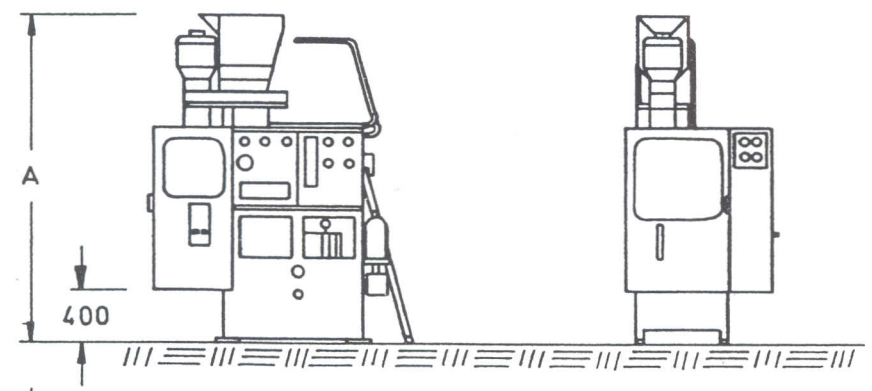
R. Stahl
Blasformtechnik GmbH

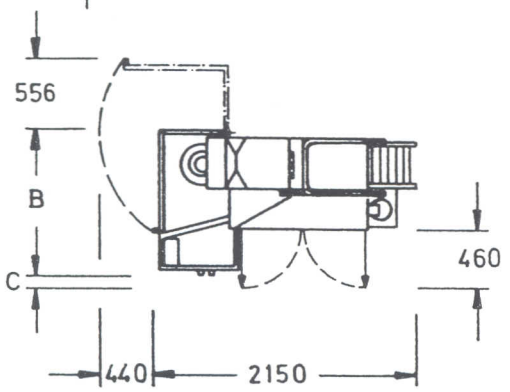
Technical data

		HS 361	HS 360	HS 451	HS 450
Blow moulder					
Clamping pressure		18 kN	18 kN	18 kN	18 kN
Mould opening stroke, adjustable		90–140 mm	90–140 mm	90–140 mm	90–140 mm
Hydraulic working pressure		90–110 bar	90–110 bar	90–110 bar	90–110 bar
Capacity of oil tank		approx. 180 l	approx. 180 l	approx. 180 l	approx. 180 l
Dry cycle time		1,3 s	1,3 s	1,3 s	1,3 s
Production cycles/h max.		1350	1350	1350	1350
Extruder					
Drive hydromotor infinitely variable					
– Screw speed		0–100 rpm	0–100 rpm	0–100 rpm	0–100 rpm
– Screw diameter/length		36 mm/20 D	36 mm/20 D	45 mm/20 D	45 mm/20 D
Plastification capacity:	PVC	approx. 20 kg/h	approx. 20 kg/h	approx. 30 kg/h	approx. 30 kg/h
(guided indication)	PE	approx. 15 kg/h	approx. 15 kg/h	approx. 20 kg/h	approx. 20 kg/h
	PETG	approx. 20 kg/h	approx. 20 kg/h	approx. 25 kg/h	approx. 25 kg/h
Die heads					
Single die head	nozzle diameter	max. 38 (60) mm	max. 38 (60) mm	max. 48 (60) mm	max. 48 (60) mm
Double die head	nozzle diameter	max. 26/26/35 mm	max. 26/26/35 mm	max. 26/26/35 mm	max. 26/26/35 mm
	distance between nozzles	50/60/70 mm	50/60/70 mm	50/60/70 mm	50/60/70 mm
Triple die head	nozzle diameter	max. 26 mm	max. 26 mm	max. 26 mm	max. 26 mm
	distance between nozzles	2 x 50 mm	2 x 50 mm	2 x 50 mm	2 x 50 mm
Energy requirements					
Electromotor hydraulic		7.5 kW	7.5 kW	11 kW	11 kW
Heating capacity extruder		4.4 kW	4.4 kW	6.6 kW	6.6 kW
Electr.control unit automatic		0.7 kW	0.7 kW	0.7 kW	0.7 kW
Total connected load		13 kW	13 kW	19 kW	19 kW
Air requirement		approx. 260 Nl/min	approx. 180 Nl/min	approx. 260 Nl/min	approx. 180 Nl/min
Air working pressure		7–10 bar	7–10 bar	7–10 bar	7–10 bar
Cooling requirement					
– Hydr.system blow mould		8000/13000 kJ/h*	8000/13000 kJ/h*	10000/18000 kJ/h*	10000/18000 kJ/h*

Dimensions

* 1 kJ=0.239 kcal





	HS 361	HS 360	HS 451	HS 450
A (mm)	2570	2570	2800	2800
B (mm)	1135	820	1135	820
C (mm)	125	440	125	440
Netweight approx. kg	1250	1200	1400	1350
Transportvolume approx. m^3	7.2	5.8	7.4	6.0

The designation indicates

HS XXX

- without article transport: 0
- with aligned bottle transfer: 1
- extruder diameter mm