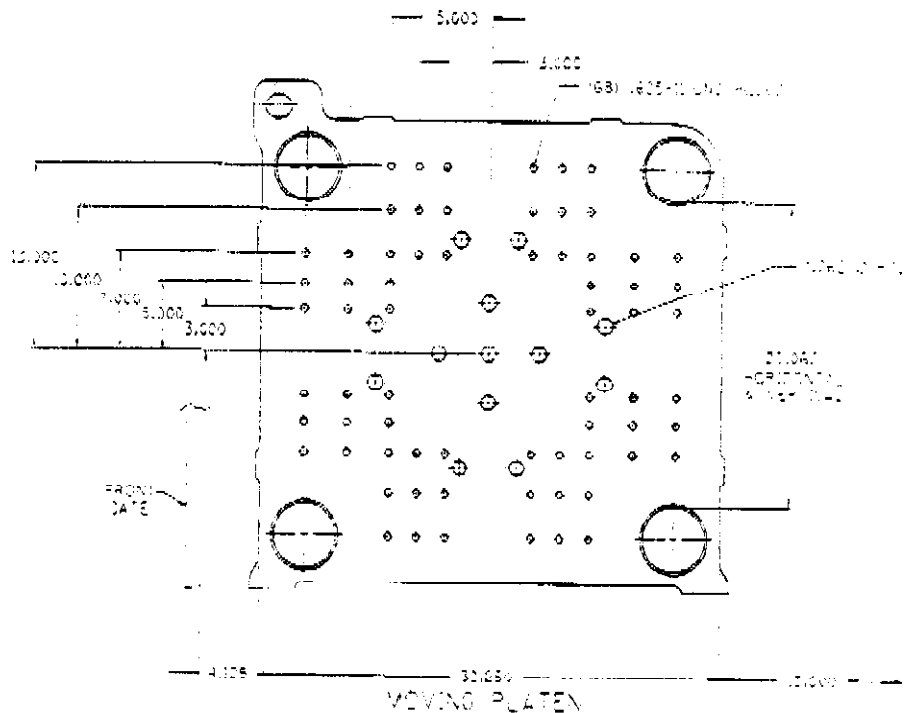
* Dependent upon mold, material and conditions.

† Average value based on S.P.I. test procedures.

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



STATIONARY PLATEN



STANDARD FEATURES

Injection Unit

- In-line injection unit, non-rotating piston
- Radial piston screw drive motor, dual torque (20 and 30 oz.)
- Gear type motor, dual torque (14 oz.)
- 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

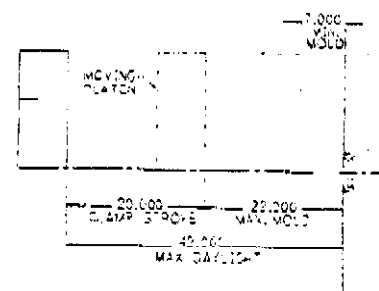
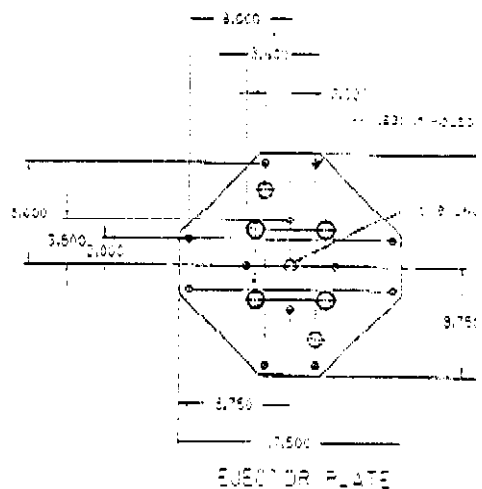
General

- 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 troubleshooting
- Precision position sensing for clamp, inject, and eject
- Digital setup of all speeds, pressures, and positions

See brochure for available options.



VAN DORN®

Committed to the future of plastics

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

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