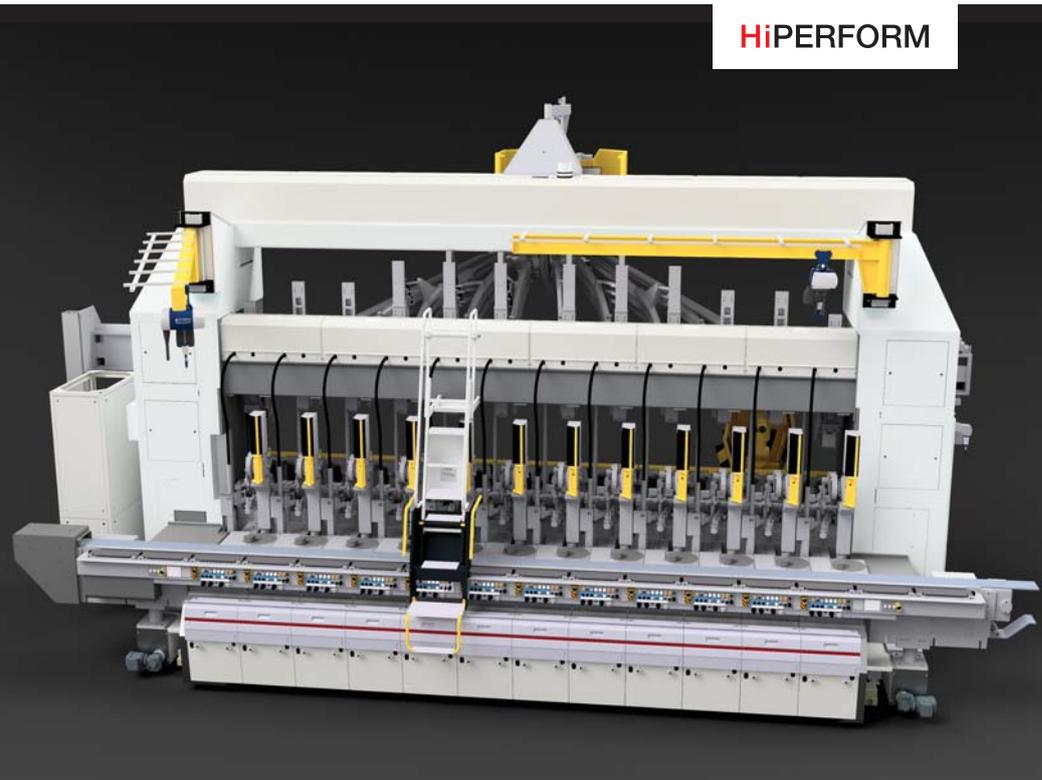


WE ARE GLASS PEOPLE

5" SG / DG SPEEDLINE

HiPERFORM

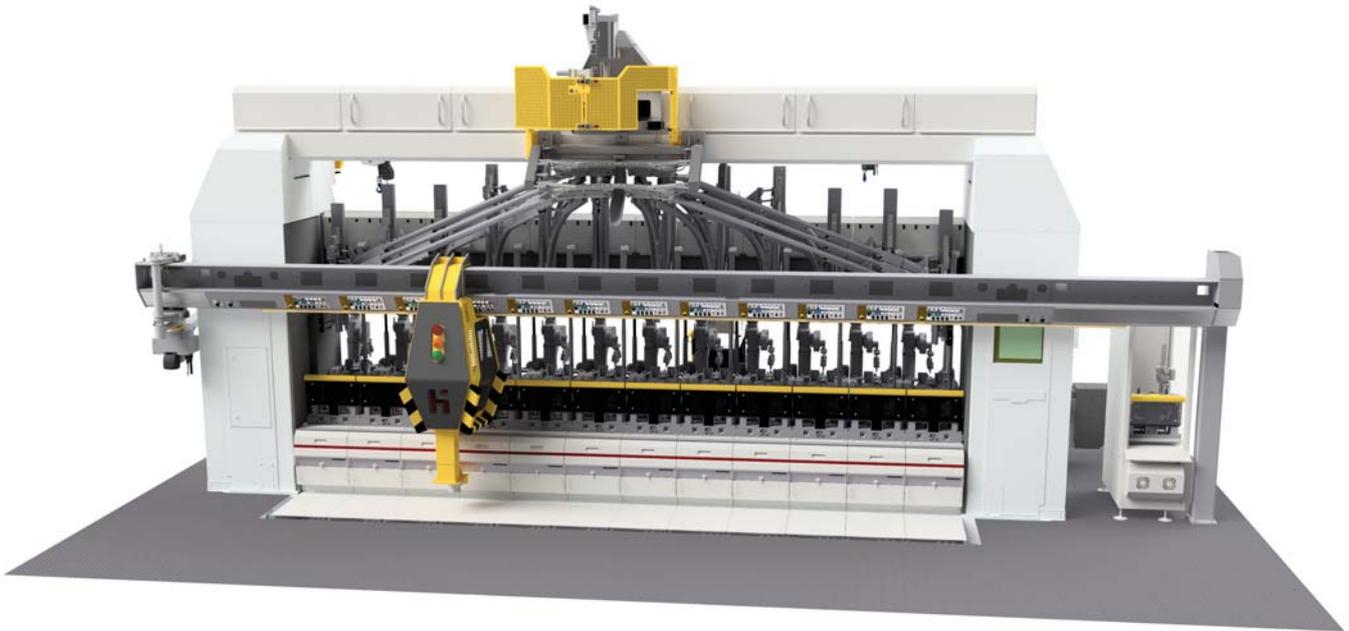


h heye
international

IS-MACHINE MANUFACTURING PROGRAMME

The high-performance 5" Heye SpeedLine IS-Machine is available for up to 24 sections in single or double gob operation.

According to the customers' needs the machine can either be utilised for Blow & Blow, Press & Blow or for NNPB.



OVERVIEW

Advantages

- Available for up to 24 sections
- Single or double gob operation possible
- Applicable for B&B, P&B and NNPB
- High-performance
- High-speed
- Reproducible motion patterns, especially in connection with Heye servo components (e.g. Heye Servo Invert, Servo Takeout, Servo Pushers)
- Lightweight and high-quality products can be produced
- Applicable even for widemouth articles
- Process supervision easily possible by integrating the Heye Process Control

Emissions

- The A-weighted permanent sound pressure level in connection with all components integrated in the machine is >85 dB(A)

Available machine sizes

Single IS-Machines

- 6 sections
- 8 sections
- 10 sections
- 12 sections

Tandem IS-Machines

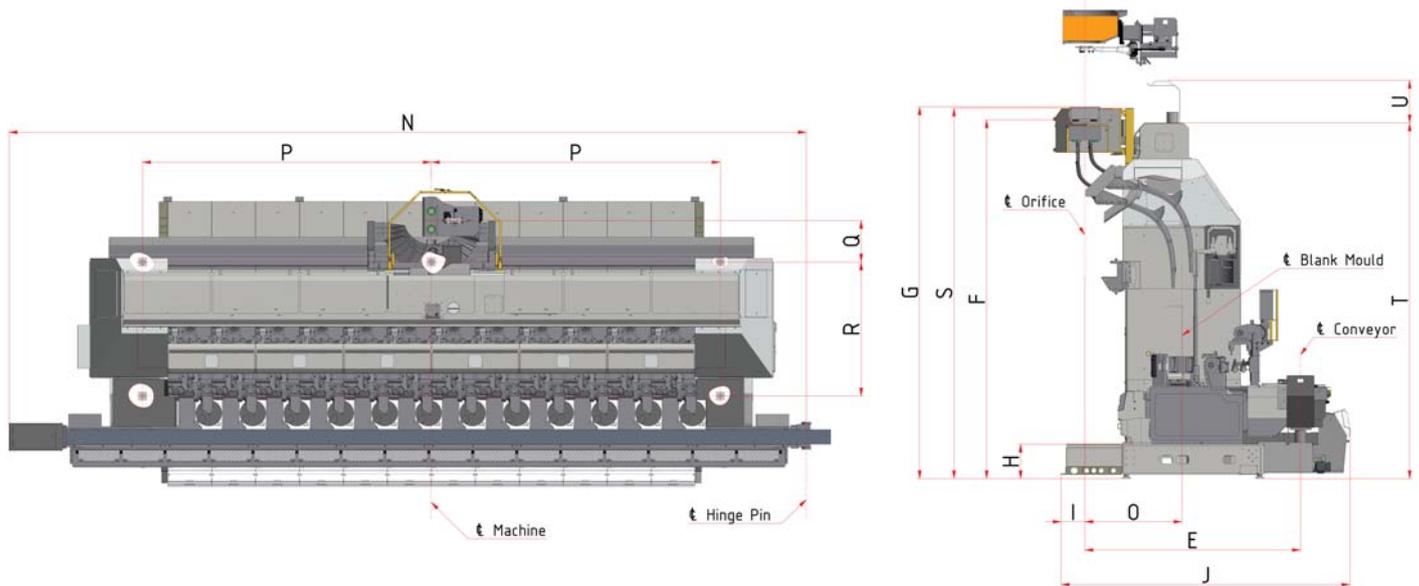
- 12 sections
- 16 sections
- 20 sections
- 24 sections

Colour

- Standard colour RAL 9010 white, glossy (other colours on request)

DIMENSIONS

Heye SpeedLine IS-Machines 5" SG / DG



Depending on the equipment the dimensions can vary:

		IS 6 Sec.	IS 8 Sec.	IS 10 Sec.	IS 12 Sec.
CL offset conveyor	E	2436 mm ±15 mm*1			
Top of funnel	F	4232 mm*2 / 4432 mm			4432 mm
Gob interceptor height	G	4403 mm*2 / 4603 mm			4603 mm
Height of bed	H	425 mm			
Distance bed to orifice	I	309 mm			
Total width	J	3366 mm			
Total length	N	6571 mm	7638 mm	8705 mm	9772 mm
Offset	O	1159 mm			
Machine foot position (6 feet)	P	1905 mm	2438 mm	2972 mm	3505 mm
	Q	489 mm			
	R	1630 mm			
Top edge of protection grid	S	4364 mm*2 / 4564 mm			4564 mm
Top of scoop beam	T	4178 mm*2 / 4378 mm			4378 mm
Opened flap of scoop beam	U	533 mm			

*1 Depending on selected pusher type

*2 Reduced in height

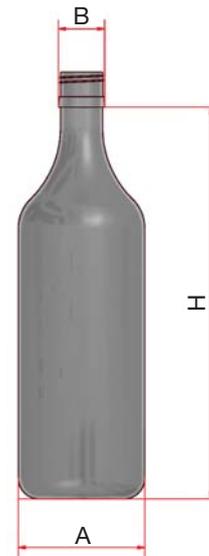
SERVICE REQUIREMENTS

APPLICATION	PRESSURE		CONSUMPTION PER SECTION
	PSI	bar	Nm ³ /h
Low pressure operating air	31.5	2.2	110
High pressure operation air BB	43.5	3.0	130
High pressure operation air NNPB	43.5	3.0	165
Pilot air	50 - 58	3.4 - 4.0	6
Pusher	29.0 - 72.5	2.0 - 5.0	6
Vacuum blow mould	12.3	0.845	66
Cooling air, dead plate and machine conveyor	1.16	0.08	1000
Cooling air:			
Blank side radial stack cooling / HiFlow Blow side radial cooling	1.45	0.1	4500
Blank side radial cooling NNPB Blow side radial cooling	1.45	0.1	4000
Blank side radial stack cooling / HiFlow Blow side axial cooling	2.32	0.16	3100
Blank side radial stack cooling / HiFlow Blow side Vertical Air Stream (VAS)	2.32	0.16	3300
Blank side radial cooling NNPB Blow side axial cooling	2.90	0.2	2000
Blank side radial cooling NNPB Blow side Vertical Air Stream (VAS)	2.61	0.18	2200
Blank side axial cooling Blow side axial cooling	2.90	0.2	2000
Blank side axial cooling Blow side Vertical Air Stream (VAS)	2.61	0.18	2200
Cooling water	36.2 - 72.5	2.5 - 5.0	0.6 - 0.9

- Operating air supply must be clean, dry and oil-free
- Operating air with constant pressure ± 0.02 bar (0.3 psi)
- Pilot air min. 0.5 bar (7.2 psi) in excess of operating air
- Pilot air must be dry, clean and filtered by a microfog oiler at a constant pressure of ± 0.02 bar (0.3 psi)
- Maximum temperature of compressed air 45°C
- Water hardness not more than 6°dH (1°dH acc. to 0.1783 mmol/l HCO³)
- Air of mould cooling must be clean and oil-free
- Maximum temperature of cc-oil 50°C

PRODUCTION LIMIT TABLE

PROCESS	5" SG	5" DG
BLOW & BLOW		
A max. body diameter (stack, w/o vacuum)	178 mm	102 mm
A max. body diameter (Vertical Air Stream [VAS])	156 mm	95 mm
A max. body diameter (Axial Cooling)		90 mm
H max. height (under finish)	343 mm	326 mm
H min. height (under finish)	64 mm	91 mm
B max. finish diameter	48 mm	48 mm
PRESS & BLOW / NNPB		
A max. body diameter (stack, w/o vacuum)	178 mm / 178 mm	102 mm / 102 mm
A max. body diameter (Vertical Air Stream [VAS])	156 mm / 156mm	95 mm / 95 mm
A max. body diameter (Axial Cooling)		90 mm / 90 mm
H max. height (under finish)	267 mm / 305 mm	290 mm / 326 mm
H min. height (under finish)	64 mm / 64 mm	60 mm / 88mm
B max. finish diameter	120 mm / 48 mm	90 mm / 48 mm



Illustrations are non-binding and may include optional equipment. Products are subject to continuous technical modifications.

1018/Web

Heye International GmbH
Lohplatz 1, 31683 Obernkirchen
Germany

T +49 5724 26 26-0
F +49 5724 26 229

www.heye-international.com

