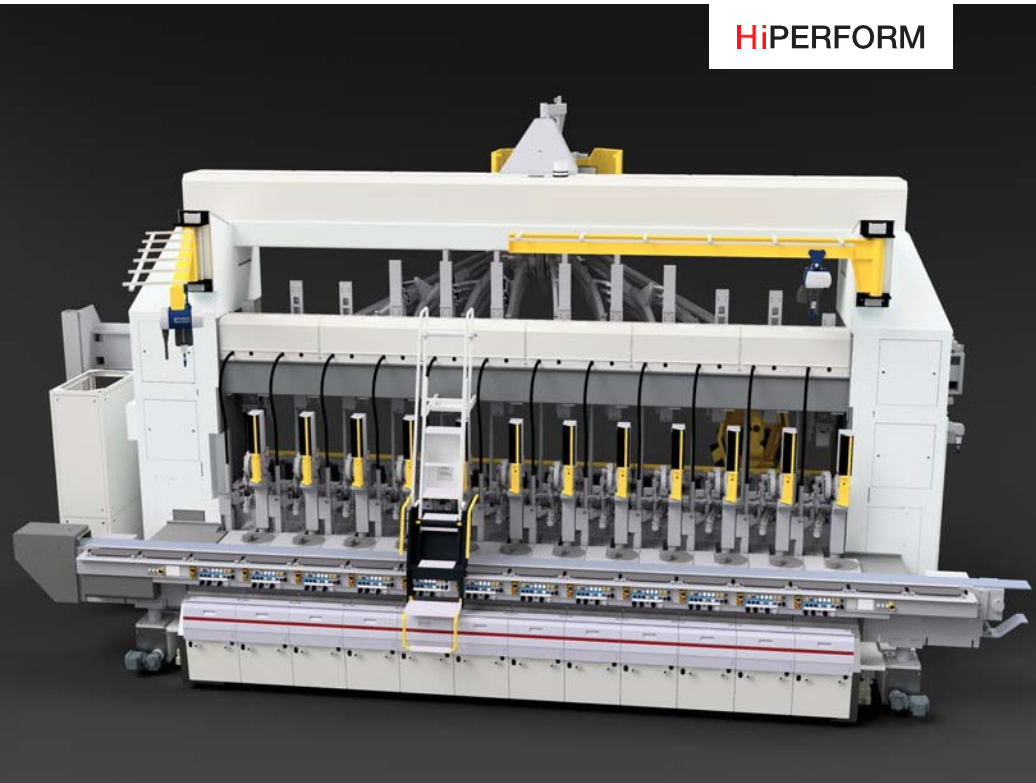


WE ARE GLASS PEOPLE

6 1/4" DG, 4 1/4" TG SPEEDLINE

HiPERFORM

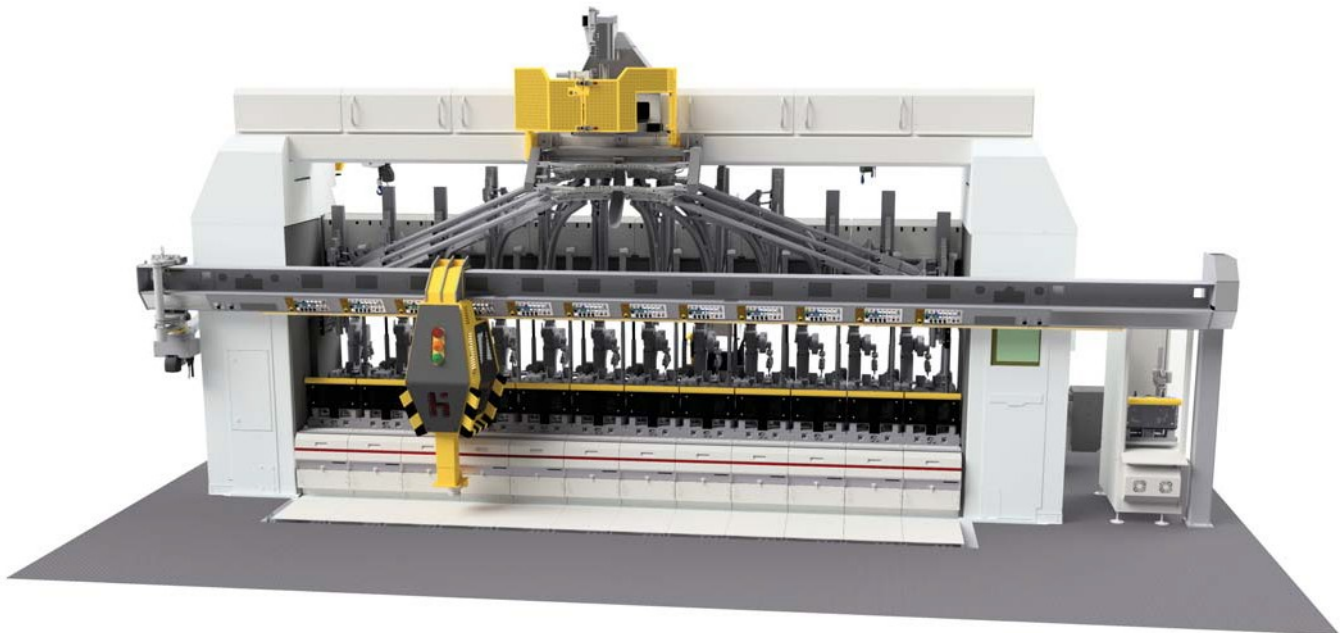


h heye
international

IS-MACHINE MANUFACTURING PROGRAMME

The high-performance 6 ¼" DG and 4 ¼" TG Heye SpeedLine IS-Machines are available for up to 24 sections.

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
- 6 ¼" double and 4 ¼" triple 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

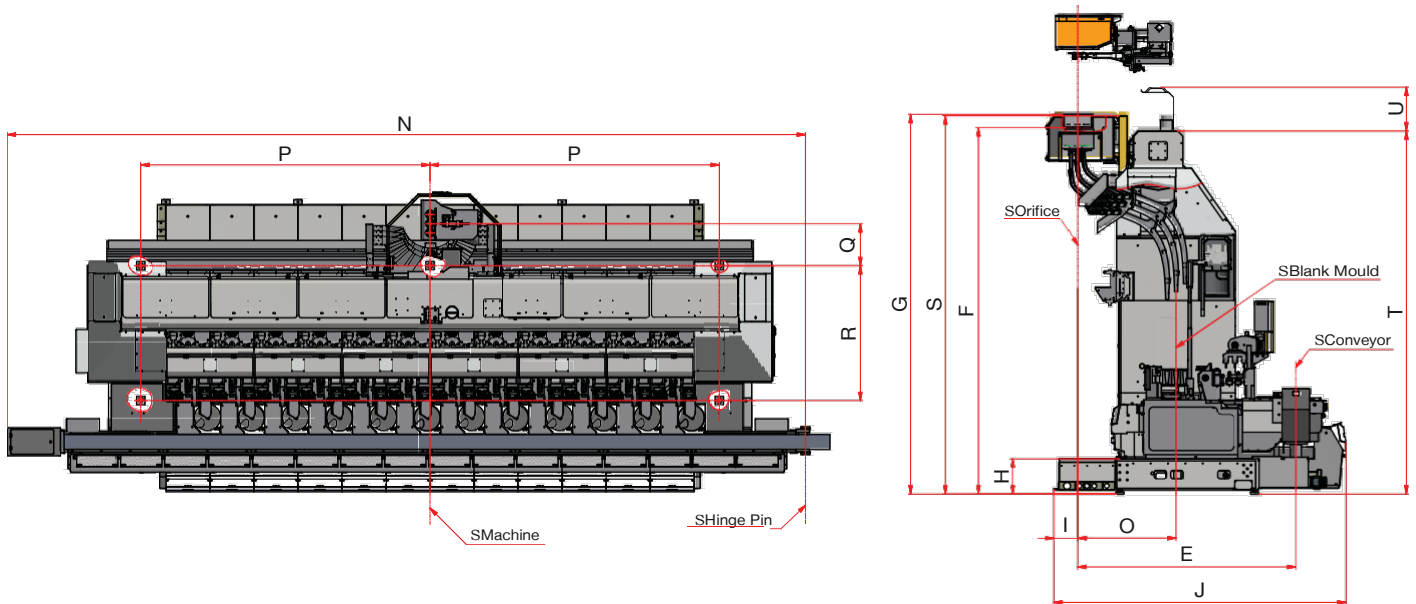
- 12 sections
- 16 sections
- 20 sections
- 24 sections

Colour

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

DIMENSIONS

Heye SpeedLine IS-Machines 6 ¼" DG and 4 ¼" TG



Depending on the equipment the dimensions can vary:

		IS 6 Sec.	IS 8 Sec.	IS 10 Sec.	IS 12 Sec.
CL offset conveyor	E	2604 mm ±15 mm*1			
Top of funnel	F	4238 mm*2 / 4438 mm			4438 mm
Gob interceptor height	G	4411 mm*2 / 4611 mm			4611 mm
Height of bed	H	425 mm			
Distance bed to orifice	I	309 mm			
Total width	J	3535 mm			
Total length	N	6571 mm	7638 mm	8705 mm	9772 mm
Offset	O	1168 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	4371 mm*2 / 4571 mm			4571 mm
Top of scoop beam	T	4186 mm*2 / 4386 mm			4386 mm
Opened flap of scoop beam	U	533 mm			

*1 Depending on selected pusher type

*2 Reduced in height

SERVICE REQUIREMENTS

The values stated refer to a 6 ¼" DG IS-Machine

APPLICATION	PRESSURE		CONSUMPTION PER SECTION
	PSI	bar	Nm³/h
Low pressure operating air	31.5	2.2	110
High pressure operating air BB	43.5	3.0	130
High pressure operating air NNPB	43.5	3.0	165
Pilot air	50 - 58	3.5 - 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	1200
Cooling air:			
Blanksideradial stack cooling / HiFlow Blow side radial cooling	1.45	0.1	6000
Blank side radial cooling NNPB Blow side radial cooling	1.45	0.1	5300
Blanksideradial stack cooling / HiFlow Blow side axial cooling	2.32	0.16	3800
Blanksideradial stack cooling / HiFlow Blow side Vertical Air Stream (VAS)	2.32	0.16	4100
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

PRODUCTION LIMIT TABLE

PROCESS	6 ¼" DG	4 ¼" TG
BLOW & BLOW		
A max. body diameter (Stack, w/o Vacuum)	130 mm	90 mm
A max. body diameter (VAS)	121 mm	76 mm
A max. body diameter (Axial Cooling)	110 mm	
H max. height (under finish)	356 mm	267 mm
H min. height (under finish)	153 mm	80 mm
B max. finish diameter	48 mm	48 mm
PRESS & BLOW / NNPB		
A max. body diameter (Stack, w/o Vacuum)	130 mm / 130 mm	90 mm / 90 mm
A max. body diameter (VAS)	121 mm / 121mm	76 mm / 76 mm
A max. body diameter (Axial Cooling)	110 mm / 110 mm	
H max. height (under finish)	336 mm / 326 mm	230 mm / 268 mm
H min. height (under finish)	102 mm / 106 mm	40 mm / 48 mm
B max. finish diameter	90 mm / 48 mm	70 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.hey-international.com

