Technology Showcase

Corma Unified Mold Block System

Overview

As a leading innovator in the industry, Corma is driven to develop technologies designed to provide clients with key advantages and benefits. Instead of requiring specific mold blocks for each corrugator model, Corma's Unified Mold Block System maximizes compatibility throughout the entire range of Corma corrugators. This means that the largest 6030 corrugator can use mold blocks from the much smaller 1530 corrugator.

The concept was developed to provide pipe manufacturers with a high level of flexibility for expansion opportunities. For example, a manufacturer can make an initial investment in a 4030 corrugator and alternative production of two pipe sizes:

1. 200mm diameter pipes with 4" wide mold blocks and 8" adaptors (4030 uses 8" wide blocks)
2. 1200mm diameter pipes with 8" wide mold blocks

In the future when they want to expand their capacity, they would be able to invest in a second smaller corrugator while utilizing the existing set of 4" wide mold blocks, eliminating the additional need to purchase redundant mold blocks for the new smaller machine:

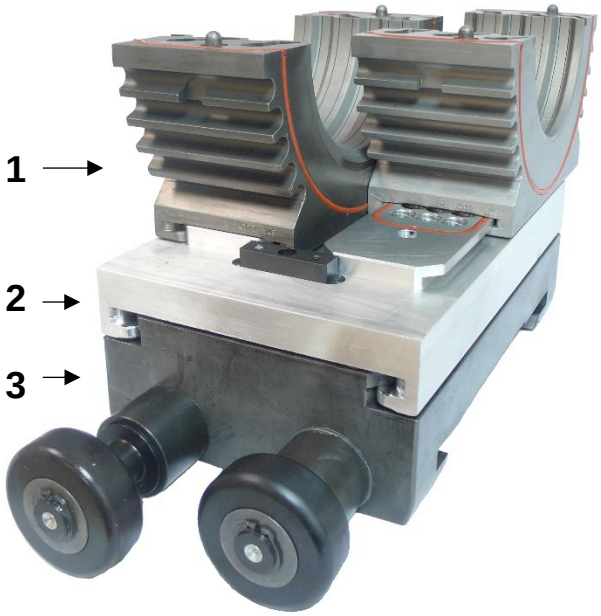
1. 4030 corrugator line with existing 8" wide mold blocks dedicated to produce 1200mm pipes
2. 1530 corrugator line with existing 4" wide mold blocks dedicated to produce 200mm pipes

Unified Mold Block System

Corma's lineup of corrugators can be divided into 4 groups, each distinguished by the width of the mold blocks it uses:

- 1" (Model 053)
- 2" (Models 130-430)
- 4" (Models 630-1530)
- 8" (Models 2030-6030)

Mold blocks within each group are compatible with corrugators in the same group. For example, mold blocks for the 630 can be used on the 1530 since they are both 4" wide.



Mold Block Adaptor Shoes

In addition, Corma has engineered mold block carrier adaptors that will enable larger corrugators to use the narrower mold blocks from smaller machines. For example, the 6030 can utilize mold blocks from the much smaller 1530 by mounting two 4" wide mold blocks onto an 8" wide carrier adaptors.

The system has three main components:

1. Mold blocks
2. Carrier adaptor
3. Mold block carrier

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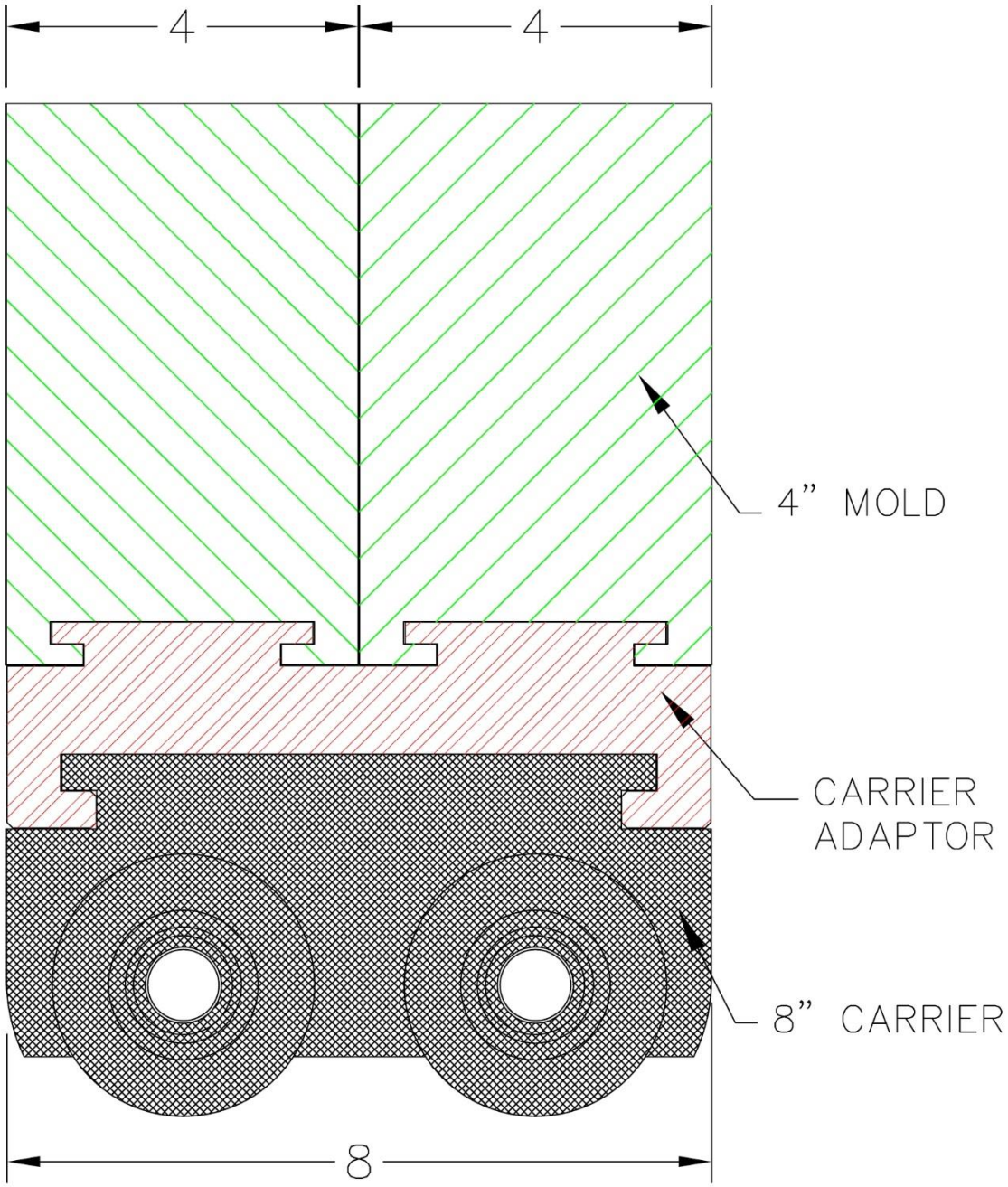
Mold Block Adaptor Diagram

The diagram below shows two 4” wide mold blocks mounted on an 8” wide carrier adaptor for use in the 2030, 3030, 4030 and 6030 series corrugators.



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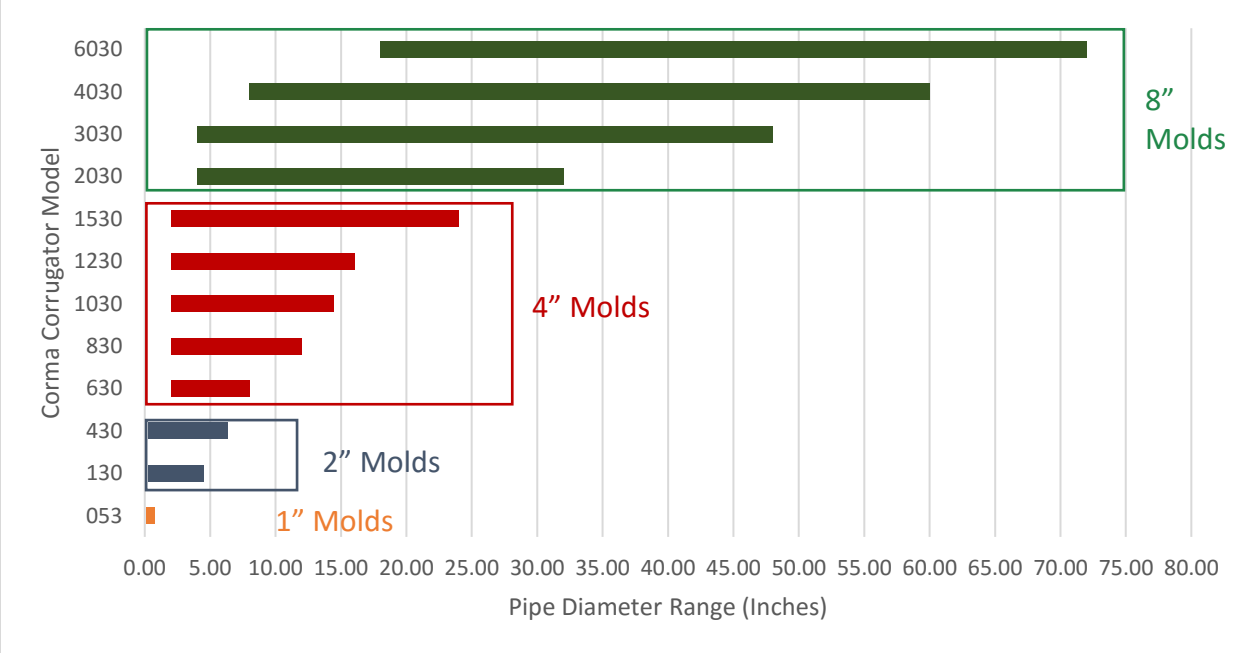
Compatibility Chart

	Corrugator Model				
Mold Block Width		053	130 430	630 830 1030 1230 1530	2030 3030 4030 6030
	1”	✓	✓*	✗	✗
	2”	✗	✓	✓*	✗
	4”	✗	✗	✓	✓*
	8”	✗	✗	✗	✓

**Compatible Utilizing the Corma Mold Block Carrier Adaptor*

Corma Mold Block Groups



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Technical Data

Corrugator Model Number* Vacuum Forming or Blow Molding	Pipe Range				Maximum Line Speed**		Maximum Output**	
	mm		inches					
	Min. I.D.	Max. O.D.	Min. I.D.	Max. O.D.	M/min	ft/min	Kg/hr	lbs/hr
053	3	20	0.12	0.8	50	165	30	66
130	6	110	0.25	4.5	55	180	360	790
430	6	160	0.25	6.3	35	115	450	990
630***	50	200	2.0	8.0	35	115	1040	2300
830***	50	300	2.0	12.0	35	115	1040	2300
1030	50	365	2.0	14.4	30	100	750	1650
1230	50	400	2.0	16.0	30	100	800	1760
1530	50	700	2.0	27.5	23	75	1000	2200
2030	100	800	4.0	32.0	10	33	1300	2860
3030	100	1200	4.0	48.0	6	20	1300	2860
4030	200	1500	8.0	60.0	5	16.5	1400	3100
6030	450	1800	18.0	72.0	3	10	1500	3300
P 30/60	750	1800	30.0	72.0	1	3.3	1300	2860
P 30/120	750	3000	30.0	120.0	1	3.3	1500	3300
Vertical Corrugator Model Number								
V 053	1	20	0.040	0.8	50	165	30	66
V 130	4	100	0.160	4.0	50	165	215	475
V 630	20	200	0.8	8.0	30	100	600	1320
Rib-Pipe Model Number								
R 2030	100	700	4.0	28.0	10	33	1100	2420
R 3030	100	1000	4.0	40.0	10	33	1300	2860

* Mold blocks are interchangeable within family groupings. Also, molds from smaller corrugators can be used on larger corrugators, using Corma's carrier adaptors.
**Line speeds and outputs are theoretical and depend on: pipe diameter; type of plastic; machine model; cooling options; mold track length; temperature and quantity of cooling water; profile configuration; extruder capacity, etc.
***630-12 and 830-12 line speed and output based on high speed corrugator configuration

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