

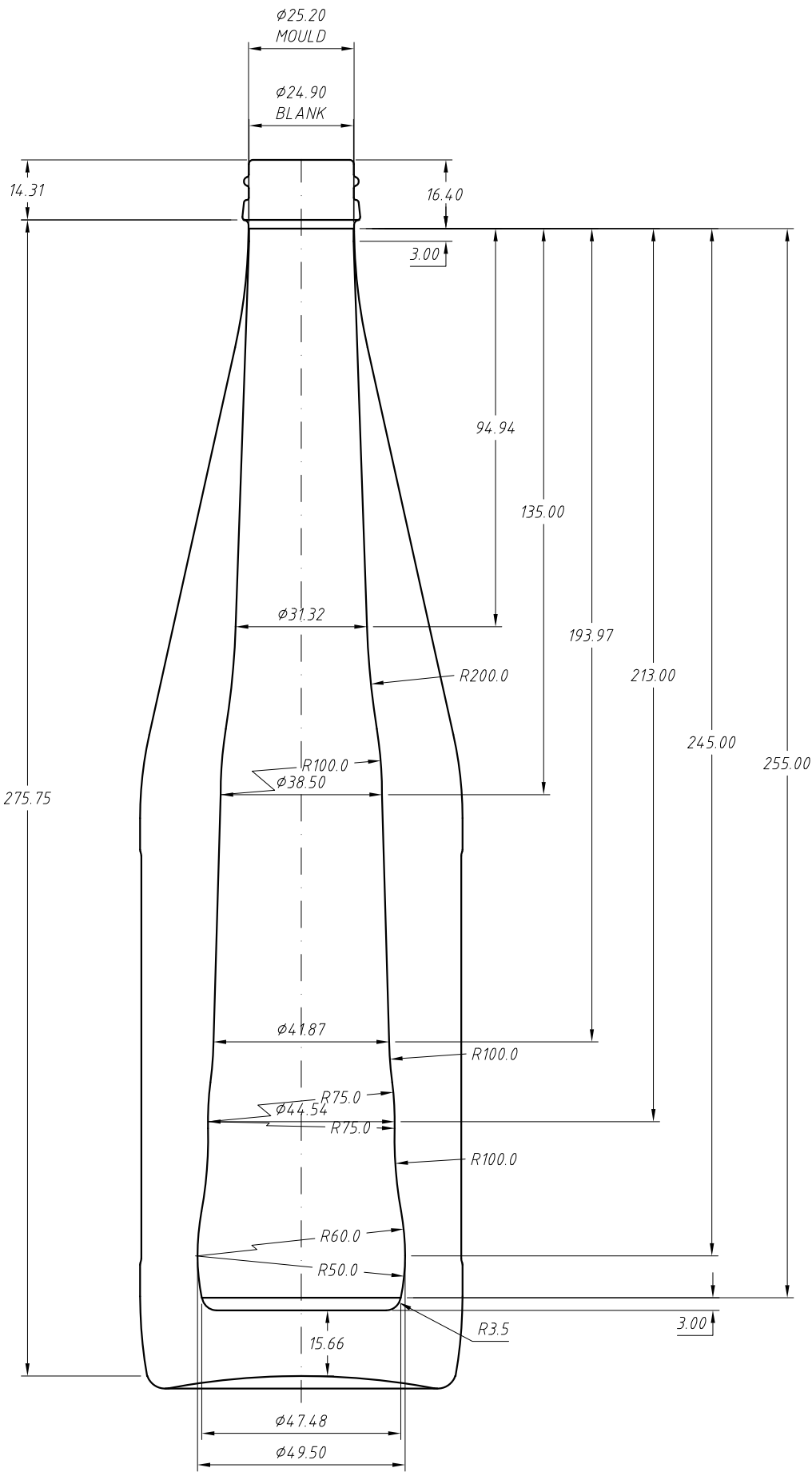
SPECIFICATION DATA	
WEIGHT: 490,0 grm	COLOUR: FLINT
FINISH: MCA 2	
FILLING CAPACITY:	700,0ml
BRIMFULL CAPACITY:	730,0ml
HEIGHT CONTRACTION CONSTANT:	1.0045
MOULD NECK DIAMETER:	25,20
BLANK NECK DIAMETER:	24,90
RING NECK DIAMETER:	25,00
TAKE OUT TONGS DIAMETER:	25,40

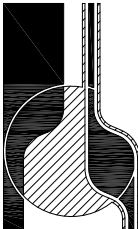
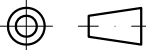





BLOW MOULD DISPLACEMENT		
	ml	g @ 20°
BRIMFULL CAPACITY	730,00	727,96
+ WEIGHT x 0.403 CONSTANT	197,47	196,92
= CONTAINER DISPLACEMENT	927,47	924,88
+ 1,01% SINKAGE & SHRINKAGE	9,37	9,34
= TOTAL DISPLACEMENT	936,84	934,22
– RING CAST HEIGHT DISPLACEMENT	7,58	7,56
= MOULD & BOTTOM DISPLACEMENT	929,26	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	



 © BIEBOUW B.V.B.A. Industriestraat 17 B-8755 Ruiselede Belgium Tel.: +32 (0)51 686714 Fax.: +32 (0)51 689182 Email: info@biebouw.com	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		
	 THIRD ANGLE PROJECTION	CUSTOMER	SYSTEMPACK	REF. NO.		
	 SURFACE FINISH CAST:  ROUGH:  FINE:  POLISH: 	ORDER NO.	20120352	DRAWN BY	F.KARLSEN	REVISIONS
		MATERIAL		CHECKED BY		DRG. NO. FKE1895 - 04
		MACHINE	EM IS DG BB 5,5"	DATE	14.02.2012	