

BIEBOUW BVBA  
INDUSTRIESTRAAT 17  
B-8755 Ruiselede  
Tel: +32(0)51 686714  
Fax: +32(0)51 689182  
Email: info@biebouw.com

DO NOT SCALE DRAWING  
IF IN DOUBT ASK

JOB NAME 500ML BAVARIA

TOLERANCES UNLESS OTHERWISE SPECIFIED  
DIM'S 00 ± 0,2 DIM'S 000 ± 0,05  
REMOVE BURRS & SHARP EDGES IN  
ACCORDANCE TO STANDARD PRACTICE

ITEM THIMBLE  
CUSTOMER ELIVDZD

ORDER NO. 20092181

QUANTITY 30

REF. NO.

DRAWN BY JBB

CHECKED BY

DATE 30/07/2009

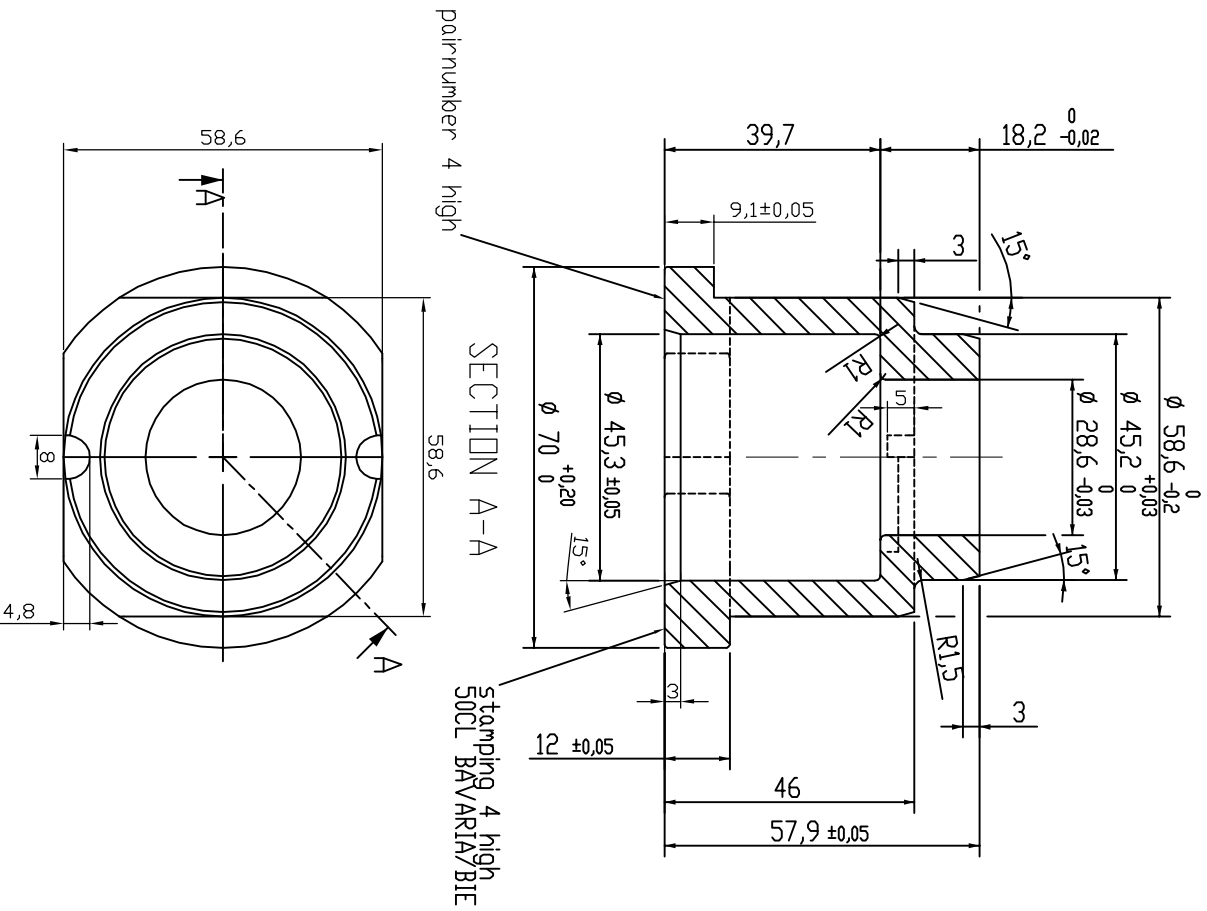
CAST: ~ ROUGH V FINE VV POLISH VVV

SURFACE FINISH  
THIRD ANGLE  
PROJECTION

MATERIAL Steel

MACHINE Emhart BB DG 5 1/2

DRG No: BIEB243-30-A



INVERT CENTRE : -  
74° DIMENSION : -  
ASSEMBLY : -  
SCALE : 1:1

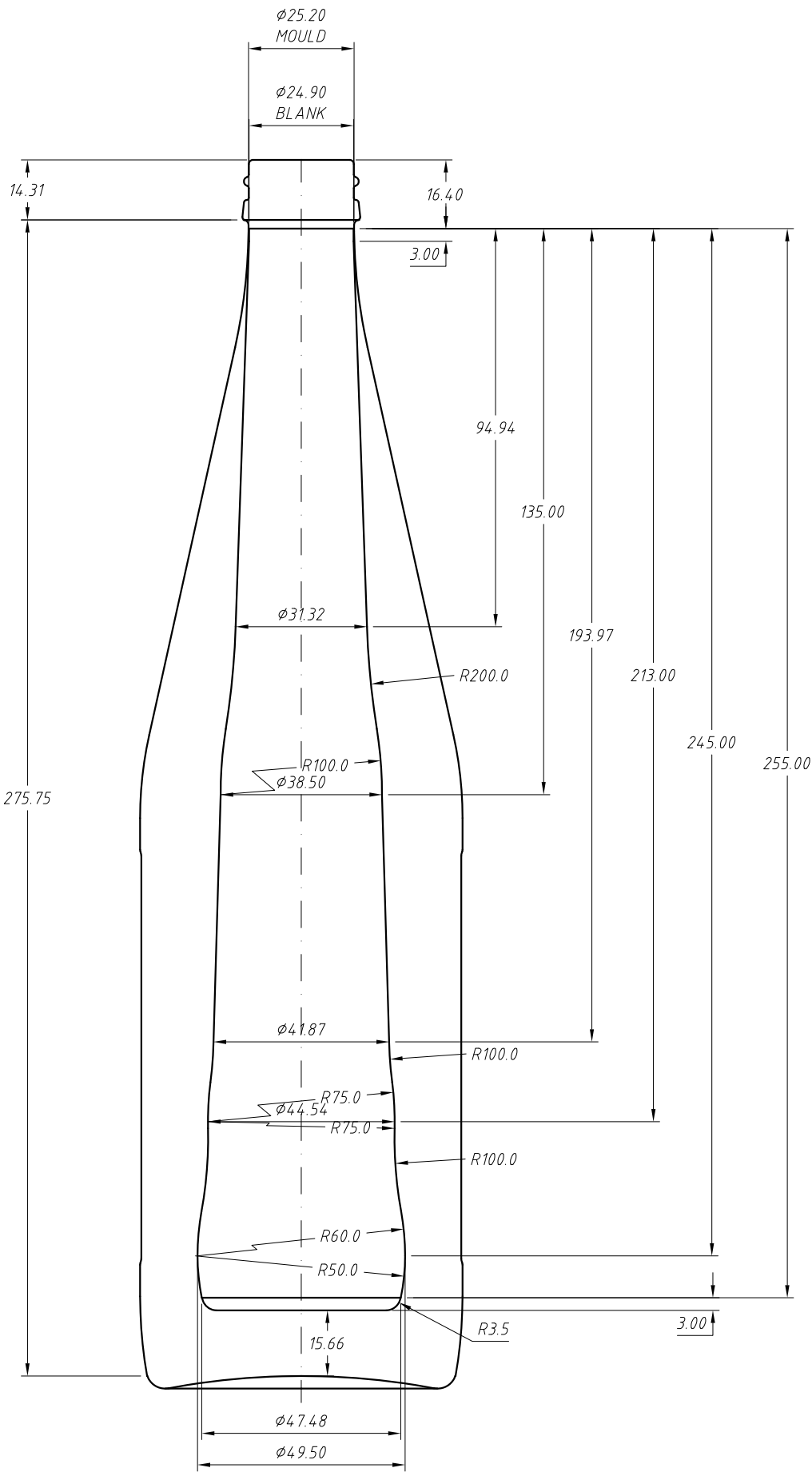
SPECIFICATION DATA	
WEIGHT: 490,0 grm	COLOUR: FLINT
FINISH: MCA 2	
FILLING CAPACITY:	700,0ml
BRIMFULL CAPACITY:	730,0ml
HEIGHT CONTRACTION CONSTANT:	1.0045
MOULD NECK DIAMETER:	25,20
BLANK NECK DIAMETER:	24,90
RING NECK DIAMETER:	25,00
TAKE OUT TONGS DIAMETER:	25,40

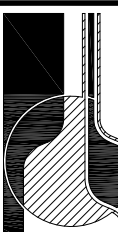
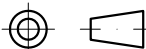




BLOW MOULD DISPLACEMENT		
	ml	g @ 20°
BRIMFULL CAPACITY	730,00	727,96
+ WEIGHT x 0.403 CONSTANT	197,47	196,92
= CONTAINER DISPLACEMENT	927,47	924,88
+ 1,01% SINKAGE & SHRINKAGE	9,37	9,34
= TOTAL DISPLACEMENT	936,84	934,22
– RING CAST HEIGHT DISPLACEMENT	7,58	7,56
= MOULD & BOTTOM DISPLACEMENT	929,26	926,66
– BOTTOM DISPLACEMENT	7,07	7,05
= MOULD CAVITY DISPLACEMENT	922,19	919,61
TOLERANCES ON DISPLACEMENT	±1,5	±1,49

BLOW/BLOW BLANK DISPLACEMENT		
	ml	g @ 20°
490,00g WEIGHT x 0.41CONSTANT	200,90	200,34
x 42,87% OVERCAPACITY	287,03	286,22
– RING & SKIRT DISPLACEMENT	8,72	8,70
= BLANK & BAFFLE DISPLACEMENT	278,31	277,53
– BAFFLE DISPLACEMENT	4,55	4,54
= BLANK CAVITY DISPLACEMENT	273,76	272,99
TOLERANCES ON DISPLACEMENT	±1,50	±1,49

MACHINE DATA	
MOULD OUTER HOLDER	53
MOULD OUTER 'H' DIMENSION	57,15mm
BLANK MOULD HOLDER	23
BLANK OUTER 'H' DIMENSION	117,5mm
INVERT CENTRE LINE	82,50mm
BOTTOM FITTING DIAMETER	105,0
BAFFLE / FUNNEL FITTING DIAMETER	77,80
RING OUTER FITTING DIAMETER	90,5
RING OUTER HEIGHT	
BLOWHEAD DIAMETER	60,0

DRAWING NUMBERS	
SPECIFICATION	
PARISON LAYOUT	
MOULD OUTER	
MOULD CAVITY	
BOTTOM PLATE	
DOT CAVITY CODE	
BLANK MOULD	
BLANK CAVITY	
BAFFLE / BAFFLE HOLDER	
BAFFLE INSERT	
FUNNEL	
MOULD VERTIFLOW PATTERN	
DISTRIBUTOR PLATE	
DISTRIBUTOR PLATE VERTIFLOW	
RING OUTER	
RING CAVITY	
RING LAYOUT	
GUIDEPLATE	
PLUG / PLUNGER	
PLUNGER COOLER	
PLUNGER & COOLER LAYOUT	
BLOWHEAD	
TAKE OUT TONGS	



<div></div> <div>© BIEBOUW B.V.B.A. Industriestraat 17 B-8755 Ruiselede Belgium</div> <div>Tel.: +32 (0)51 686714 Fax.: +32 (0)51 689182 Email: info@biebouw.com</div>	DO NOT SCALE DRAWING IF IN DOUBT ASK	JOB NAME	700ml BADEN			
	TOLERANCES UNLESS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 REMOVE BURRS & SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE	ITEM	PARISON LAYOUT	QUANTITY		
		CUSTOMER	SYSTEMPACK	REF. NO.		
	 THIRD ANGLE PROJECTION	ORDER NO.	20120352	DRAWN BY	F.KARLSEN	REVISIONS
		MATERIAL		CHECKED BY		
	SURFACE FINISH CAST:  ROUGH:  FINE:  POLISH: 	MACHINE	EM IS DG BB 5,5"	DATE	14.02.2012	<b>DRG. NO. FKE1895 - 04</b>





# Dot Code Specification

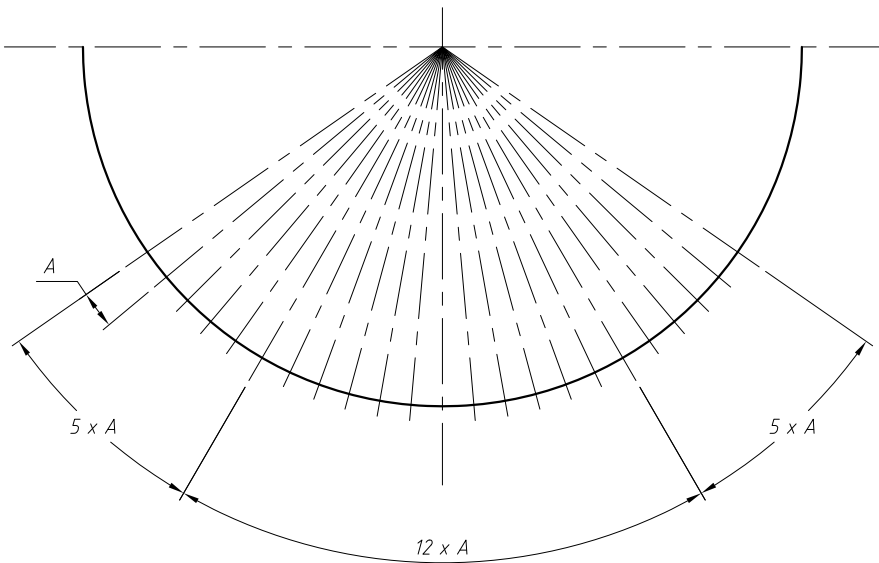
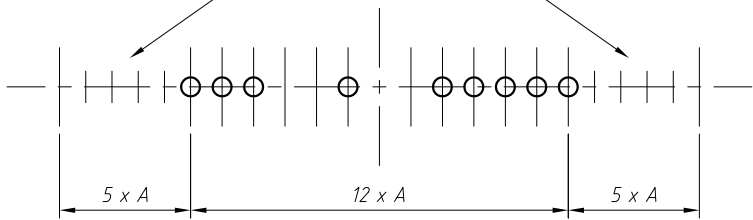
AS SEEN IN METAL

No.	Code
01.	OO••O•••OOOOOO
02.	OO••O•O••OOOOOO
03.	OO•O••O••OOOOOO
04.	OO••OO•••OOOOOO
05.	OO•O•O•••OOOOOO
06.	OOO••O•••OOOOOO
07.	OO••O•OO••OOOOOO
08.	OO•O••OO••OOOOOO
09.	OO••OO•O••OOOOOO
10.	OOOOOO••O••OO
11.	OOOO••O•••OOOOOO
12.	OO•O•O•O••OOOOOO
13.	OOO••O•O••OOOOOO
14.	OO•OO••O••OOOOOO
15.	OOO•O••O••OOOOOO
16.	OO••OOO•••OOOOOO
17.	OO•O•OO•••OOOOOO
18.	OOO••OO•••OOOOOO
19.	OO•O•O•OOO••OO
20.	OOOOOO•O•O••OO
21.	OOOO•O•O•O••OO
22.	OOO•O•O•O••OO
23.	OO•OO•O•••OOOOOO
24.	OOO•O•O•••OOOOOO
25.	OO••O•OOO••OO
26.	OO•O•••OOO••OO
27.	OO••OO•OO••OO
28.	OO•O•O•OO••OO
29.	OO•OOO•O•O••OO
30.	OOOOOO•O••O••OO

No.	Code
31.	OOOO•O•O•••OOO
32.	OOOO••O•O••OO
33.	OOO•••OOO•••OOO
34.	OOO••O•O••OO••OO
35.	OO•OO•••OO••OOO
36.	OOO•O•••OO••OOO
37.	OO•••OOO•O••OOO
38.	OO•O•OO•O••OOO
39.	OO•OO•••OOO••O
40.	OOOOOO••OO•••OO
41.	OOOO•O•••OO••OO
42.	OOOO••O•O••OOO
43.	OOO•OO•O•••OOO
44.	OO•OO•O••OO••OO
45.	OOO••OO•O••OOO
46.	OO•OO•O•O••OOO
47.	OO•OOO••O••OOO
48.	OO•••OOOO•••OOO
49.	OO•OOO•••OO••OO
50.	OOOOOO••O•O••OO
51.	OOOO•O•••O••OOO
52.	OOO•OOO•O•••OO
53.	OOO•OO•••OO••OO
54.	OOO•O•OO•••OOO
55.	OO•O•OOO•O••OO
56.	OO•O••OOO•••OOO
57.	OO•OO•OO•••OOO
58.	OO•OOO•O•••OOO
59.	OO•••OOO•OO••OO
60.	OOOOOO••O•••OOO

No.	Code
61.	OOOO•••OOO•••OO
62.	OOO••OOO•••O••OO
63.	OOO•OO•••O••OOO
64.	OOO•O•O•O••OO••OO
65.	OOO•••OOO•O••OO
66.	OO•••OOOOO•••OO
67.	OO•••O••OOOO••OO
68.	OO•O•••OOOO••OO
69.	OO•OO••OOO•••OO
70.	OOOO•OO•O•••OO
71.	OOOO•••OO•O••OO
72.	OOO•OO•OO•••OO
73.	OOO•O••OOO•••OO
74.	OOO•O•••OOO••OO
75.	OOO•••OO•OO••OO
76.	OO••OOOO•O•••OO
77.	OO•OO•OO•O••OO
78.	OO•••OO•OOO••OO
79.	OO•••OOOO•O••OO
80.	OOOO•OO•••O••OO
81.	OOOO•••OO•••OOO
82.	OOO•OO•O•O••OO
83.	OOO•O•OO•O••OO
84.	OOO•••OOOO•••OO
85.	OOO••O•OOO••OO
86.	OO••OOOO•••O••OO
87.	OO••OOO•OO•••OO
88.	OO•O•OO•OO••OO
89.	OO•O••OOOO•••OO
90.	OOOO•O••OO•••OO

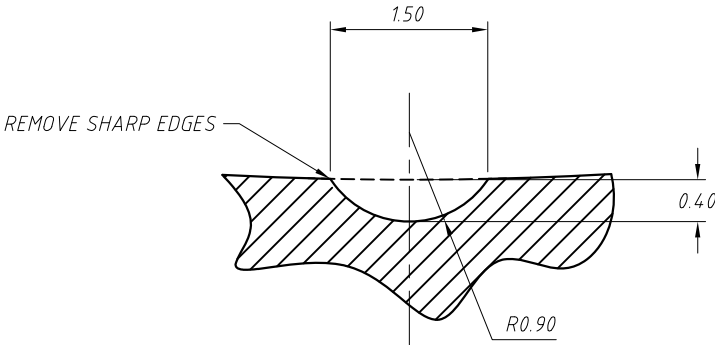
THIS AREA MUST BE  
FREE FROM ANY ENGRAVING



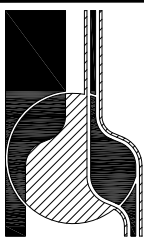
THESE REPRESENT THE EMPTY SPACES

THESE REPRESENT ENGRAVED 'DOTS'






ANGULAR DIVISION 'A' (1/2° MINIMUM)	4,59°
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SECTION THRU' DOT CODE  
SCALE 20:1

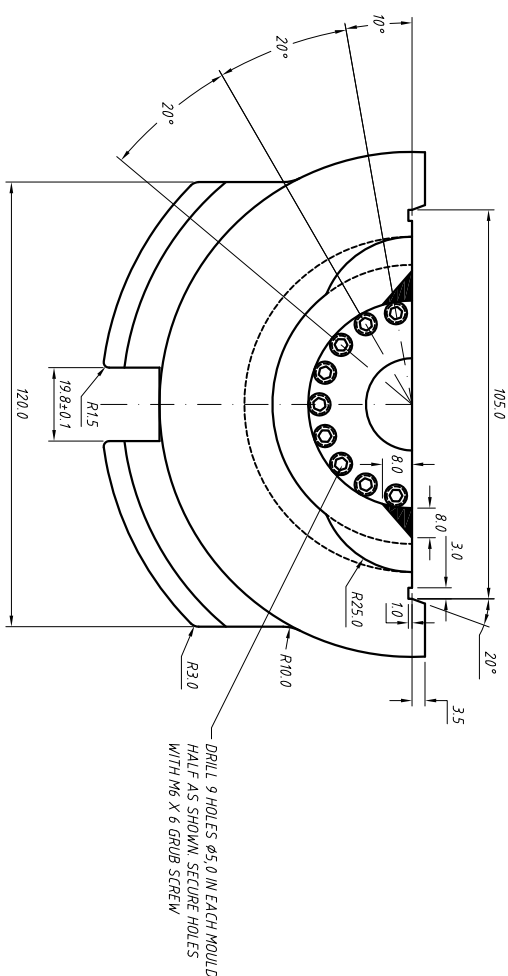
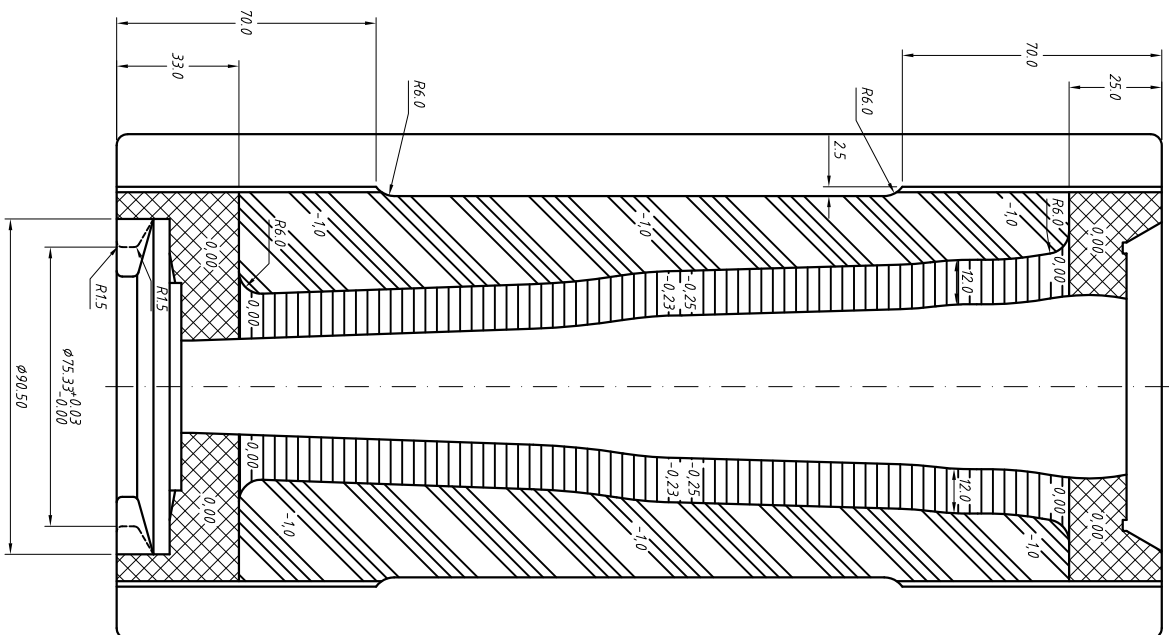
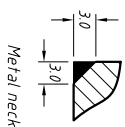
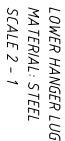






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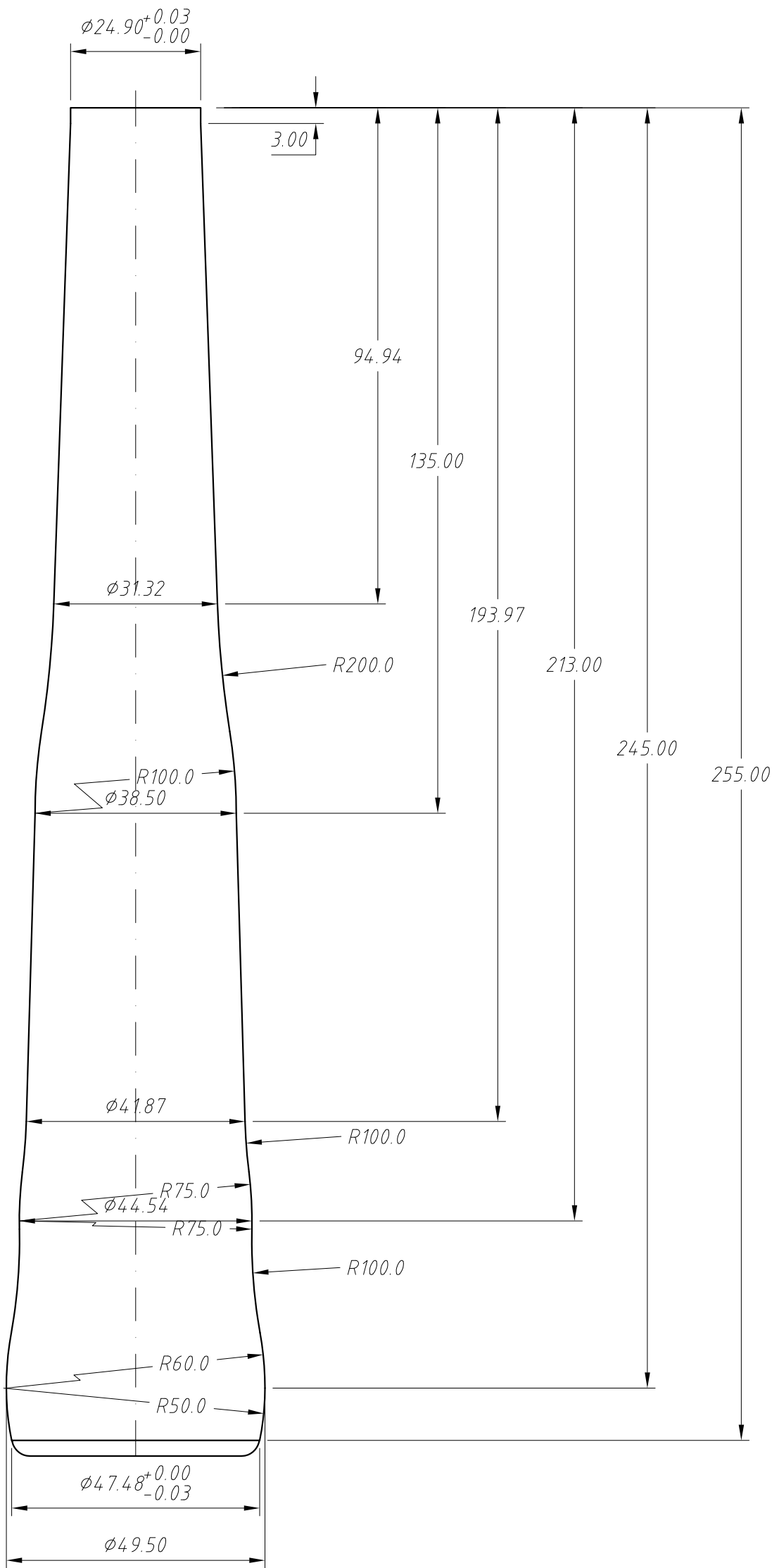
DO NOT SCALE DRAWING IF IN DOUBT ASK
TOLERANCES UNLESS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 REMOVE BURRS & SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE
 THIRD ANGLE PROJECTION
SURFACE FINISH CAST:  ROUGH:  FINE:  POLISH: 

JOB NAME	700ml BADEN		
ITEM	DOT CODE	QUANTITY	
CUSTOMER	SYSTEMPACK	REF. NO.	
ORDER NO.	20120352	DRAWN BY	F.KARLSEN
MATERIAL		CHECKED BY	
MACHINE		DATE	14.02.2012






REVISIONS	
DRG. NO.	FKE1895 - 11



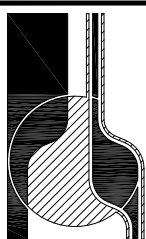
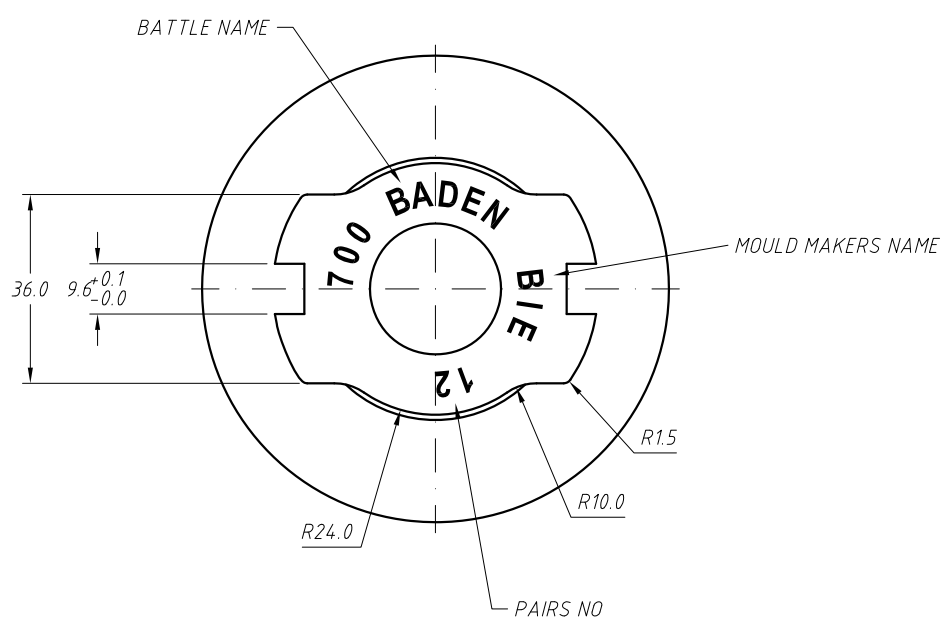
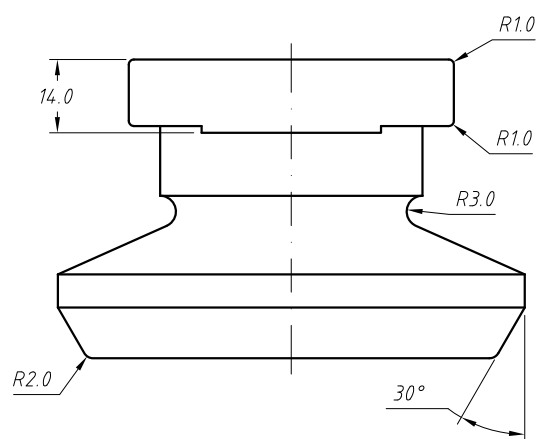
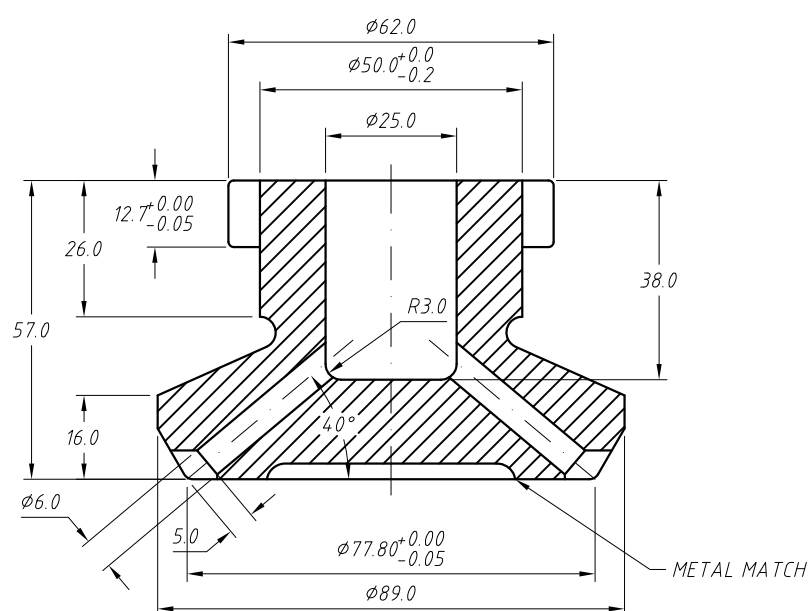
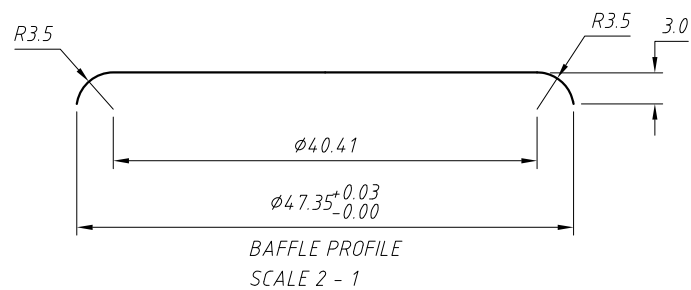
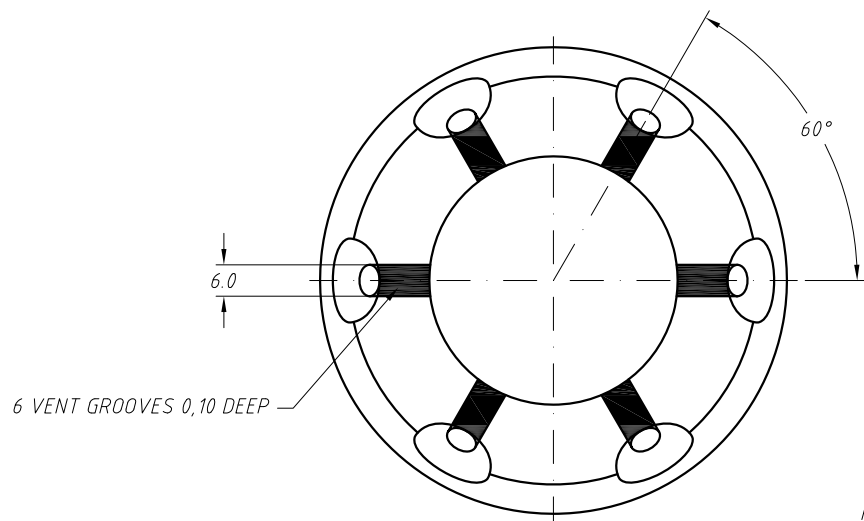
 <b>BIEBOW B.V.B.A.</b> Industriestraat 17 B-8755 Ruiselede Belgium Tel.: +32 (0)51 886714 Fax.: +32 (0)51 889182 E-mail: <a href="mailto:info@biebow.com">info@biebow.com</a>		DO NOT SCALE DRAWING IF IN DOUBT ASK	
 TOLERANCE LIMITS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 HOLE: H9/D9 SHAFTING: H7/g6 MOUNTING: AS SHOWN		700ml BADEN	
 THIRD ANGLE PROJECTION		JOB NAME	
 SURFACE FINISH GR1: ~ ROUGH ▽ FINE FV10 POLISH VVV		ITEM	
MACHINE		BLANK MOLD	
MATERIAL		SYSTEMPACK	
ORDER NO.		QUANTITY	
SEE ORDER		REF. NO.	
CHECKED BY		DRAWN BY F.AARSEN	
DATE 16.02.2012		REVISIONS	
<b>DRG. NO. FKE1895 - 12</b>			



BLANK CAVITY VOLUME: 273,76ml  
BAFFLE VOLUME: 4,55ml  
TOTAL VOLUME: 278,31ml

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<div>DO NOT SCALE DRAWING IF IN DOUBT ASK</div>		JOB NAME			
		ITEM		BLANK CAVITY	
<div>TOLERANCES UNLESS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 REMOVE BURRS &amp; SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE</div>		CUSTOMER		SYSTEMPACK	
		ORDER NO.		20120352	
<div> THIRD ANGLE PROJECTION</div>		MATERIAL			
		MACHINE		EM IS DG BB 5,5"	
<div>CAST:  SURFACE FINISH ROUGH:  FINE:  POLISH: </div>					
		QUANTITY			
		REF. NO.			
		DRAWN BY		F.KARLSEN	
		CHECKED BY			
		DATE		15.02.2012	
		REVISIONS			
		DRG. NO.		FKE1895 - 13	



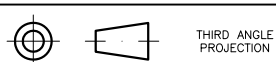


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TOLERANCES UNLESS OTHERWISE SPECIFIED  
DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05  
REMOVE BURRS & SHARP EDGES IN  
ACCORDANCE TO STANDARD PRACTICE



SURFACE FINISH  
CAST: ROUGH: FINE: POLISH:

JOB NAME

700ml BADEN

ITEM

BAFFLE

QUANTITY

CUSTOMER

SYSTEMPACK

REF. NO.

ORDER NO.

20120352

DRAWN BY

F.KARLSEN

MATERIAL

SEE ORDER

CHECKED BY

MACHINE

EM IS DG BB 5,5"

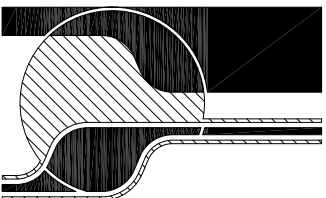
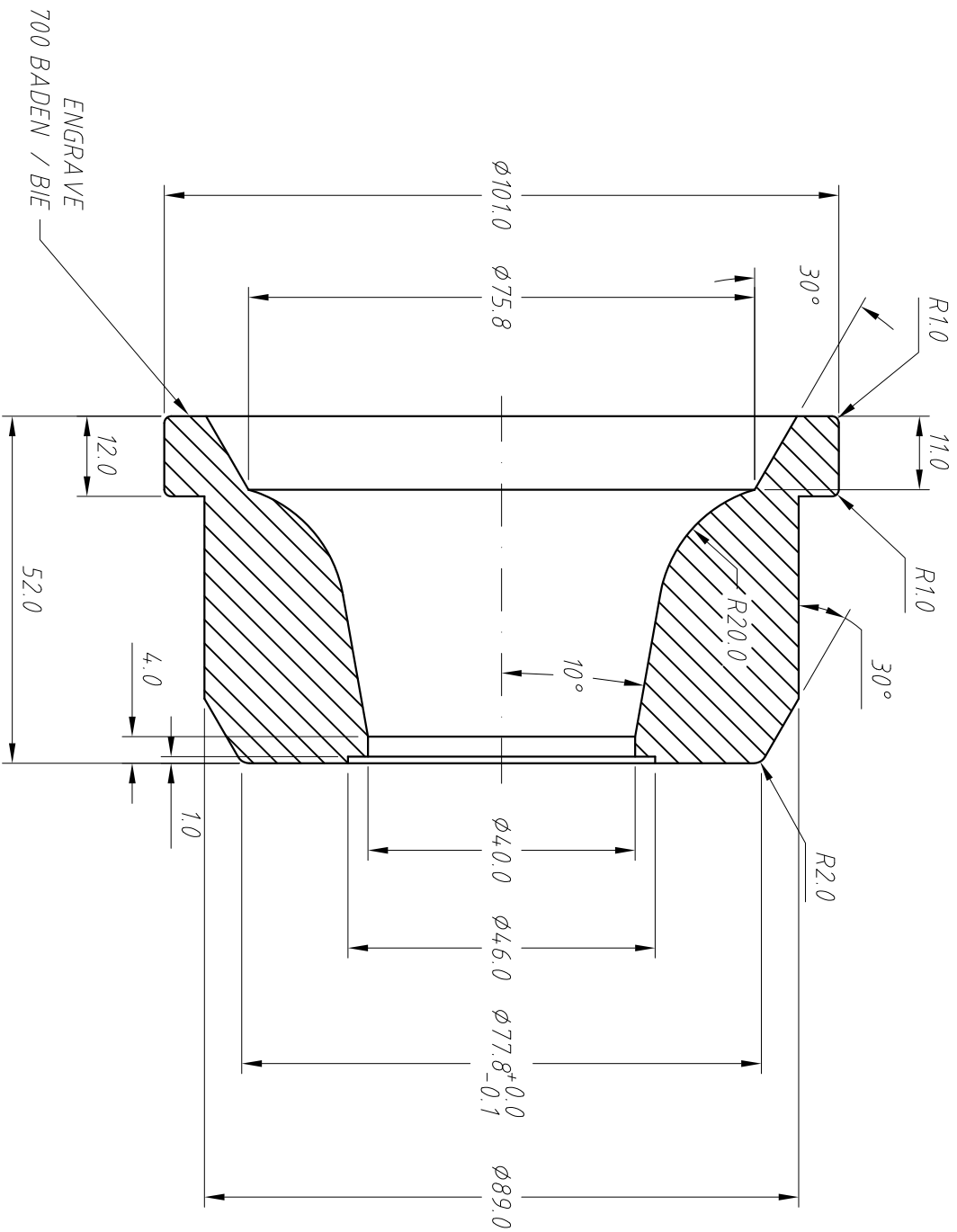
DATE

17.02.2012

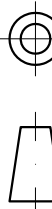
REVISIONS

DRG. NO.

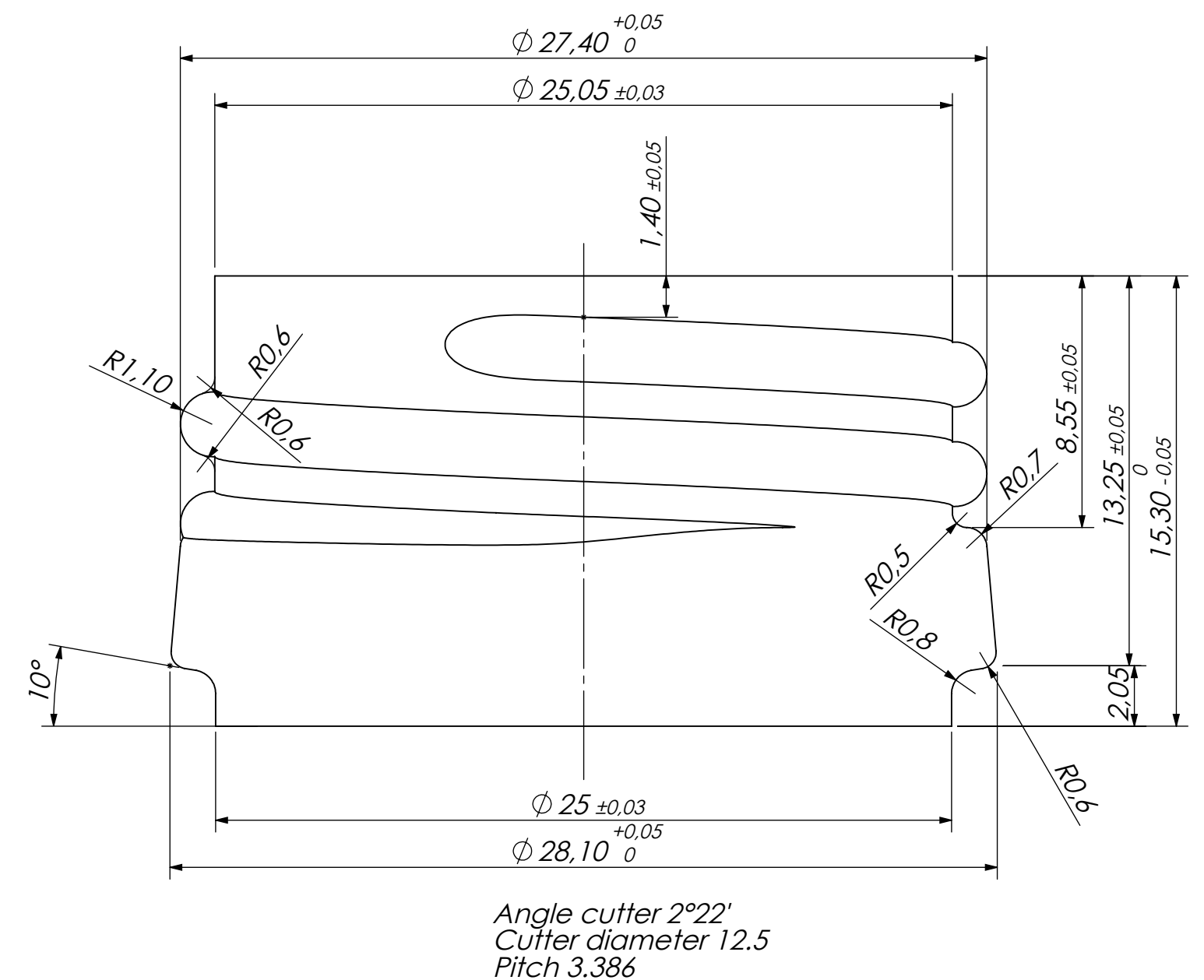
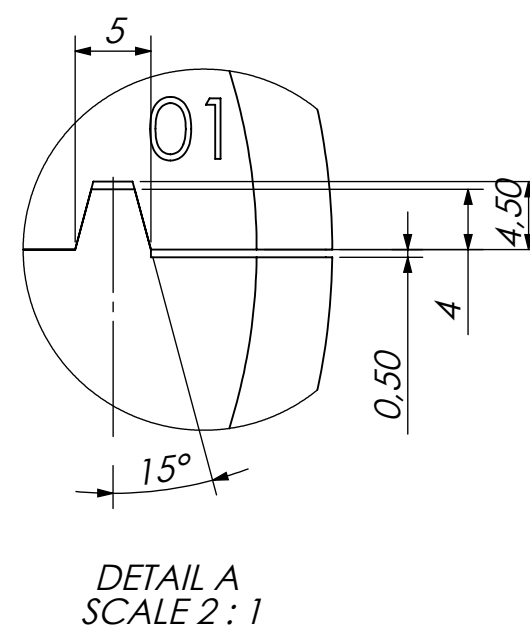
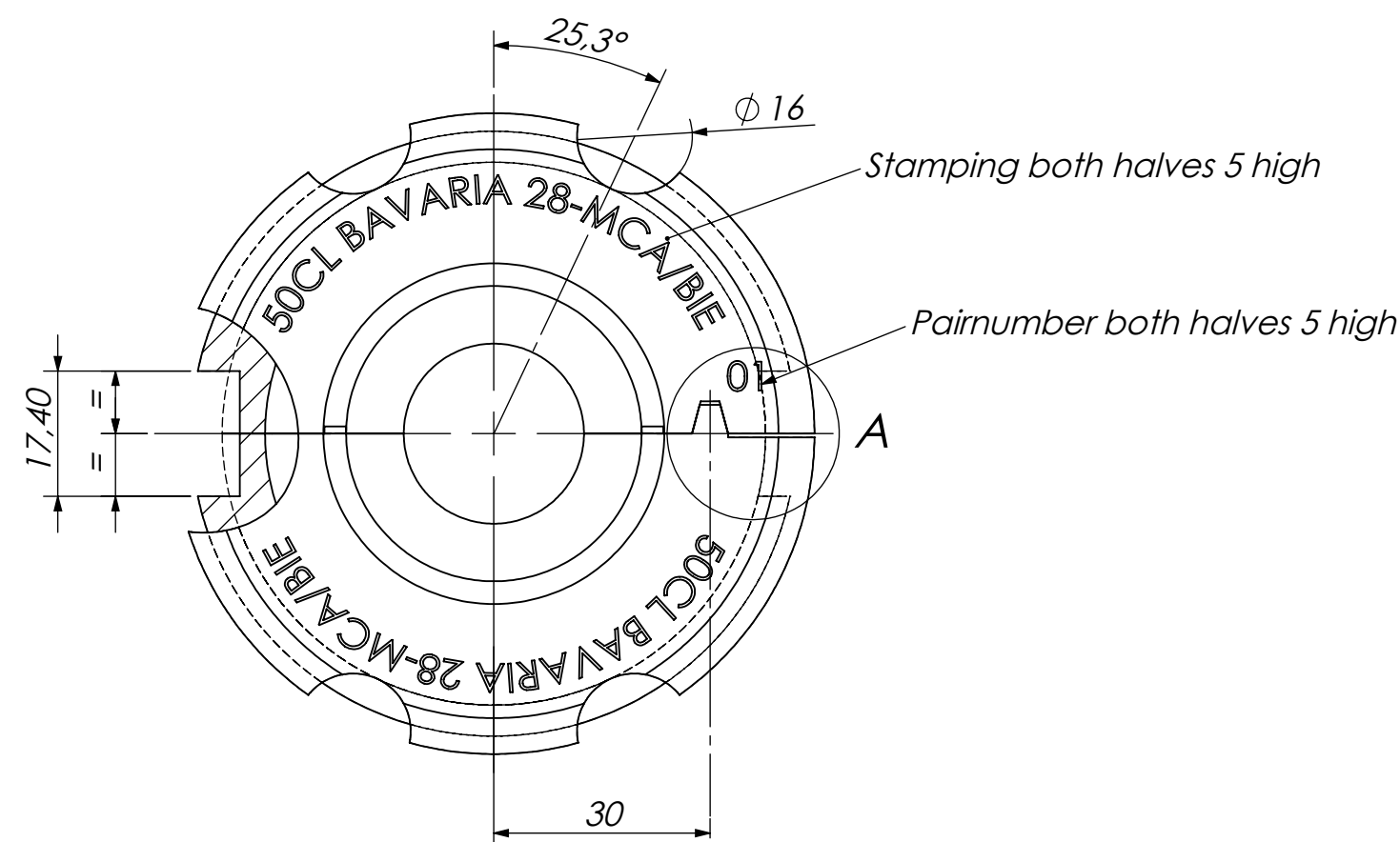
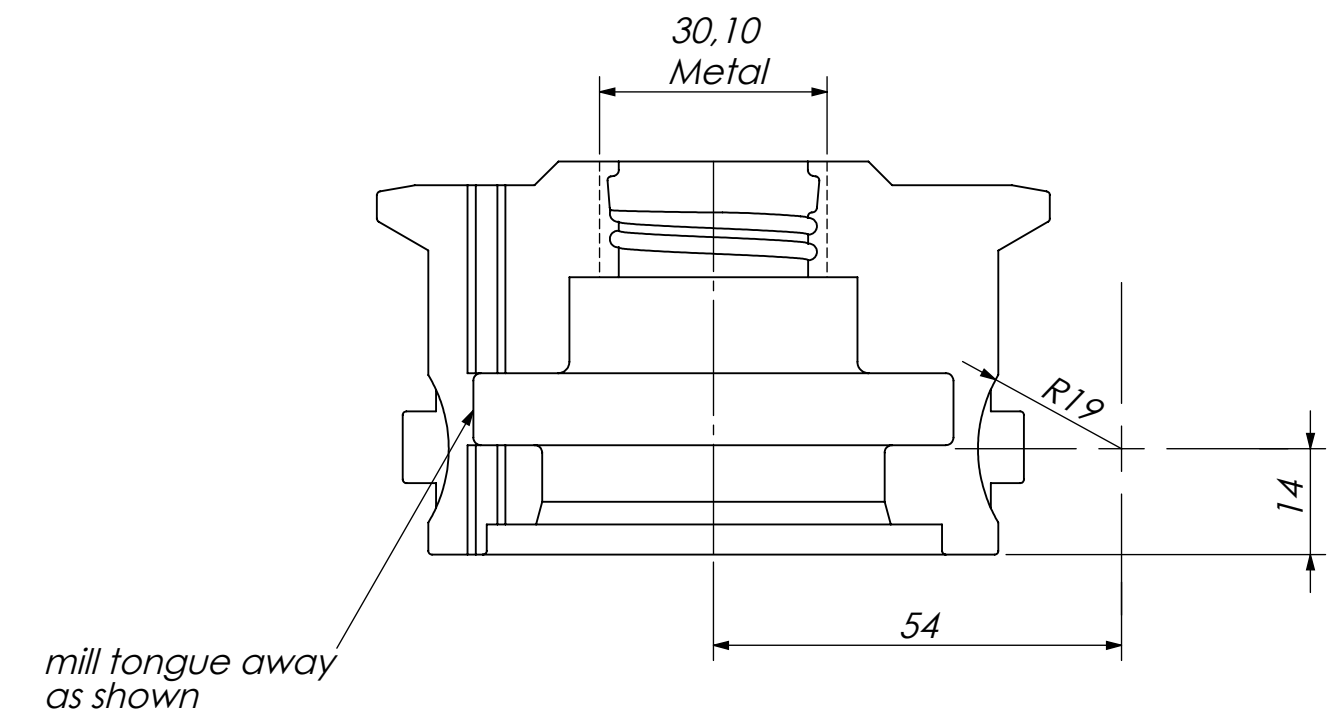
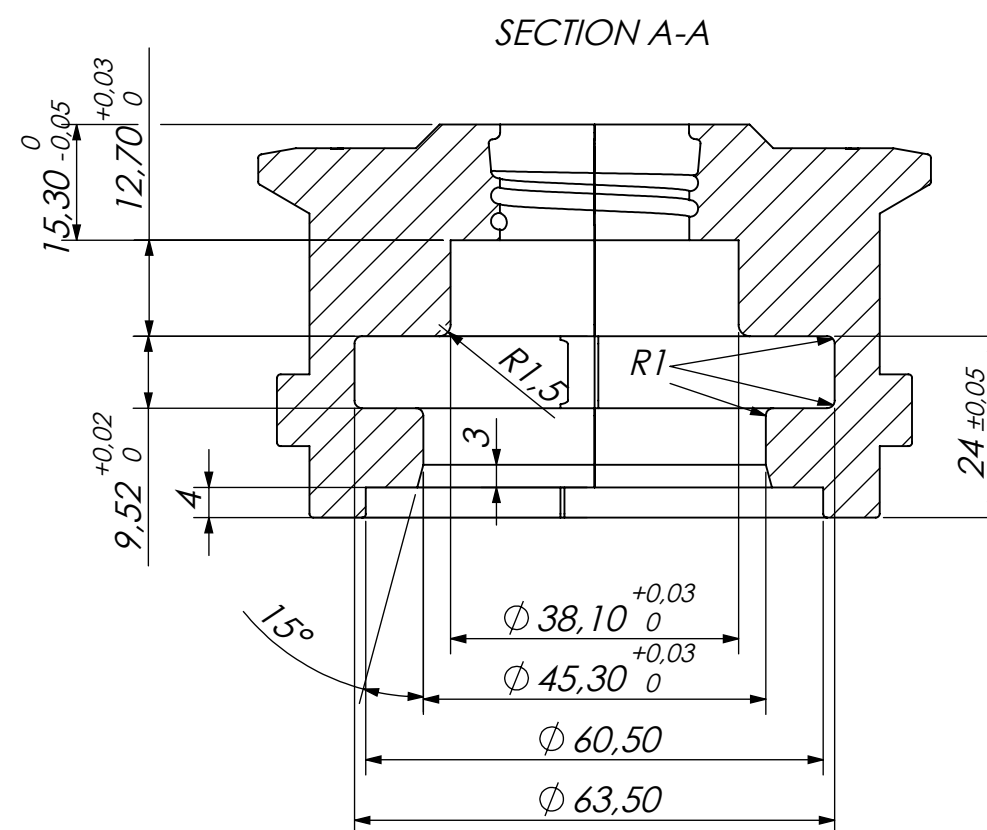
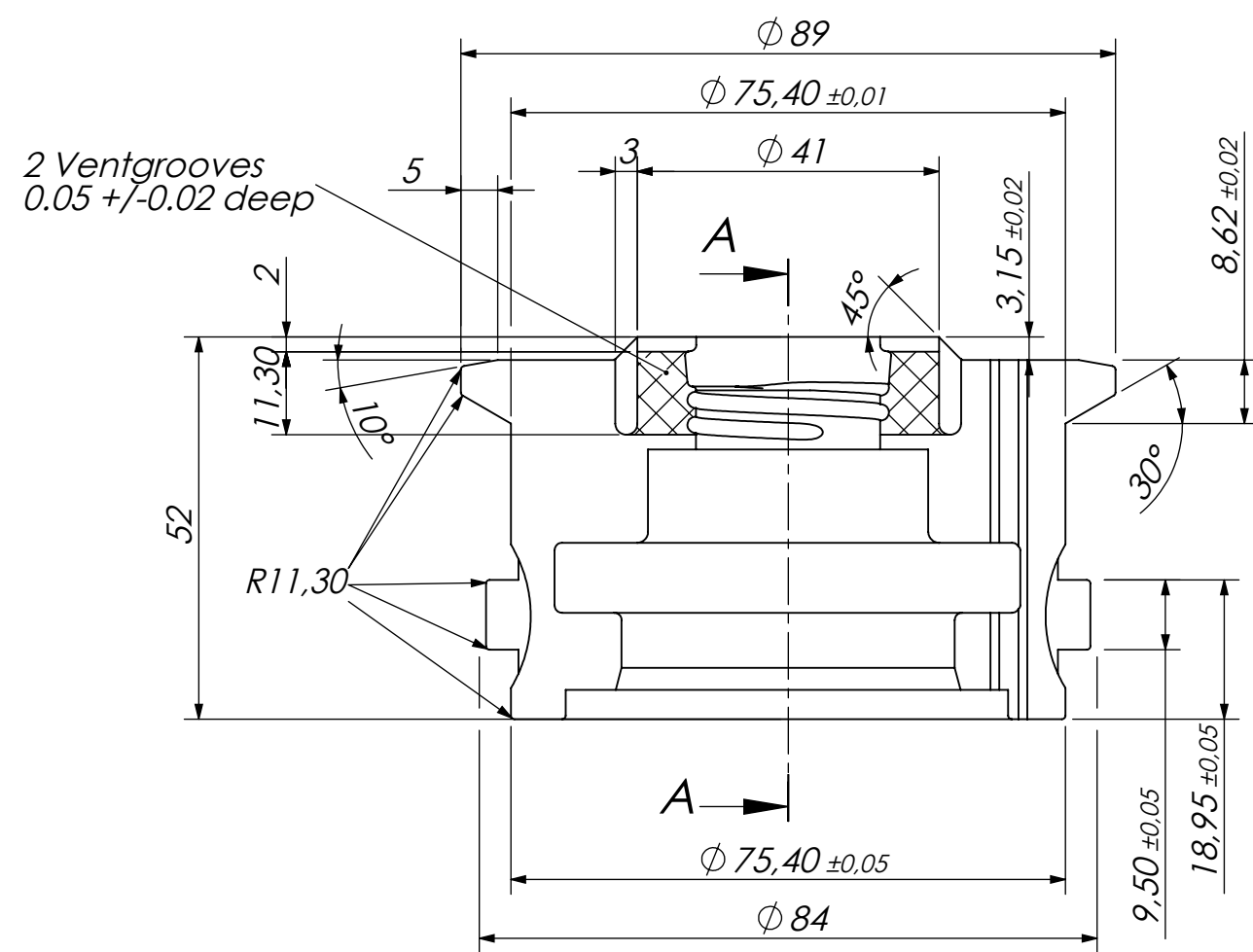
FKE1895 - 14



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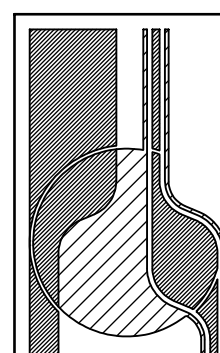
DO NOT SCALE DRAWING IF IN DOUBT ASK		700ml BADEN			DRG. NO. FKE1895 - 25
TOLERANCES UNLESS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 REMOVE BURRS & SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE	JOB NAME				
	ITEM	FUNNEL	QUANTITY		
	CUSTOMER	SYSTEMPACK	REF. NO.		
	ORDER NO.	20120352	DRAWN BY	F.KARLSEN	
	MATERIAL	SEE ORDER	CHECKED BY		
 THIRD ANGLE PROJECTION	MACHINE	EM IS DG BB 5,5"	DATE	17.02.2012	REVISIONS
SURFACE FINISH CAST: ~ ROUGH: ▽ FINE: ▽▽ POLISH: ▽▽▽					





Cavity hard welded 1 mm bigger then biggest diameter

INVERT CENTRE :-  
'H' DIMENSION :-  
ASSEMBLY :-  
SCALE : 1:1

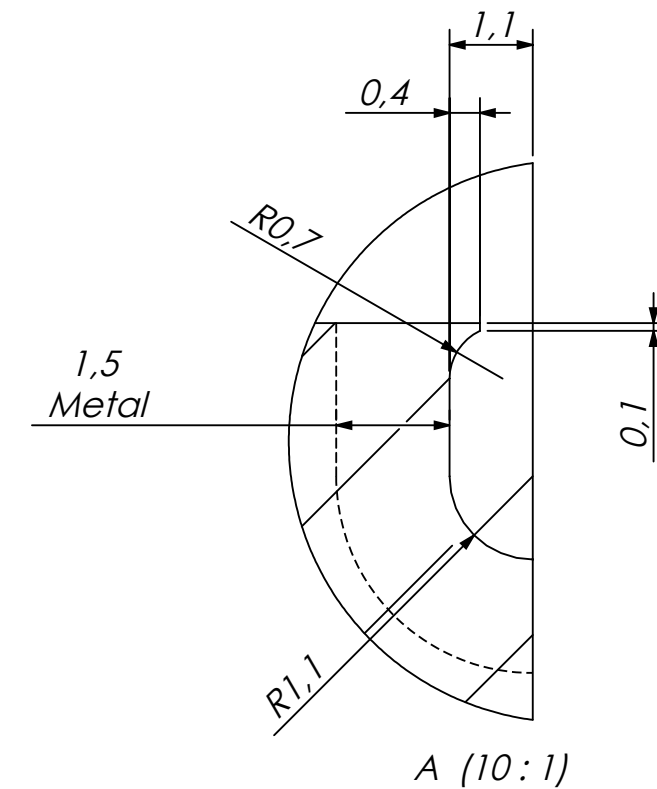
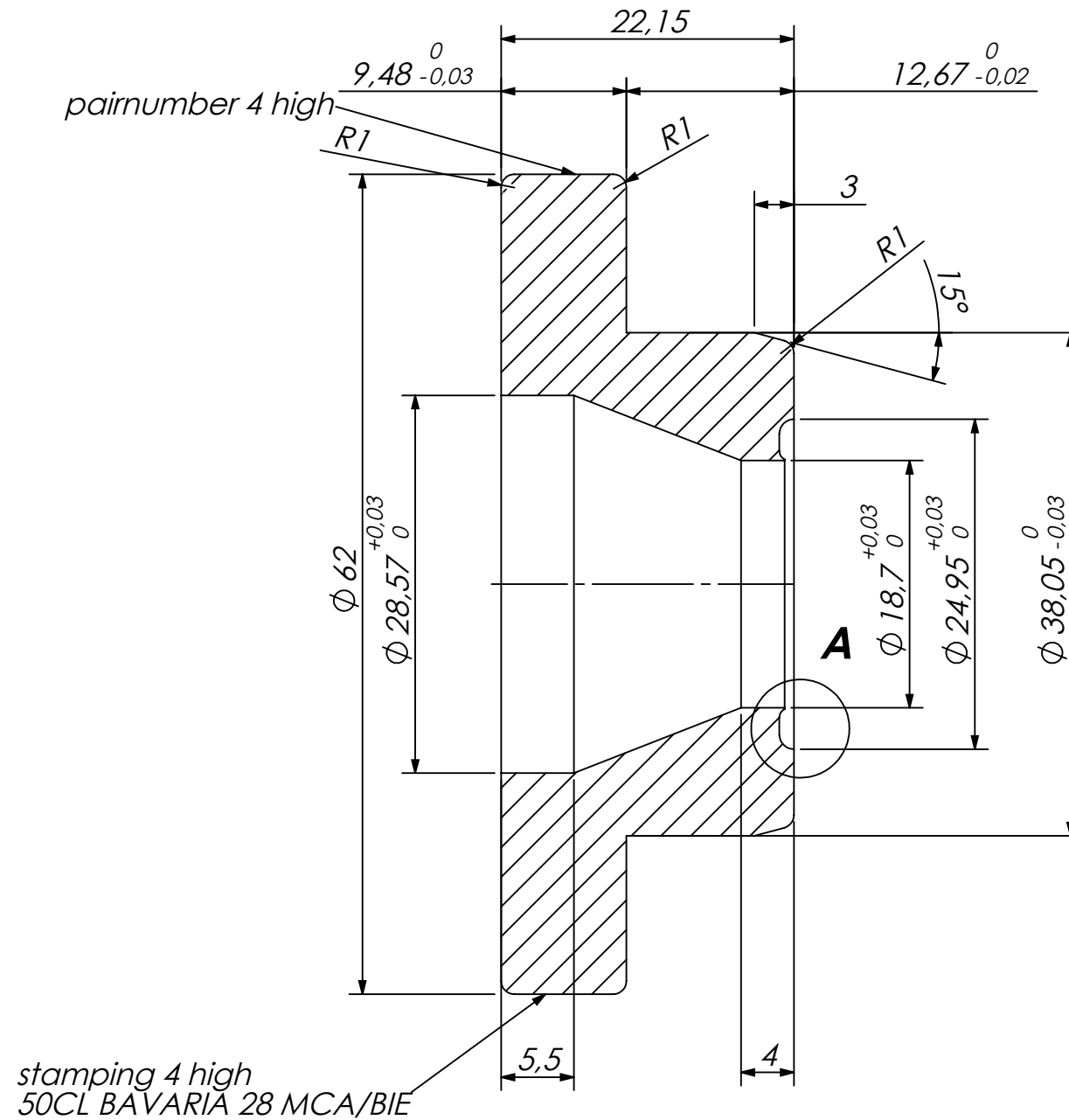


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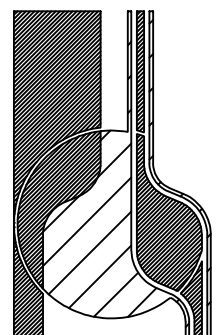
DO NOT SCALE DRAWING IF IN DOUBT ASK	
TOLERANCES UNLESS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 REMOVE BURRS & SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE	
	THIRD ANGLE PROJECTION
SURFACE FINISH CAST:  ROUGH  FINE  POLISH:	

JOB NAME		500ML BAVARIA	
ITEM	NECKRING	QUANTITY	100
CUSTOMER	ELIVOZO	REF. NO.	
ORDER NO.	20092181	DRAWN BY	JBB
MATERIAL	Bronze	CHECKED BY	
MACHINE	Emhart BB DG 5 1/2	DATE	31/07/2009
		REVISIONS	
		DRG No: BIEB243-15 MCA	



CAVITY FULLY HARD WELDED

INVERT CENTRE :  
'H' DIMENSION : -  
ASSEMBLY : -  
SCALE : 1:1

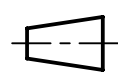


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B-8755 Ruiselede

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Fax.: +32(0)51 689182  
Email: info@biebouw.com

DO NOT SCALE DRAWING  
IF IN DOUBT ASK

TOLERANCES UNLESS OTHERWISE SPECIFIED  
DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05  
REMOVE BURRS & SHARP EDGES IN  
ACCORDANCE TO STANDARD PRACTICE



THIRD ANGLE  
PROJECTION

SURFACE FINISH  
CAST: ~ ROUGH: ~ FINE: ~ POLISH: ~

JOB NAME 500ML BAVARIA

ITEM GUIDE PLATE

QUANTITY 80

CUSTOMER ELIVOZO

REF. NO.

ORDER NO. 20092181

DRAWN BY JBB

MATERIAL Cast iron

CHECKED BY

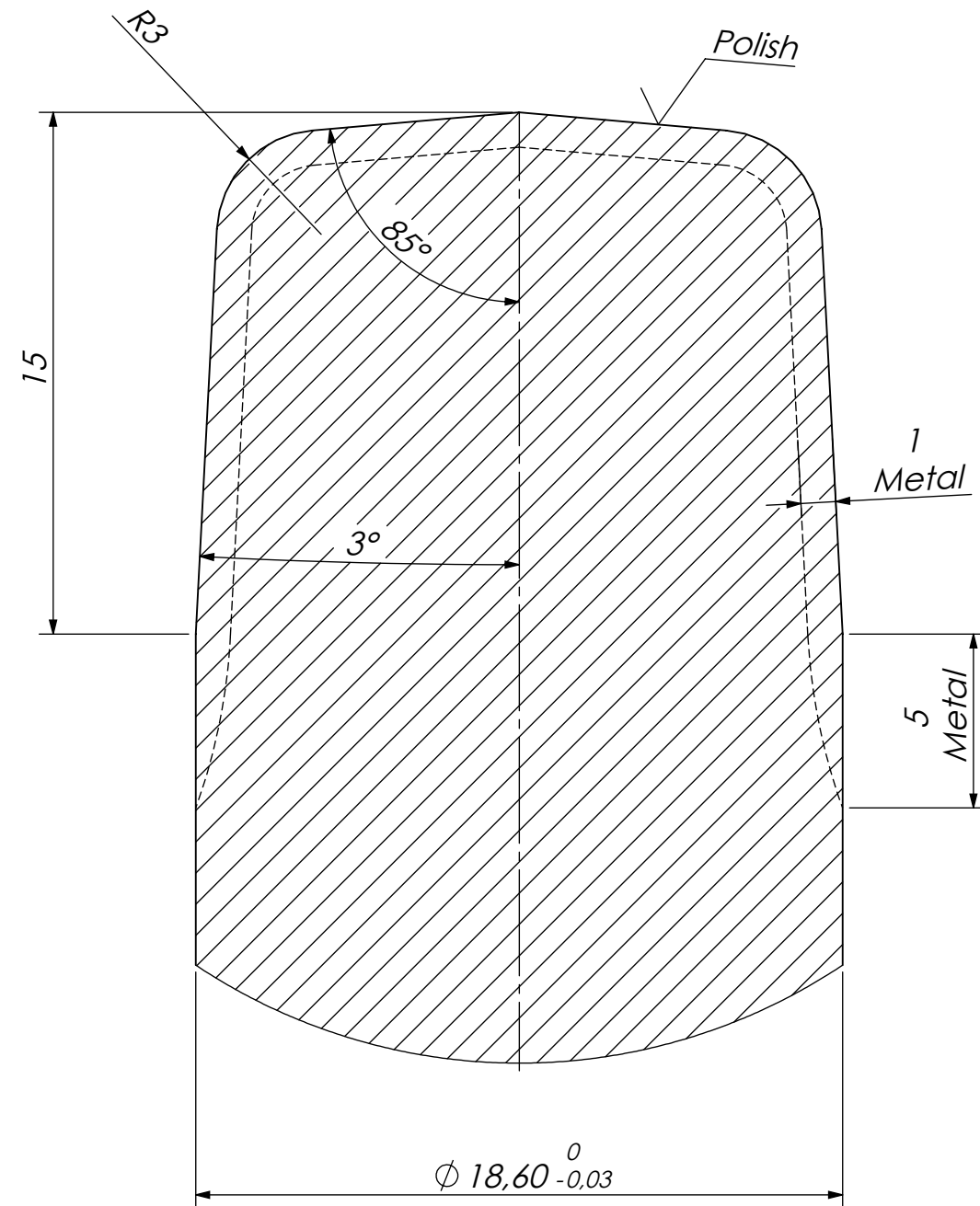
MACHINE Emhart BB DG 5 1/2

DATE 31/07/2009

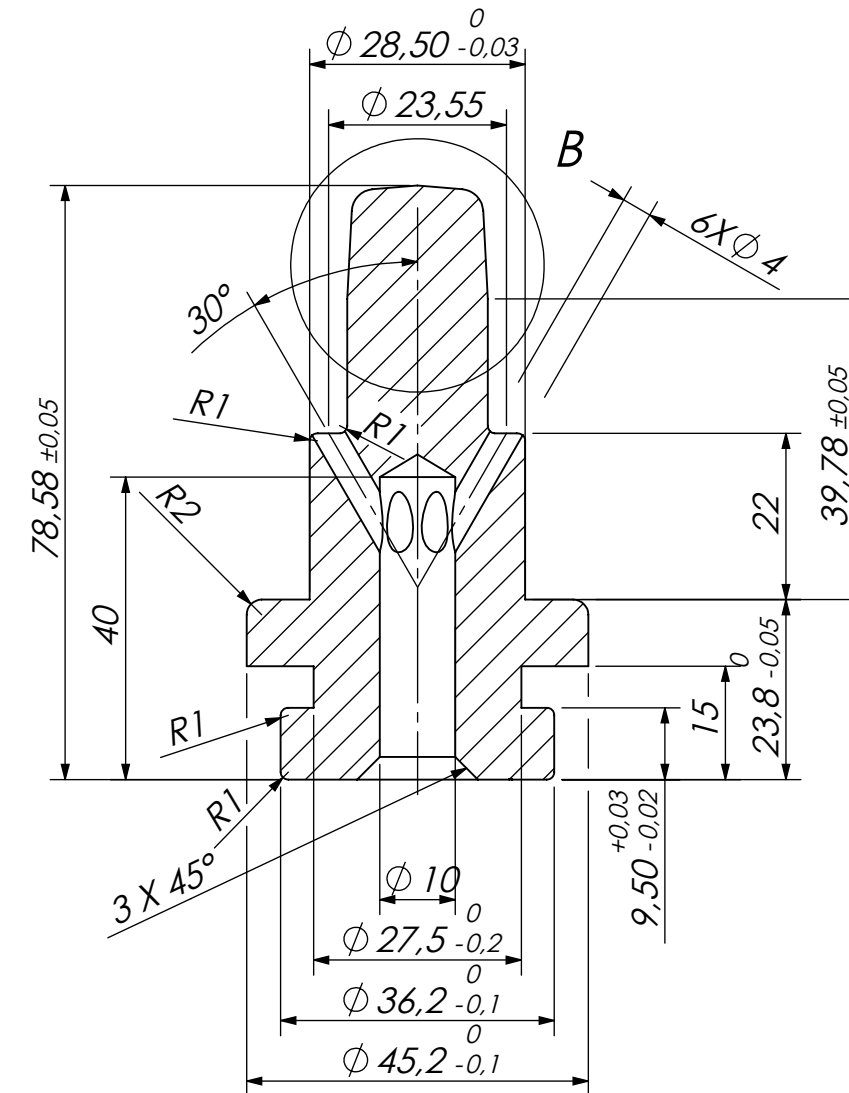
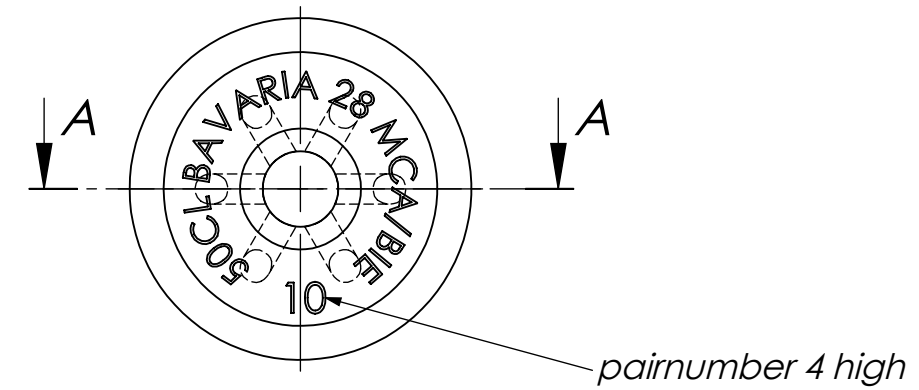
REVISIONS

DRG No: BIEB243-19 MCA

HARD WELD PLUNGER TIP 1 MM DEEP

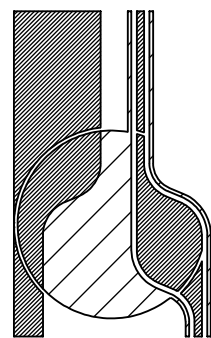


B (5:1)



SECTION A-A

INVERT CENTRE : -  
'H' DIMENSION : -  
ASSEMBLY : -  
SCALE : 1:1

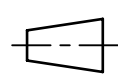


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DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05  
REMOVE BURRS & SHARP EDGES IN  
ACCORDANCE TO STANDARD PRACTICE



THIRD ANGLE  
PROJECTION

SURFACE FINISH  
CAST: ~ ROUGH: ~ FINE: ~ POLISH: ~

JOB NAME 500ML BAVARIA

ITEM PLUNGER

CUSTOMER ELIVOZO

ORDER NO. 20092181

MATERIAL Steel

MACHINE Emhart BB DG 5 1/2

QUANTITY 50

REF. NO.

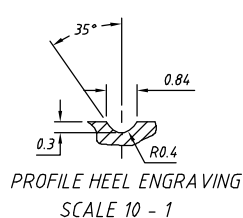
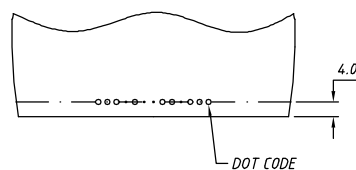
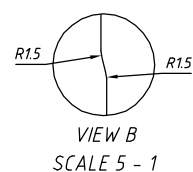
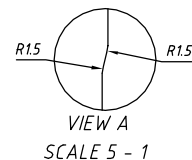
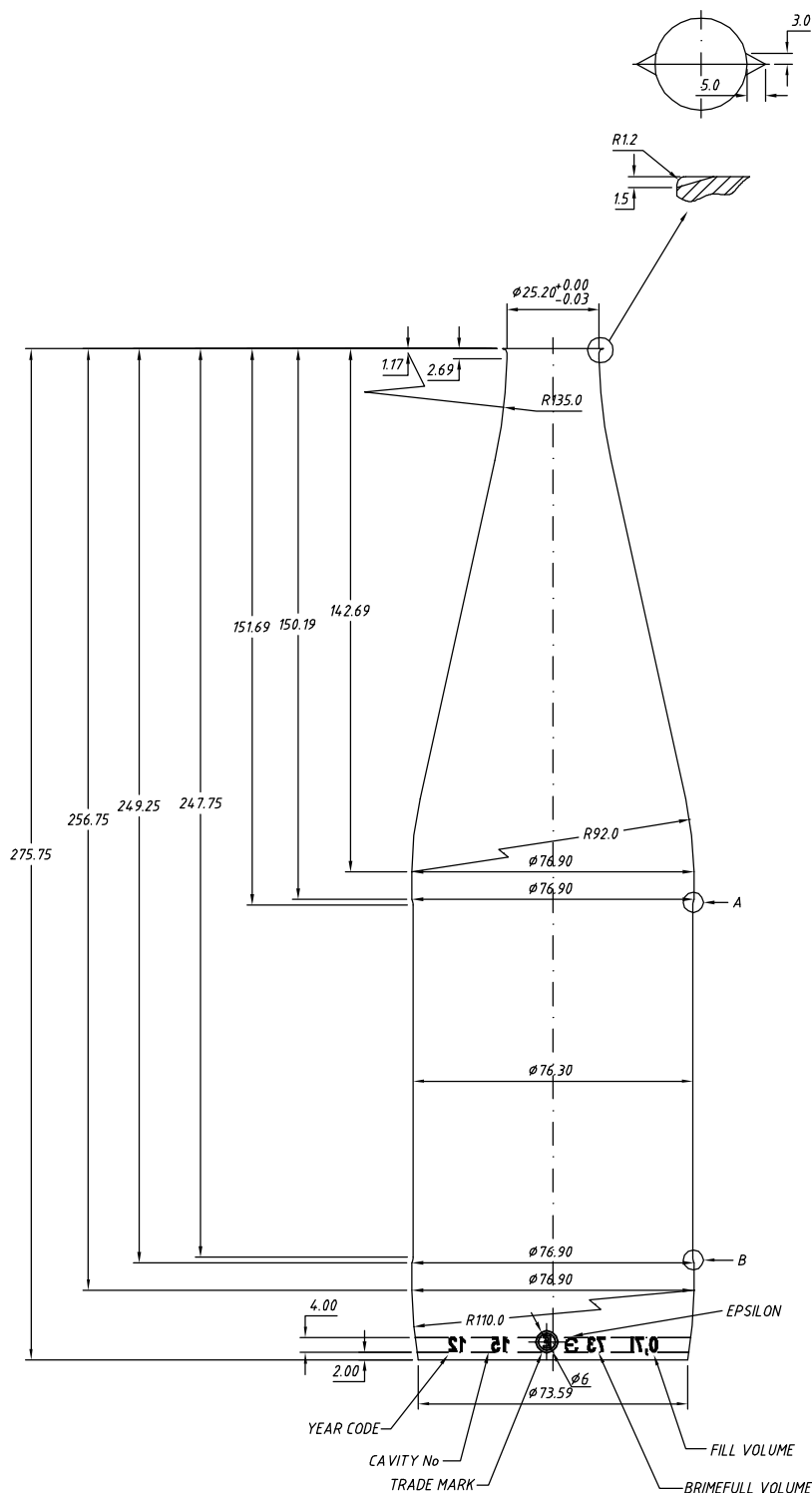
DRAWN BY JBB

CHECKED BY

DATE 31/07/2009

REVISIONS

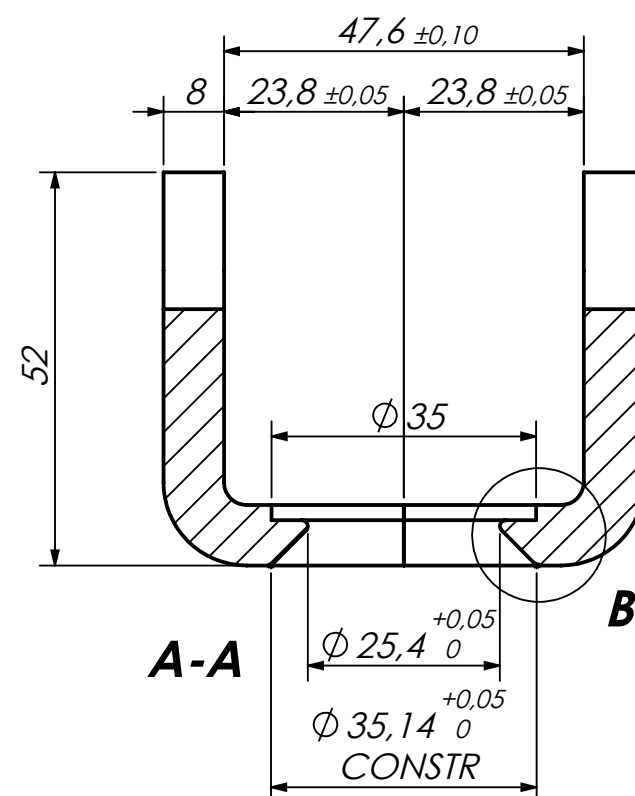
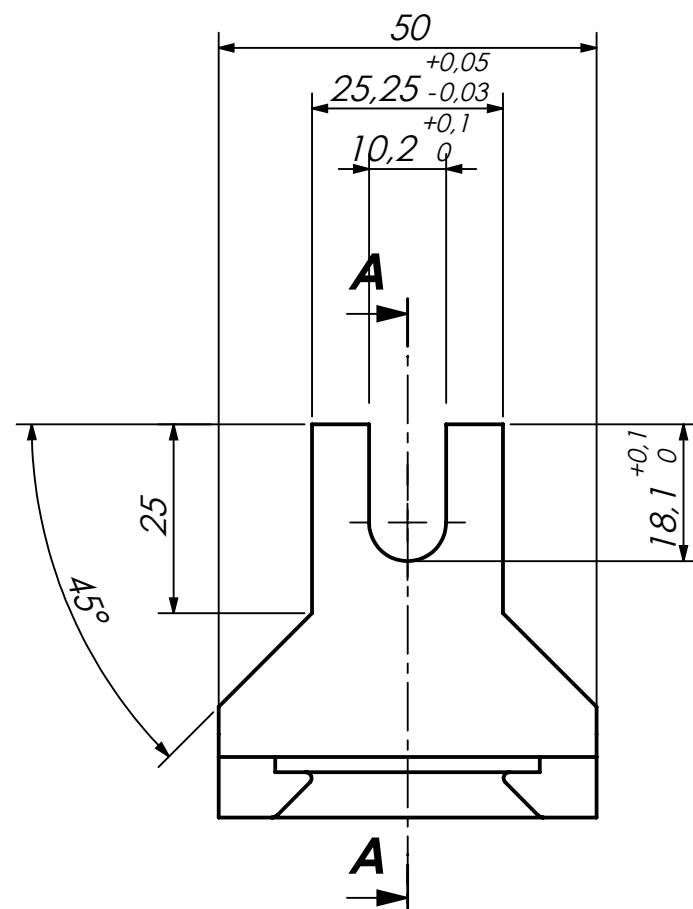
DRG No: BIEB243-20 MCA



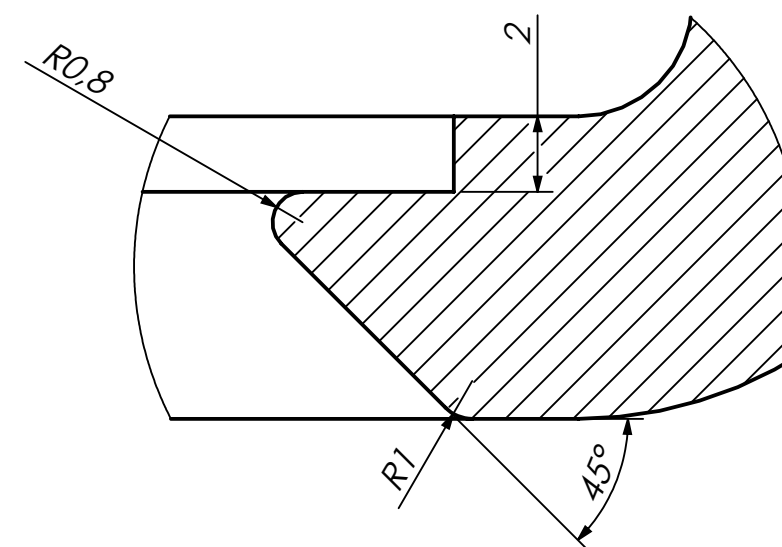
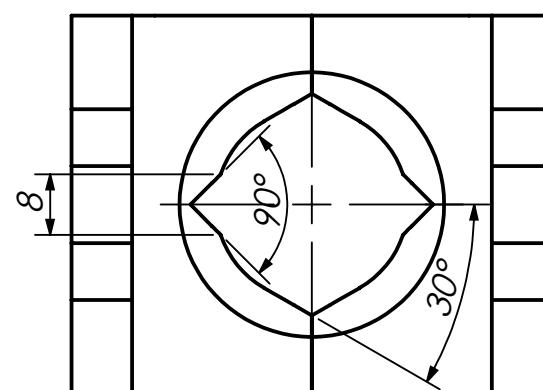
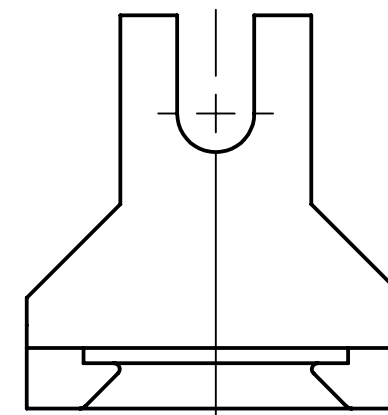
MOULD CAVITY VOLUME: 922,19ml  
 BOTTOM VOLUME: 7,07ml  
 TOTAL VOLUME: 929,26ml

Перв. примен.		Формат	Зона	Поз.	Обозначение	Наименование	Кол.	Прим.		
Справ. №										
						<u>Документация</u>				
						Теоретические чертежи				
	A3			FKE1895-04	Профиль пульки	1				
	A3			FKE1895-07	Профиль чистовой формы	1				
	A3			FKE1895-13	Профиль черновой формы	1				
	A3			FKE1895-11	Штрих-код	1				
						1				
						1				
					<u>Детали</u>					
	A1			FKE1895-05	Форма чистовая	1				
	A3			FKE1895-10	Поддон чистовой формы	1				
	A1			FKE1895-12	Форма черновая	1				
	A3			FKE1895-14	Поддон черновой формы	1				
Подп. и дата	A3			BIEB 243-15MCA	Кольцо горловое	1				
	A3			BIEB 243-19MCA	Кольцо прессующее	1				
	A3			BIEB 243-20MCA	Плунжер	1				
	A3			BIEB 243-30-A	Втулка плунжера	1				
Инв. № дубл.	A3			FKE1895-25	Воронка приемная	1				
	A3			BIEB 243-23-A MCA	Головка дутьевая	1				
	A3			BIEB 243-24	Хватки	1				
	A2			FKE1895-41	Плита охлаждения	1				
Взам. инв. №										
Подп. и дата										
Инв. № подл.						FKE1895-00-00				
	Изм	Лист	?	докум.	Подп.	Дата	Формокомплект БУТЫЛКИ XI-28-MCA-700 (BADEN 700ml)		СЗАО "Стеклозавод Елизово"	
	Разраб.	Позднякова			19.05.14					
	Пров.									
	Утв.	Дудко								





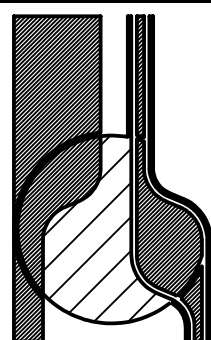
Engrave  
50CL BAVARIA/BIE



**APROVED**  
**06/11/2009**

**B (5 : 1)**

INVERT CENTRE : -  
'H' DIMENSION : -  
ASSEMBLY : -  
SCALE : 1:1

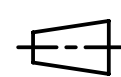


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ACCORDANCE TO STANDARD PRACTICE



THIRD ANGLE  
PROJECTION

SURFACE FINISH  
CAST: ~ ROUGH: ▽ FINE: ▽ POLISH: ▽

JOB NAME 500ML BAVARIA

ITEM TAKE OUT TONGUE

QUANTITY 40

CUSTOMER ELIVOZO

REF. NO.

ORDER NO. 20092181

DRAWN BY JBB

MATERIAL Bronze

CHECKED BY

MACHINE Emhart BB DG 5 1/2

DATE 6/11/2009

REVISIONS

DRG No: BIEB243-24