**VAN DORN®**

**TOGGLE CLAMP**

**200-RS-8/14/20/30F**

---

**Injection Unit**

<table>
<thead>
<tr>
<th></th>
<th>8F</th>
<th>14F</th>
<th>20F</th>
<th>30F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inject Capacity- Calculated (cu. in.)</td>
<td>14.9</td>
<td>25.9</td>
<td>37.6</td>
<td>55.3</td>
</tr>
<tr>
<td>Inject Capacity- G.P. Polyethylene (oz.)*</td>
<td>8</td>
<td>14</td>
<td>20</td>
<td>30</td>
</tr>
<tr>
<td>Recovery Rate - G.P. PS (oz./sec.)*</td>
<td>.85</td>
<td>1.20</td>
<td>2.00</td>
<td>2.20</td>
</tr>
<tr>
<td>Injection Pressure - Max. (p.s.i.)</td>
<td>21,900</td>
<td>19,800</td>
<td>19,800</td>
<td>19,800</td>
</tr>
<tr>
<td>Injection Rate - at 10,000 p.s.i. (cu. in./sec.)</td>
<td>18.0</td>
<td>18.0</td>
<td>18.0</td>
<td>24.5</td>
</tr>
<tr>
<td>Inject Stroke (in.)</td>
<td>7.78</td>
<td>8.50</td>
<td>9.50</td>
<td>10.75</td>
</tr>
<tr>
<td>Screw Diameter (in.)</td>
<td>1.57</td>
<td>1.97</td>
<td>2.24</td>
<td>2.56</td>
</tr>
<tr>
<td>Barrel L/D Ratio</td>
<td>20:1</td>
<td>20:1</td>
<td>20:1</td>
<td>20:1</td>
</tr>
<tr>
<td>Screw Speed Range (R.P.M.†)</td>
<td>20-355†</td>
<td>30-350†</td>
<td>30-300</td>
<td>30-250†</td>
</tr>
<tr>
<td>Back Press. Adjust (screw rotating- p.s.i.)</td>
<td>75-300</td>
<td>75-300</td>
<td>75-300</td>
<td>75-300</td>
</tr>
</tbody>
</table>

---

**General Specifications**

- Pump Motor—Hydraulic System (HP)
  - 30
  - 30
  - 30
  - 50
- System Pressure (p.s.i.)
  - 2000
  - 2000
  - 2000
  - 2000
- Total Heating Wattage (KW)
  - 8.9
  - 12.7
  - 13.9
  - 13.9
- Number of Heat Control Zones
  - 4
  - 4
  - 4
  - 4
- Comb. Pump Capacity (G.P.M. @ 1000 p.s.i.)
  - 30
  - 50
  - 50
  - 60
- Oil Capacity (Gal.)
  - 110
  - 110
  - 110
  - 110
- Hopper Capacity (Lb.)
  - 95
  - 145
  - 145
  - 145
- Machine Weight (Lb. approx.)
  - 16,000
  - 19,300
  - 19,400
  - 19,700
- Machine Dimensions—Length (ft.)
  - 20.6
  - 20.6
  - 21.0
  - 21.0
- Width (ft.)
  - 4
  - 4
  - 4
  - 4
- Height (ft.)
  - 7.5
  - 7.6
  - 7.6
  - 7.7

---

**Clamping Unit**

<table>
<thead>
<tr>
<th></th>
<th>8-20F</th>
<th>30F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamp Force (tons)</td>
<td>200</td>
<td>200</td>
</tr>
<tr>
<td>Clamp Stroke—Adjustable (in.)*</td>
<td>8-16.5</td>
<td>8-16.5</td>
</tr>
<tr>
<td>Open Daylight—Max. (in.)*</td>
<td>37.5</td>
<td>37.5</td>
</tr>
<tr>
<td>Mold Thickness—Min./Max. (in.)*</td>
<td>8-21</td>
<td>8-21</td>
</tr>
<tr>
<td>Platen Size—Standard—HxW (in.)*</td>
<td>30.75 x 30.75</td>
<td>30.75 x 30.75</td>
</tr>
<tr>
<td>Dist. Between Rods—Std. HxW (in.)</td>
<td>21 x 18</td>
<td>21 x 18</td>
</tr>
<tr>
<td>Tie Rod Diameter (in.)</td>
<td>3.5</td>
<td>3.5</td>
</tr>
<tr>
<td>Clamp Speeds: Closing (in/sec.)</td>
<td>30</td>
<td>40</td>
</tr>
<tr>
<td>Opening (in/sec.)</td>
<td>43</td>
<td>57</td>
</tr>
<tr>
<td>Ejector Force (tons)</td>
<td>50</td>
<td>50</td>
</tr>
<tr>
<td>Ejector Stroke (in.)</td>
<td>4</td>
<td>4</td>
</tr>
</tbody>
</table>

*Dependent upon mold, material and conditions.
†Average value based on S.P.I. test procedures.
‡Higher torque motor available with lower R.P.M. and recovery rates.

Since continuous improvement is Van Dorn’s policy, we reserve the right to change specifications, designs and performance data without prior notice or obligation.
200-R5-8/14/20/30F

Van Dorn's fluid drive, or F-Series, toggle clamp machines feature hydraulically driven screws that generate high-quality homogeneous melts at high rates. Stable screw speeds and precise, infinitely variable back pressure control are features contributing to outstanding molding output.

Add faster set-ups, improved molding speeds and minimal maintenance and you have the injection molding capability molders identify with the name, Van Dorn.

STANDARD FEATURES
- Large part removal clearance
- Purge guard with interlock
- Swing-away material hopper
- Integral-base drip pan
- Full-floating hardened toggle pins
- Automatic oil lubrication.

VAN DORN
Committed to the future of plastics

VAN DORN PLASTIC MACHINERY CO., A Division of Van Dorn Company
11792 Alameda Dr. • Strongsville, Ohio 44136 • Write: P.O. Box 8848 • Strongsville, Ohio 44136 • Telephone: (216) 236-8988

Effective June 1, 1989 • Made in U.S.A.