

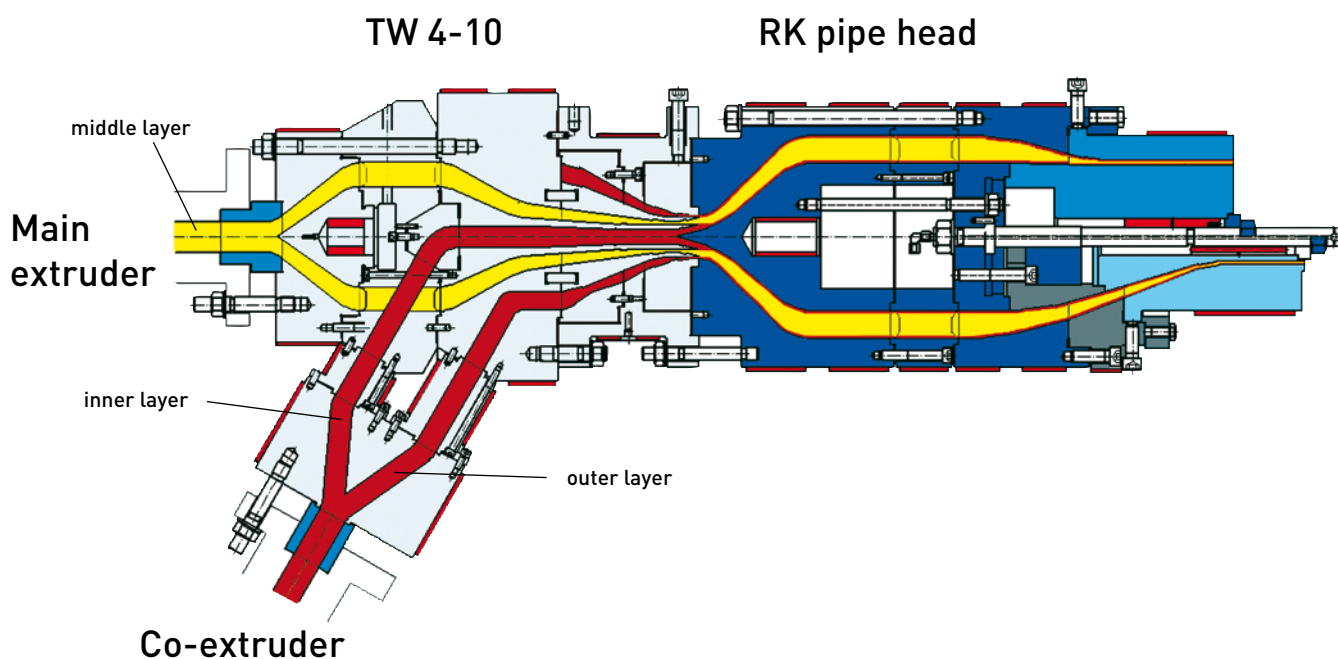
PERFECT COMPONENTS.
PERFECT SYSTEMS.

A MEMBER OF **HTI** GROUP

Co-extrusion block TW 4-10

3-layer sandwich structured pipes save up to 30 % costs!

The TW 4-10 co-extrusion block by High Tech Extrusion has been specially developed for the production of 3-layer sandwich structured pipes. Foamed or low cost formulations containing regrind or lower levels of expensive pigments and stabilizers for the middle layer reduce costs while maintaining the necessary ring stiffness of the pipe.



Main Extruder	Co-extruder	Output rate*	Pipe head	Dimension
CON 63	CON 50	←400 kg/h	RK 1.5F, RK 2F	32-110 mm
TTS 78	TTS 78	←500 kg/h	RK 2F, RK 3F	50-200 mm
TTS 88	TTS 88	←650 kg/h	RK 2F, RK 3F, RK 4F	50-200 mm
TTS 108	TTS 108	←850 kg/h	RK 3F, RK 4F, RK 5F	90-500 mm
TTM 118	TTM 118	←1100 kg/h	RK 4F, RK 5F, RK 6F	250-710 mm
TTM 138	TTM 138	←1600 kg/h	RK 5F, RK 6F	315-710 mm

*Output rate depends on pipe dimension, raw material and formulation

Pipe Head	Dimension	Output rate	Length A
RK 1.5F	40-50 mm	→200 kg/h	700 mm
RK 2F	50-110 mm	←400 kg/h	1000 mm
RK 3F	90-200 mm	←800 kg/h	1325 mm
RK 4F	160-315 mm	←900 kg/h	1380 mm
RK 5F	280-500 mm	→900 kg/h	1640 mm
RK 6F	500-630 mm	→900 kg/h	2150 mm

Technical data	TW 4-10
Heating zones	9
Heating power	14.3 kW
Melt pressure indicator	2 / 3
Melt temperature indicator	2
Length	736 mm
Weight	818 kg
Material (chromium plated)	42CrMo4

Diverter Block	140 °	120 °
Heating zones	3	3
Heating power	5.5 kW	5.5 kW
Weight	160 kg	160 kg

- complete line: conical or parallel twin-screw extruders from High Tech Extrusion, co-extrusion block, pipe head, die sets and downstream equipment
- co-extrusion block design similar to pipe head design
- can be used in combination with 2 or 3 extruders
- easy control of wall thickness distribution through thermal adjustment
- with the TW 4-10 co-extrusion block and by use of the suitable pipe heads and dies, pipes of 40 - 630 mm OD can be produced
- with a foamed middle layer, weight savings up to 30 % compared to compact pipes can be achieved
- up to 80 % of the wall thickness can be made of regrind material, with minimum inner and outer pipe layers of 0.5 mm
- special formulations and customer assistance available
- considering more than 100 TW 4-10 co-extrusion systems already delivered, the highest levels of experience and assistance can be guaranteed



K-Tron dosing unit for foaming agent (blowing)

