PROCESS CONTROL
Equipment for the Plastics Industry

Final Product:
……

Data Form

Blender Total Blend Rate……

Element	Rate kg/h or %	Raw Material	Pellets	Regrind Screen	Bulk Density kg/dm³
A					
B					
C					
D					
E					
F					
G					
H					
I					
J					
K					
L					

Materialhandling

Convey Distance		Elbows 90°
Horizontal	Vertical	

Gravitrol

Extruder	Screw mm	kg/h	Loading from Hopper / Gate
A			
B			
C			
D			
E			
F			
G			
H			
I			
J			
K			
L			

Extruder: Single Screw?.....Twin Screw?.....
Continuous?……Batch?.....
Is Blender to be extruder mounted? Yes …… No ……
What is the head room available? ……m
Mezzanine mounted? Yes…… No……..
Pick-up Box for floor installation?.....

Mono……..CoEx…….Tandem……..
Line Speed Control: yes ….. no ……
Line Speed ……m/min
Encoder for haul off existing? yes……no….
Throughput Monitor in kg/h? yes……no……
Length Throughput……Area Throughput……..

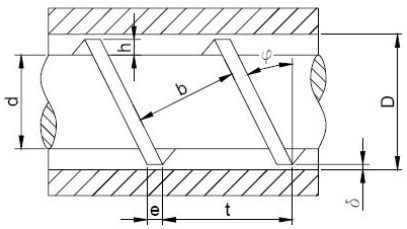
Gravitrol?.....
Hightemperature ……. Notes:……

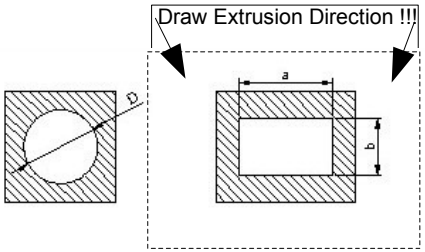
ASR Extruderdata

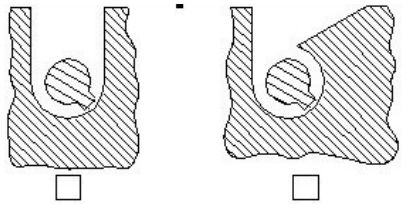
Grooved Feed Section? yes….. no…... If yes, how many grooves? ……...
Groove dimensions: Length:……mm Width:……mm Depth:……mm Grooves: ….straight ….sickle style
Screw pitch at throat……. mm

Screw dimensions	Inner diameter (d)	Flight (h)	Pitch (t)	Flight width (e)
Extruder throat	mm	mm	mm	mm
Discharge end	mm	mm	mm	mm

D = barrel diameter
d = inner diameter of the extruder screw
t = pitch (mostly 0,8 – 1,0 D)
e = flange width (mostly appr. 0,1 D)
f = angle
d = distance barrel / screw
h = screw depth







D: ..... mm
a: ..... mm
b: ..... mm

ASR Process Line Speed……..m/min
Blown film……..Cast Film……Die Width……
Co-Ex? yes.….no….. If yes, how many Extruder …….
Extruder size… …….
Max Line throughput……kg/h Refeed at Extruder……..
Throughput of the Refeed Extruder……..kg/h
Film thickness…….µ Net Film Width……..mm
Width pickup Manifold…… mm Number of Trims .....
Number of Winders…… Waste roll recycling? yes…….no…..