



Mold Block Quick Return System

TECHNOLOGY
SHOWCASE

An outstanding technical feature available on Corma corrugators is the patented Mold Block Quick Return (MQR) System. This feature increases production speed by extending the molding track with mold blocks from the return track. The quick return feature also allows the corrugator to operate with just a partially filled mold track.

The production speed of the corrugator depends on two key factors:

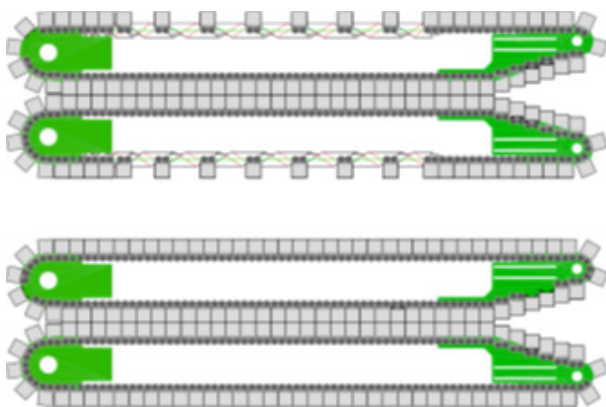
- 1) Length of time the mold blocks are in contact with the formed plastic
- 2) Heat exchange ability of the mold blocks

With Corma's MQR System the mold track can be extended by the number of mold blocks saved in the return track and the production speed increases proportionately.

Corma's self-driven MQR System automatically picks up the mold blocks at production speed, accelerates them along the return track, and slows them down again to production speed before entering the molding track. The end result is that mold blocks spend less time in the return track and more time in the molding track.

The MQR separates the mold blocks in the return track exposing all surfaces to be air cooled. Working in conjunction with other patented Corma features such as the Optimized Mold Block Design, SupercoolingTM and the Cooling Enclosure, highly effective cooling is achieved resulting in increased production speeds.

With these new features, Corma corrugators are even more productive. Customers who do not require high production speeds can benefit from the MQR System, since it can allow them to reduce their investments in mold blocks. With Corma's future generation 40 series corrugator, even greater mold block savings and higher outputs can be achieved due to a newly designed MQR system



This 1530-7.4 MQR corrugator is equipped with the Mold Block Quick Return System. It only needs 60 mold

In comparison, this 1530-7.4 corrugator is not equipped with MQR and needs 74 mold blocks to form a molding

Technical Data

Corrugator Model Number* Vacuum Forming or Blow Molding	Pipe Range				Maximum Line Speed**		Maximum Output**	
	mm		inches		M/min	ft/min	Kg/hr	lbs/hr
	Min.I.D.	Max. O.D.	Min.I.D.	Max. O.D.				
054	3	40	0.12	1.6	50	165	40	88
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
840	50	300	2.0	12.0	25	80	840	1850
1030	50	365	2.0	14.4	30	100	750	1650
1230***	50	500	2.0	20.0	27	90	910	2000
1530***	50	700	2.0	27.5	26	85	1000	2200
2430	100	800	4.0	32.0	10	33	1300	2860
3630	100	1200	4.0	48.0	6	20	1300	2860
4830	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	0.04	0.8	50	165	30	66
V 130	4	110	0.16	4.5	50	165	215	475
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 (shaded) groupings. Also, mold blocks from smaller corrugators can be used on larger corrugators, using Corma's Unified Mold Block System and Mold Block Adapter Shoes.

** 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, 830-12, 1230-12 and 1530-12 line speed and output based on high speed corrugator configuration.

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