**Injection Unit**

<table>
<thead>
<tr>
<th></th>
<th>20F</th>
<th>30F</th>
<th>35F</th>
<th>60F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inject Capacity - Calculated (cu in.)</td>
<td>37.6</td>
<td>55.3</td>
<td>55.2</td>
<td>111.5</td>
</tr>
<tr>
<td>Inject Capacity - G.P. Polyurethane (oz)</td>
<td>20</td>
<td>30</td>
<td>35</td>
<td>60</td>
</tr>
<tr>
<td>Recovery Rate - G.P. PS (cu/sec)</td>
<td>2.00</td>
<td>2.20</td>
<td>2.45</td>
<td>2.95</td>
</tr>
<tr>
<td>Injection Pressure - Max. (p.s.i.)</td>
<td>19,900</td>
<td>18,900</td>
<td>17,500</td>
<td>20,400</td>
</tr>
<tr>
<td>Inject Rate - at 10,000 p.s.i. (cu in/sec)</td>
<td>24.0</td>
<td>25.0</td>
<td>28.0</td>
<td>25.0</td>
</tr>
<tr>
<td>Screw Diameter (in.)</td>
<td>2.24</td>
<td>2.66</td>
<td>2.72</td>
<td>3.15</td>
</tr>
<tr>
<td>Barrel L/D Ratio</td>
<td>20.1</td>
<td>20.1</td>
<td>70.1</td>
<td>70.1</td>
</tr>
<tr>
<td>Screw Speed Range (R.P.M.)</td>
<td>30-300</td>
<td>30-300</td>
<td>30-300</td>
<td>30-200</td>
</tr>
<tr>
<td>Back Pressure (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>

**Clamping Unit**

<table>
<thead>
<tr>
<th></th>
<th>20/30</th>
<th>35F</th>
<th>60F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamp Force (tons)</td>
<td>350</td>
<td>350</td>
<td>350</td>
</tr>
<tr>
<td>Clamp Stroke - Adjustable (in)</td>
<td>11-24.5</td>
<td>11-24.5</td>
<td>11-24.5</td>
</tr>
<tr>
<td>Open Daylight - Max. (in.)</td>
<td>48.5</td>
<td>48.5</td>
<td>48.5</td>
</tr>
<tr>
<td>Mold Thickness - Min. Max. (in)</td>
<td>8.24</td>
<td>3.24</td>
<td>8.24</td>
</tr>
<tr>
<td>Plate Size Standard - HxW (in)</td>
<td>40 x</td>
<td>40 x</td>
<td>40 x</td>
</tr>
<tr>
<td>41,37</td>
<td>41,37</td>
<td>41,37</td>
<td></td>
</tr>
<tr>
<td>Dist. Between Rods - Std. HxW (in)</td>
<td>27 x 27</td>
<td>27 x 27</td>
<td>27 x 27</td>
</tr>
<tr>
<td>Tie Rod Diameter (in)</td>
<td>4.5</td>
<td>4.5</td>
<td>4.5</td>
</tr>
<tr>
<td>Clamp Speeds:</td>
<td>Closing (in/sec)</td>
<td>21</td>
<td>22</td>
</tr>
<tr>
<td></td>
<td>Opening (in/sec)</td>
<td>30</td>
<td>31</td>
</tr>
<tr>
<td>Ejector Force (tons)</td>
<td>11.7</td>
<td>11.7</td>
<td>11.7</td>
</tr>
<tr>
<td>Ejector Stroke (in)</td>
<td>6</td>
<td>6</td>
<td>6</td>
</tr>
</tbody>
</table>

*Dependent upon mold, material and conditions.*

*Average value based on S.P.A. test procedures.*

*Since continuous improvement is Van Dorn's policy, we reserve the right to change specifications, designs and performance data without prior notice or obligation.*
350-RS-20/30/35/60F

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