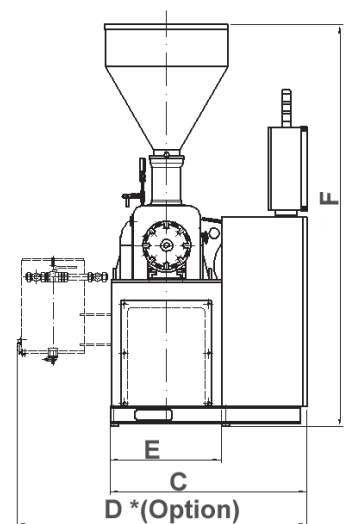
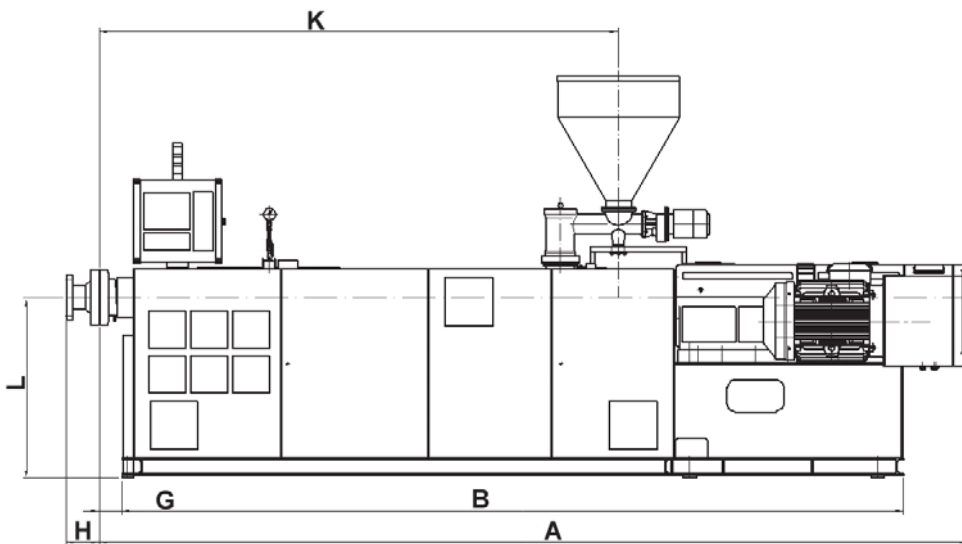




Theysohn Twin-Screw Extruder

Parallel Twin-Screw Extruders for PVC-Profiles

The Theysohn TTS HD series represents the newest technology in parallel twin-screw extrusion. The TTS series meets increased customer demands on processing and flexibility for profile extrusion. Highest melt quality is achieved with proven and reliable up to 28D long processing units. Due to an improved gearbox design a higher safety factor of more than 1.45 has been achieved. Therefore the lifetime of the gearbox is increased and a trouble-free production over a long time is ensured.



[mm]	A	B	C	D	E	F	G	H	K	L
TTS 78P-26	4117	3738	1145	1710	630	2252	55	170	2330	1100
TTS 88P-24	4364	3945	1195	1760	680	2201	62	100	2459	1100
TTS 88P-26	4557	4065	1195	1760	680	2290	135	180	2647	1100
TTS 108P-21	4765	4295	1295	1860	780	2450	76	203	2627	1100
TTS 108P-24	5080	4245	1295	1860	780	2452	441	203	2996	1100
TTS 108P-26	5305	4775	1295	1860	780	2449	136	203	3167	1100
TTS 128P-26	6283	5663	1410	1975	890	2577	135	236	3685	1100

Technical data			TTS	TTS	TTS	TTS	TTS	TTS	TTS
			78P-26	88P-24	88P-26	108P-21	108P-24	108P-26	128P-26
Output rate (dep. on formulation and tool)	Gelification capacity	kg/h	260	300	330	390	480	520	680
	Output guarantee for PVC window profile	kg/h	60-220	70-240	80-260	100-320	120-400	120-440	160-580
	Output guarantee for rigid-PVC profile	kg/h	60-240	70-280	80-300	100-360	120-440	120-480	160-630
Screws	Diameter	mm	78	88	88	108	108	108	128
	L/D total length	L/D	28	26	28	23	26	28	28
	L/D ratio	L/D	26	24	26	21	24	26	26
	Screw speed max.	rpm	28.8	25.5	25.5	17	20.8	20.8	17.6
	Total torque	Nm	7390	10600	10600	20000	20000	20000	32000
	Heating/cooling unit by oil, heating/cooling cap.	kW	10/15	10/15	10/15	10/15	10/15	10/15	15/20
Drive	Main drive (AC)	kW	24	30	30	38	47	47	63
	Drive speed max.	rpm	1129	1130	1130	995	1217	1217	1185
	Melt pressure (short time/max.)	bar	400/600	400/600	400/600	400/600	400/600	400/600	400/600
Gearbox	Application factor		1.45	1.45	1.45	1.45	1.45	1.45	1.55
Barrel	Installed heating capacity	kW	28	33.8	33.8	38.8	50.2	50.2	71
	No. of heating/cooling zones		5/3	5/3	5/3	5/3	5/3	5/3	5/3
	Vacuum pump	kW	1.5	1.5	1.5	1.5	1.5	1.5	3.0
Adapter	Heating zones (no./installed cap.)	kW	1 x 0.9	1 x 1.0	1 x 1.0	1 x 1.2	1 x 1.2	1 x 1.2	1 x 1.5
Tool zone (option)	Max. tool zones 230V 1-phase (no./installed cap.)	kW	18 x 3.5	18 x 3.5	18 x 3.5	18 x 3.5	18 x 3.5	18 x 3.5	18 x 3.5
	Max. tool zones 400V 3-phase (no./installed cap.)	kW	16 x 10.5	16 x 10.5	16 x 10.5	18 x 10.5	18 x 10.5	18 x 10.5	18 x 10.5
Feeding (option)	Starve feeder (AC)	kW	1.1	1.1	1.1	1.1	1.1	1.1	1.1
General data	Total connection (stand./max. tooling zones), max.	kVA	73/190	83/200	83/200	98/245	116/263	116/263	148/295
	Water consumption (at 10°C water temperature)	m³/h	1.2	1.4	1.4	1.6	1.6	1.6	1.9
	Center Line	mm	1100	1100	1100	1100	1100	1100	1100
	Weight (incl. control cabinet) approx.	kg	4700	5200	5300	5800	6700	6800	9900

Standard

- Main drive maintenance-free AC-motor
- Hopper with shut-off valve (Ebro-valve)
- TEC-2TS control with 15" color TFT display with touch screen
- Windows NT operating system
- 320 MB flash disk
- Production log of last week
- Saving and calling of formulas and process parameters
- Plain language alarm message
- Alarm history of the past month
- On-line shifting between languages
- Production logs (stored or printed)
- Voltage loss protection (up to 3 sec)
- Back pressure monitoring in gearbox with emergency cut-off
- Synchronization of up to 4 additional analog drives
- Self-tuning temperature controllers
- Timer for barrel and tool heating zones
- Deep nitrided screws, molybdenum coating of screw flights, chromium-plated screw flanks in venting and metering zone
- Passive screw temperature control (water-filled screw)
- Barrel with 5 heating zones, 2 zones air-cooled and metering zone oil-cooled with speed controlled oil-pump, elliptical barrel design in metering zone
- Barrel heating with ceramic heater bands
- Barrel covers
- Vacuum pump and vacuum canister with filter and bypass
- Adapter stainless steel incl. heating zone
- Bore holes incl. plugs for melt pressure and temperature sensors in adapter
- Colour: blue RAL 5015/doors grey RAL 7036
- Voltage: 3 x 400V + 0, 50 Hz
- Electric CE-conform

Options

- 6/10/14/16/18 tool zones 230V 1-phase
- 6/10/14/16/18 tool zones 400V 3-phase
- Starve feeder with maintenance-free AC-motor and full screw
- Heat current control for tool zones
- Heat current control for barrel heating zones
- Melt temperature monitoring and data storage
- Melt pressure monitoring and data storage
- Active screw temperature control by oil incl. oil blocks
- Barrel with 5 heating and 3 air-cooled zones, elliptical barrel design in metering zone
- Customized adapter design
- Gravimetric feeding unit integrated in TEC-2TS control
- Saw cut control integrated in TEC-2TS control
- Modem for remote access (analog or ISDN)
- Interface cards for network links (Ethernet card)
- Acoustic alarm (horn)
- Air conditioning for control cabinet
- Air-water heatexchanger for cooling of control cabinet
- Machine subframe for customized extrusion center height
- Machine subframe on wheels with rails (+ 50 mm)
- Separate free standing control cabinet with cables
- TEC control panel on swivel arm
- Hopper level indicator
- Stainless steel hopper with lid
- Hopper loader systems
- Side-mounted vacuum canister
- Second side-mounted vacuum canister
- Additional 2 single dosing feeders for pigments and additives
- K-Tron twin-screw side dosing feeders
- Screws deep nitrided, without molybdenum-coating, without chromium
- X-800 barrel together with tungsten-carbide coated screws
- Special voltage and electrical standards
- Customized colour

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