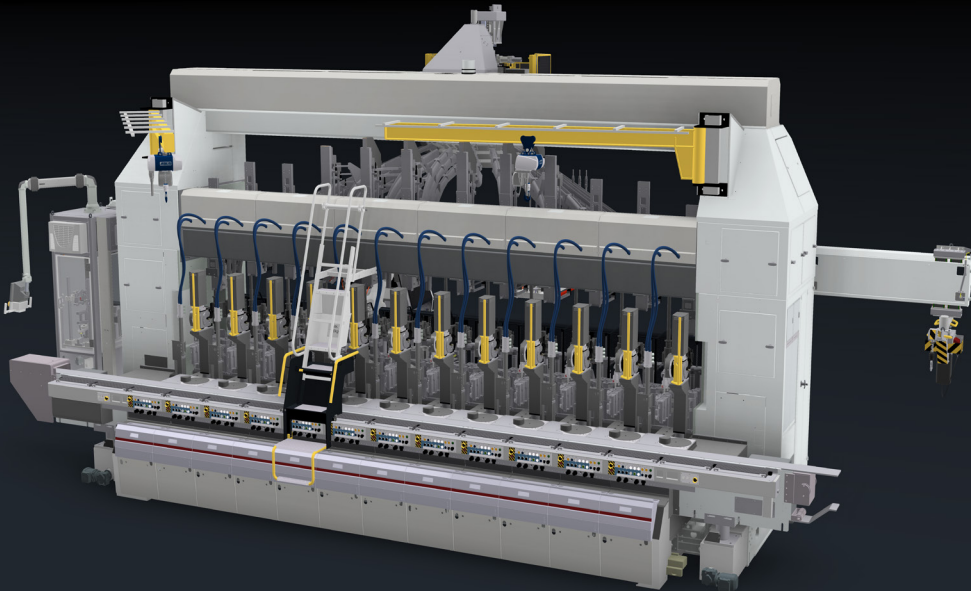


WE ARE GLASS PEOPLE

# HEYE SPEEDLINE

4 ¼" SG/DG, 5" SG/DG, 85 mm TG  
5 ½" DG, 6 ¼" DG, 4 ¼" TG

HiPERFORM

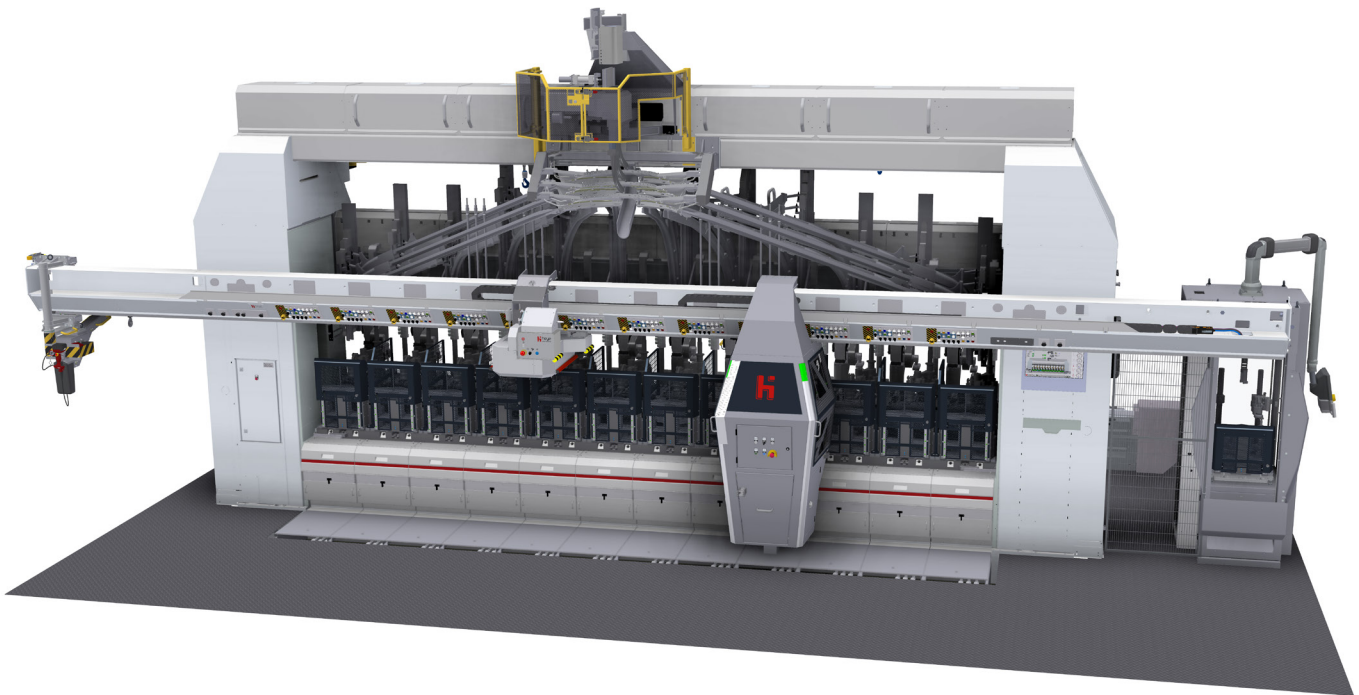


**h** heye  
international

# IS-MACHINE MANUFACTURING PROGRAMME

The high-performance Heye SpeedLine IS-Machines are available for up to 24 sections.

According to the customers' needs the machine can either be utilised for Blow & Blow, Press & Blow or for NNPB.



## OVERVIEW

### Advantages

- Available for up to 24 sections
- Single, double and triple gob operation possible
- Applicable for B&B, P&B and NNPB
- High-performance
- High-speed
- Reproducible motion patterns, especially in connection with Heye servo components (e.g. Heye Servo Invert, Servo Takeout, Servo Pushers)
- Lightweight and high-quality products can be produced
- Applicable even for widemouth articles
- Process supervision easily possible by integrating the Heye Process Control

### Emissions

- The A-weighted permanent sound pressure level in connection with all components integrated in the machine is >85 dB(A)

### Available machine sizes

#### Single IS-Machines

- 6 sections
- 8 sections
- 10 sections
- 12 sections

#### Tandem IS-Machines

- 12 sections
- 16 sections
- 20 sections
- 24 sections

### Colour

- Standard colour RAL 9010 white, glossy (other colours on request)

# PRODUCTION LIMIT TABLE

IS-Forming Machines

Values in mm

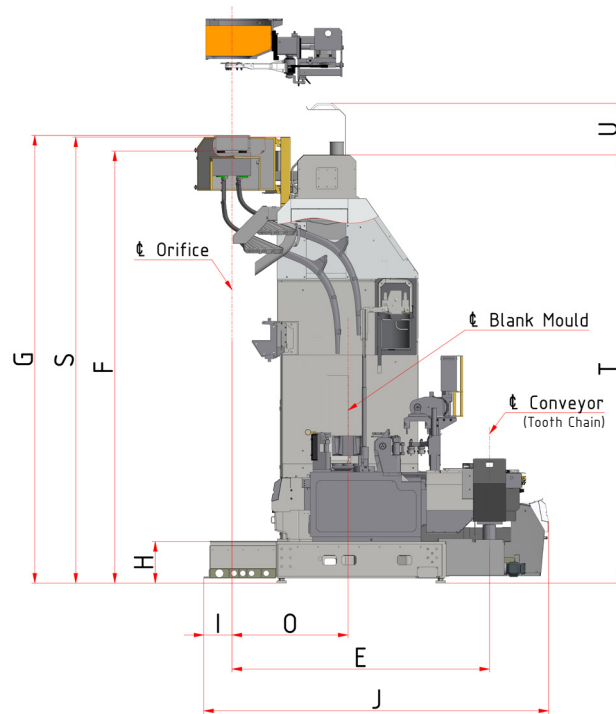
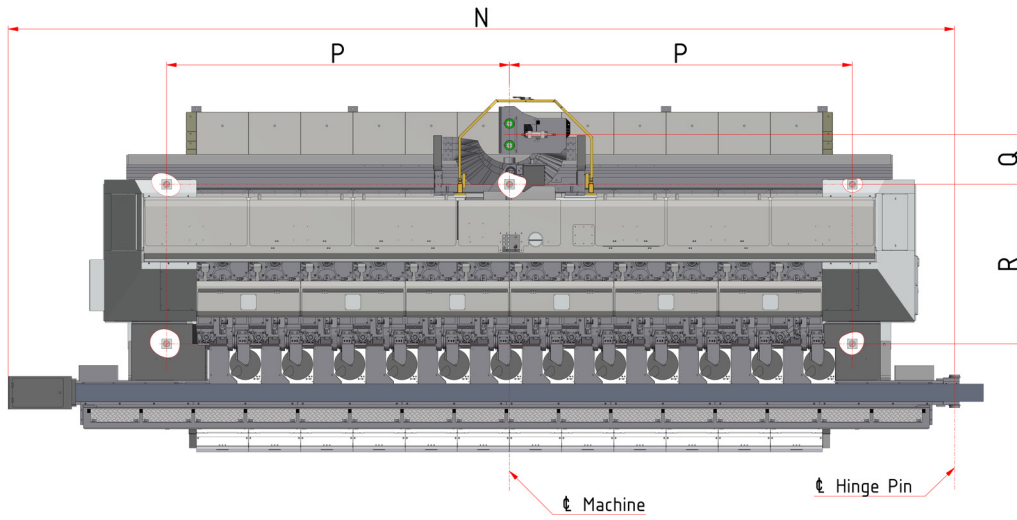
PROCESS	4 ¼" SG	4 ¼" DG	5" SG	5" DG	85 mm TG	5 ½" DG
<b>BLOW &amp; BLOW</b>						
A max. body diameter (stack, w/o vacuum)	178	90	178	102	62	111
A max. body diameter (VAS)	156	76	156	95	60	102
A max. body diameter (Axial Cooling)	-	-	-	90	60	96
H max. height (under finish)	360	301	343	326	245	343
H min. height (under finish)	61	58	64	91	55	115
B max. finish diameter	48	48	48	48	30	48
<b>PRESS &amp; BLOW / NNPB</b>						
A max. body diameter (stack, w/o vacuum)	178 / 178	90 / 90	178 / 178	102 / 102	62 / 62	111 / 111
A max. body diameter (VAS)	156 / 156	76 / 76	156 / 156	95 / 95	60 / 60	102 / 102
A max. body diameter (Axial Cooling)	-	-	-	90 / 90	60 / 60	96 / 96
H max. height (under finish)	284 / 284	282 / 282	267 / 305	290 / 326	213	300 / 326
H min. height (under finish)	74 / 74	40 / 40	64 / 64	60 / 88	50 / 50	82 / 106
B max. finish diameter	120 / 48	83 / 48	120 / 48	90 / 48	55 / 38	90 / 48

PROCESS	6 ¼" DG	4 ¼" TG	
		standard application	small ware application
<b>BLOW &amp; BLOW</b>			
A max. body diameter (stack, w/o vacuum)	130	90	73
A max. body diameter (VAS)	121	76	70
A max. body diameter (Axial Cooling)	110	76	-
H max. height (under finish)	356	267	105
H min. height (under finish)	153	80	25
B max. finish diameter	48	48	30
<b>PRESS &amp; BLOW / NNPB</b>			
A max. body diameter (stack, w/o vacuum)	130 / 130	90 / 90	73 / 73
A max. body diameter (VAS)	121 / 121	76 / 76	70 / 70
A max. body diameter (Axial Cooling)	110 / 110	76 / 76	-
H max. height (under finish)	336 / 326	230 / 268	101 / 101
H min. height (under finish)	43 / 106	40 / 48	21 / 21
B max. finish diameter	105 / 48	70 / 48	34 / 28



# DIMENSIONS

For Heye SpeedLine IS-Machines



Depending on the equipment the dimensions can vary.

Values in mm

		4 ¼" SG/DG, 5" SG/DG, 85 mm TG			
		6 Sec.	8 Sec.	10 Sec.	12 Sec.
CL offset conveyor	<b>E</b>	5" SG/DG, 85 mm TG: $2436 + x^{*1}$ 4 ¼" SG/DG: $2417 + x^{*1}$			
Top of funnel	<b>F</b>	4232 <sup>*2</sup> / 4432			4432
Gob interceptor height	<b>G</b>	4403 <sup>*2</sup> / 4603			4603
Height of bed	<b>H</b>	425			
Distance bed to orifice	<b>I</b>	309			
Total width	<b>J</b>	3366			
Total length	<b>N</b>	6571	7638	8705	9772
Offset	<b>O</b>	5" SG/DG, 85 mm TG: 1159 4 ¼" SG/DG: 1168			
Machine foot position (6 feet)	<b>P</b>	1905	2438	2972	3505
	<b>Q</b>	489			
	<b>R</b>	1630			
Top edge of protection grid	<b>S</b>	4364 <sup>*2</sup> / 4564			4564
Top of scoop beam	<b>T</b>	4178 <sup>*2</sup> / 4378			4378
Opened flap of scoop beam	<b>U</b>	533			

		5 ½" DG			
		6 Sec.	8 Sec.	10 Sec.	12 Sec.
		$2566 + x^{*1}$			
		4238 <sup>*2</sup> / 4438			4438
		4411 <sup>*2</sup> / 4611			4611
		425			
		328			
		3516			
		6571	7638	8705	9772
		1169			
		1905	2438	2972	3505
		470			
		1630			
		4371 <sup>*2</sup> / 4571			4571
		4186 <sup>*2</sup> / 4386			4386
		533			

		6 ¼" DG, 4 ¼" TG			
		6 Sec.	8 Sec.	10 Sec.	12 Sec.
CL offset conveyor	<b>E</b>	$2604 + x^{*1}$			
Top of funnel	<b>F</b>	4238 <sup>*2</sup> / 4438			4438
Gob interceptor height	<b>G</b>	4411 <sup>*2</sup> / 4611			4611
Height of bed	<b>H</b>	425			
Distance bed to orifice	<b>I</b>	309			
Total width	<b>J</b>	3535			
Total length	<b>N</b>	6571	7638	8705	9772
Offset	<b>O</b>	1169			
Machine foot position (6 feet)	<b>P</b>	1905	2438	2972	3505
	<b>Q</b>	489			
	<b>R</b>	1630			
Top edge of protection grid	<b>S</b>	4371 <sup>*2</sup> / 4571			4571
Top of scoop beam	<b>T</b>	4186 <sup>*2</sup> / 4386			4386
Opened flap of scoop beam	<b>U</b>	533			

*1 Pusher Offset x	
Pusher Type	Offset in mm
2157	x = 0
2154	x = 15
2158	x = 30

\*2 Reduced in height

# SERVICE REQUIREMENTS

APPLICATION	4 ¼" SG/DG, 5" SG/DG, 85 mm TG		
	Pressure		Consumption per section
	PSI	bar	Nm³/h
Low pressure operating air	31.5	2.2	110
High pressure operating air BB	43.5	3.0	130
High pressure operating air NNPB	43.5	3.0	165
Pilot air	50 - 58	3.4 - 4.0	6
Pusher	29.0 - 72.5	2.0 - 5.0	6
Vacuum blow mould	12.3	0.845	66
Cooling air, dead plate and machine conveyor	1.16	0.08	1000

APPLICATION	5 ½" DG, 6 ¼" DG, 4 ¼" TG		
	Pressure		Consumption per section
	PSI	bar	Nm³/h
Low pressure operating air	31.5	2.2	110
High pressure operating air BB	43.5	3.0	130
High pressure operating air NNPB	43.5	3.0	165
Pilot air	50 - 58	3.5 - 4.0	6
Pusher	29.0 - 72.5	2.0 - 5.0	6
Vacuum blow mould	12.3	0.845	66
Cooling air, dead plate and machine conveyor	1.16	0.08	1200

## Cooling air:

Blank side radial stack cooling / HiFlow Blow side radial cooling	1.45	0.1	4500
Blank side radial cooling NNPB Blow side radial cooling	1.45	0.1	4000
Blank side radial stack cooling / HiFlow Blow side axial cooling	2.32	0.16	3100
Blank side radial stack cooling / HiFlow Blow side Vertical Air Stream (VAS)	2.32	0.16	3300
Blank side radial cooling NNPB Blow side axial cooling	2.90	0.2	2000
Blank side radial cooling NNPB Blow side Vertical Air Stream (VAS)	2.61	0.18	2200
Blank side axial cooling Blow side axial cooling	2.90	0.2	2000
Blank side axial cooling Blow side Vertical Air Stream (VAS)	2.61	0.18	2200
Cooling water	36.2 - 72.5	2.5 - 5.0	0.6 - 0.9

Blank side radial stack cooling / HiFlow Blow side radial cooling	1.45	0.1	6000
Blank side radial cooling NNPB Blow side radial cooling	1.45	0.1	5300
Blank side radial stack cooling / HiFlow Blow side axial cooling	2.32	0.16	3800
Blank side radial stack cooling / HiFlow Blow side Vertical Air Stream (VAS)	2.32	0.16	4100
Blank side radial cooling NNPB Blow side axial cooling	2.90	0.2	2000
Blank side radial cooling NNPB Blow side Vertical Air Stream (VAS)	2.61	0.18	2200
Blank side axial cooling Blow side axial cooling	2.90	0.2	2000
Blank side axial cooling Blow side Vertical Air Stream (VAS)	2.61	0.18	2200
Cooling water	36.2 - 72.5	2.5 - 5.0	0.6 - 0.9

- Operating air supply must be clean, dry and oil-free
- Operating air with constant pressure  $\pm 0.02$  bar (0.3 psi)
- Pilot air min. 0.5 bar (7.2 psi) in excess of operating air
- Pilot air must be dry, clean and filtered by a microfog oiler at a constant pressure of  $\pm 0.02$  bar (0.3 psi)
- Maximum temperature of compressed air 45°C
- Water hardness not more than 6°dH (1°dH acc. to 0.1783 mmol/l HCO<sub>3</sub>)
- Air of mould cooling must be clean and oil-free

Illustrations are non-binding and may include optional equipment. Products are subject to continuous technical modifications.

The mentioned consumption values are non-binding and are subject to the customer's individual production program.

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