Corma® | Innovation Over Imitation™

Corma's Compact Die

TECHNOLOGY SHOWCASE

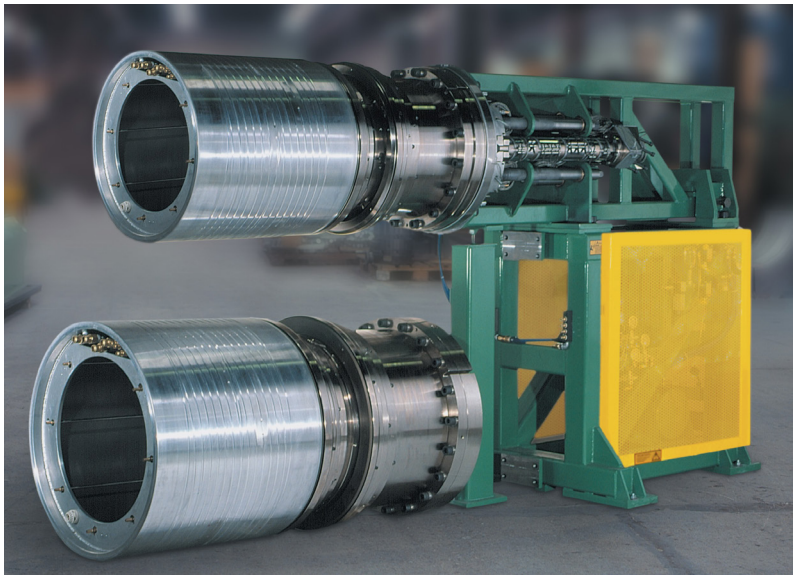
Overview

Corma has developed a huge advancement in the technology for the production of large diameter PE and PP pipes.

Our motivation was to give our customers a die which was easy to operate and made changeovers quick and safe,

The Corma Compact Die boasts low back pressure; allowing for increased outputs. The Compact Die can be adjusted during production.

This technology has been so popular with our customers that they have asked us to incorporate its design for their medium pipe sizes, starting at 12" (300mm) I.D..



Key Features

- Simplified changeovers; - the tooling connects directly to an input die plate that's fixed on the die stand.
- Reduced material wastage; - there is little material wastage during changes and start up.
- Ease of start up; - as the tooling is removed as a complete set, the production settings from the previous run is held, reducing rework and improving start-up times.
- Heat up times; - the tooling is 50% lighter, there is less material to heat, reducing dwell times and making the tooling more responsive to processing.
- Access for change; - as the tooling does not project into the die body, the space required to separate the tooling from the die plate is minimal. The compact design of the die tooling makes it easy to handle and install.
- Improved centring and wall thickness control; - having 6 point flow control distribution on the die plate allows for material flow and pressures to be balanced, aiding processing on large diameters.

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Head Office
10 McCleary Court
Concord (Toronto)
Ontario, Canada L4K 2Z3

T 905 669 9397
F 905 738 4744
E info@corma.com

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
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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T 905 669 9397
F 905 738 4744
E info@corma.com

International Sales and Service Offices

Corma Deutschland GmbH
Oststraße 54 40211
Düsseldorf
Germany
T 49 211 434688
F 49 211 9350150

Corma India
1123, Regus Grandeur,
Earth Arise Building,
S.G Road, Makarba
Ahmedabad - 380015
Gujarat, India
T 91 79 6134 4542
E bpawar@corma.com

Corma Latin America
Avenida los Eucaliptos 3-C,
Brisas de Las Mercedes
Zaragoza, La Libertad
El Salvador, CA
T 503 2566 2297
F 503 7797 5667
E fsolano@corma.com

Corma Shanghai Co., Ltd.
759 Qiangye Road
Sheshan Industrial Zone
Songjiang District, Shanghai
201602, P.R. China
T 86 21 5779 4175 & 6
F 86 21 5779 4159
E ryang@corma.com