

BASIC EQUIPMENTS INTO PLASTIC DEPARTMENT

Model Type	Ekinmakina EKIN 190	Ekinmakina EKIN 240	Battenfeld BA 350/125	TM Bronze TM 250/80	Formoplast 395/165
Year of producing	2007	2007	1987	1989	1982
Quantity	2	1	1	2	1

Clamping Unit

Clamping Force	kN	1900	2400	350	800	1650
Mould Opening Stroke	mm	400	540	475	320	400
Minimum Mould Height	mm	120	140	150	140	165
Maximum Mould Height	mm	500	630	325	360	400
Distance Between Tie-Bars	mm x mm	410 x 410	510 x 510	304 x 254	360 x 360	450 x 450
Front base hole	Ø /mm/	125	130	110	125	175
Back base hole	Ø /mm/	90	90	110	125	175

Injection Unit

Shot Weight PS	g	290	570	77	250	286
Specific Injection Pressure	bar	2200	1978	1492	1800	1788
Core -Pull devices		2	2	1	1	-
Hot runner System-Managing	zone	1	2	External	External	External
Vertical Hoper Dryer		Yes	Yes	Motan; Shini		
Auto Louder		Yes	Yes	Motan; Shini		
Mould Temperature Device	to 100°C	Yes	Yes	Shini		

Type of Materials: PP, PE, ABS, PS, PC, PA6, PA6.6, PA+GF/15,20,30/, PBT, TPU,TPV,SAN

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Internal Quality System:

Quality Manager: Giuldjhan Ziulabein
Checks of the Parts: According GIL /AQL Standart
Email: sovisplast-contact@abv.bg

<i>Mould Approval Protocol Signed from the customer:</i>	Yes
<i>Part Approval Protocol Signed from the customer:</i>	Yes
<i>Samples Signed from the customer:</i>	Yes
<i>Drawings of the parts:</i>	Yes
<i>Tools /Moulds/ Pasport:</i>	Yes
<i>Process Data Card</i>	Yes
<i>Quality Aproval Certificate</i>	Yes
<i>Maintance Ruls of the Machines</i>	Yes
<i>Maintance Ruls of the Moulds</i>	Yes
<i>Rejects Protocol</i>	Yes

Measuring Devices	Calliper Gauge	Micrometers	Canon Drills	Microscope	Electronic Balance
Purpose of Using:	Standart Profile	Standart Profile	holes	non-standart profile, and angles	measuring wheight
Precision (+/- tolerance)	0.1mm.	0.01mm.	0.01mm.	0.01mm.	0.02g.