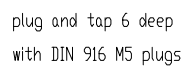


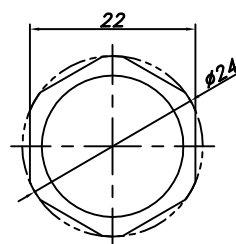
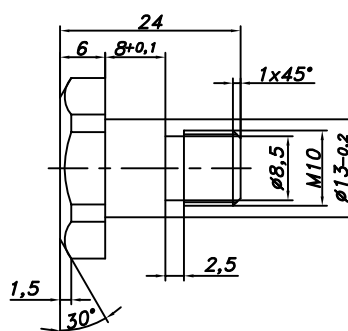




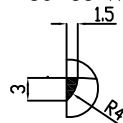
XXI-B-30-4B-500-14			
BLANK CAVITY			
SCALE	DRAWING NO.		
1:1	XXI-B-30-4B-500-14 -BMC-A1		
DRAW		CHECKED	APPROVED
10/10/2019			



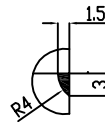
⑤



NECK RING END  
COLMOMONROY DETAIL  
30-35 HRc



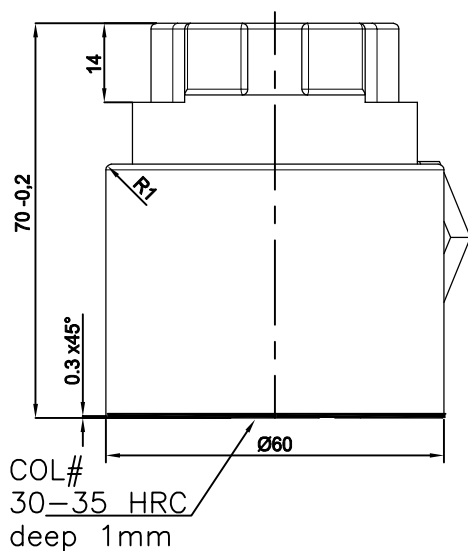
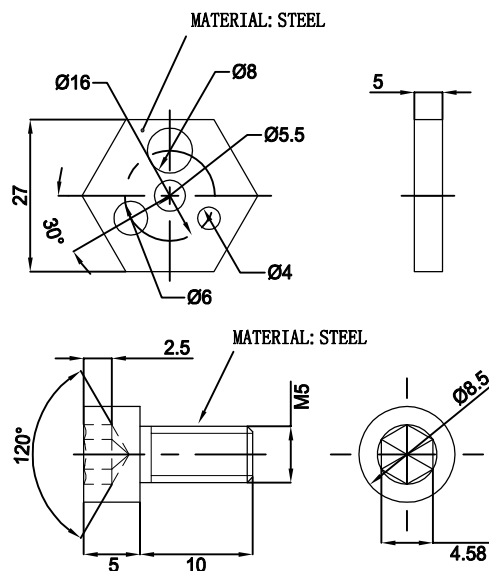
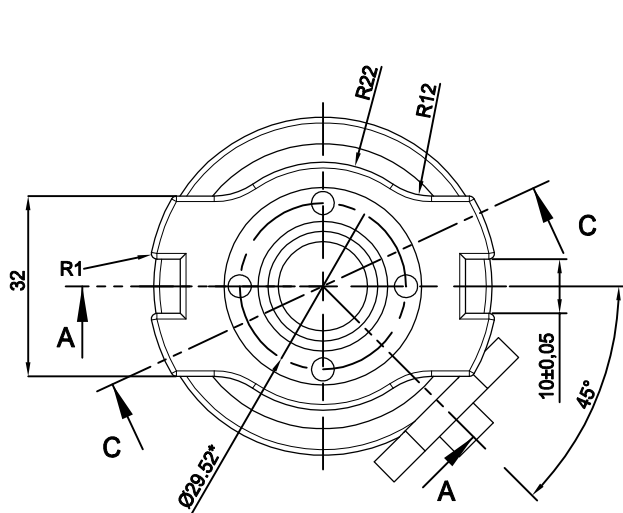
BAFFLE END  
COLMOMONROY DETAIL  
30-35 HRc



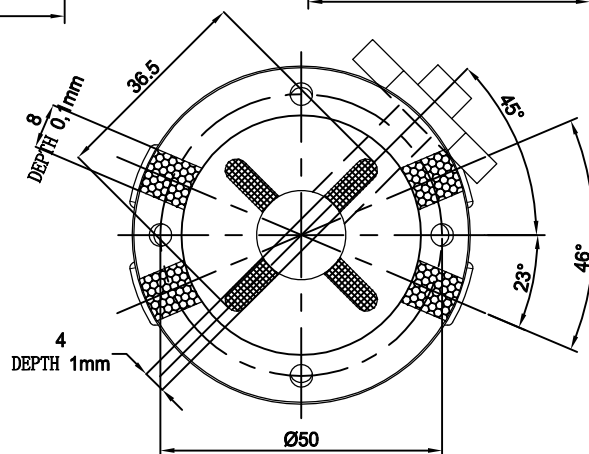
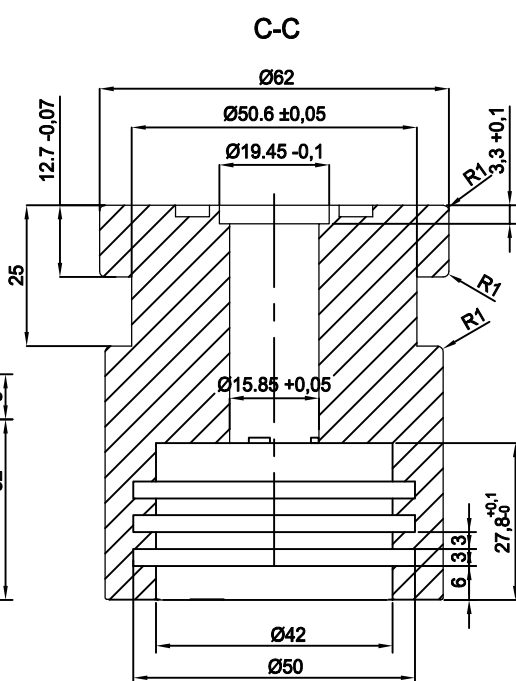
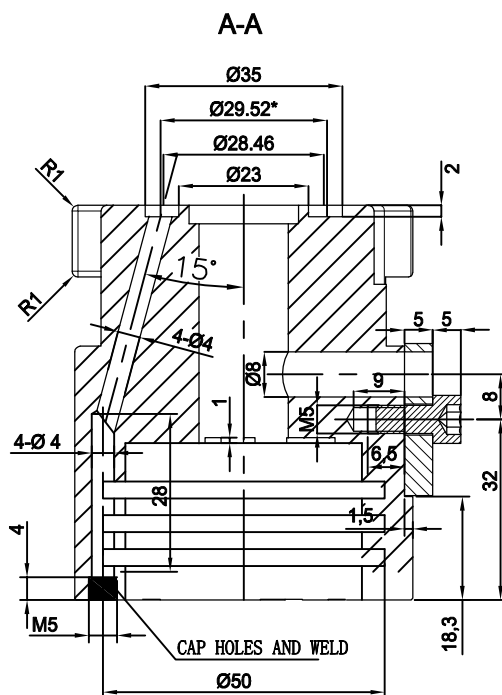
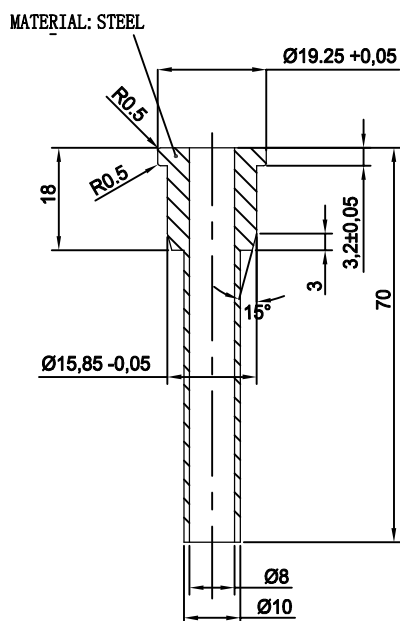
XXI-B-30-45-500-14 BLANK MOULD			
WEIGHT		380±10g	
BRIMFUL CAPACITY		520±10ml	
FILL POINT CAPACITY		500±10ml	
SCALE		DRAWING NO.	
1:1		XXI-B-30-45-500-14 -BM-A1	
DRAW		CHECKED	APPROVED
10/10/2019			
MATERIAL		CAST IRON	

MACHINE TYPE	Emhart DG 52	10/10/2019		
HOLDER SIZE	#23			
INVERT	90	MATERIAL	CAST IRON	
"H" DIM.	117.5			





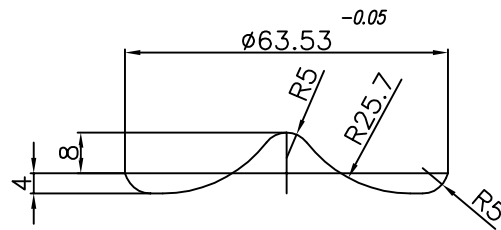
COL#  
30-35 HRC  
deep 1mm



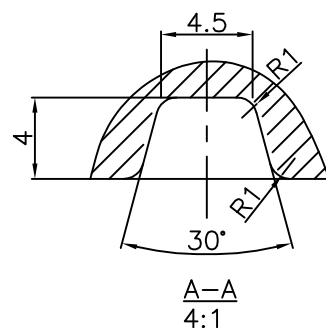
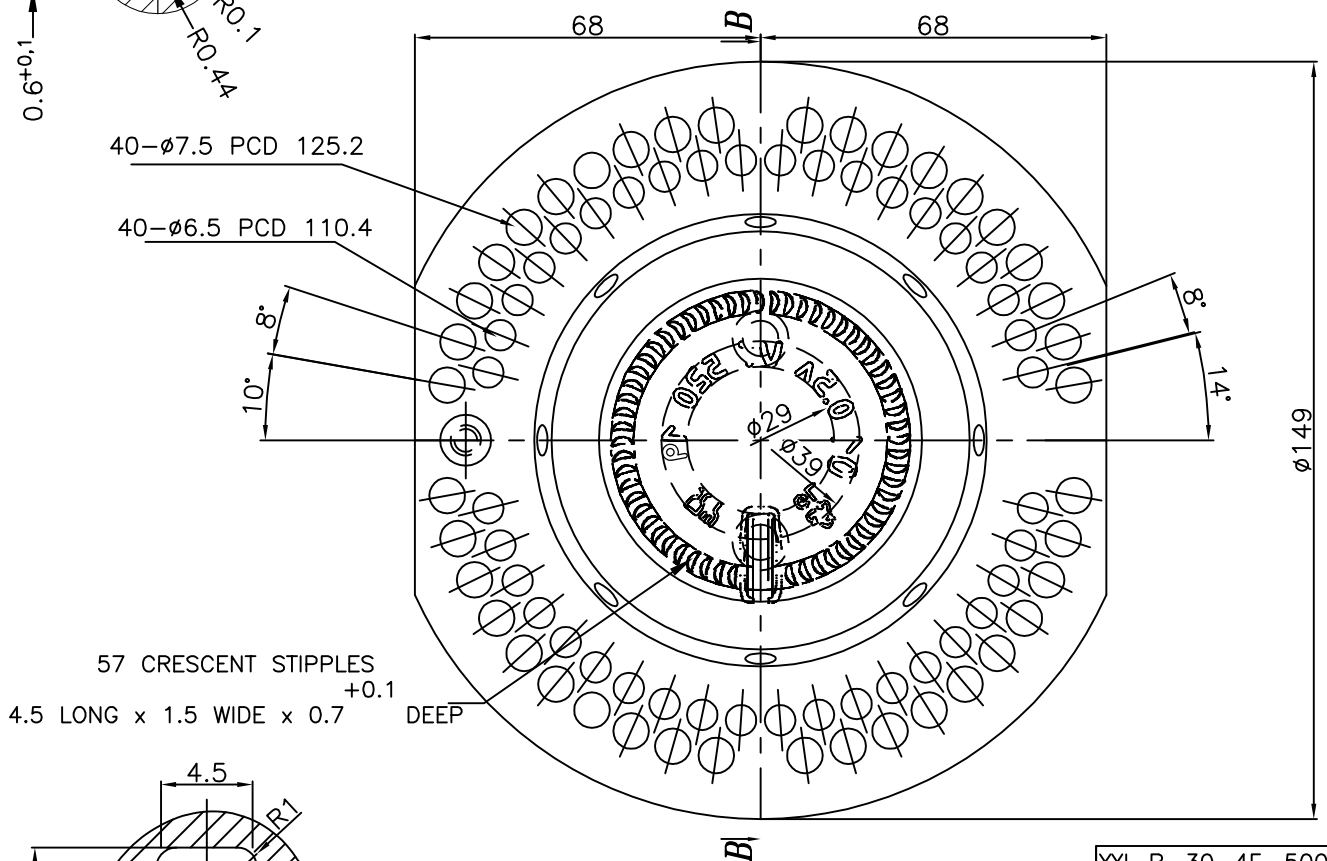
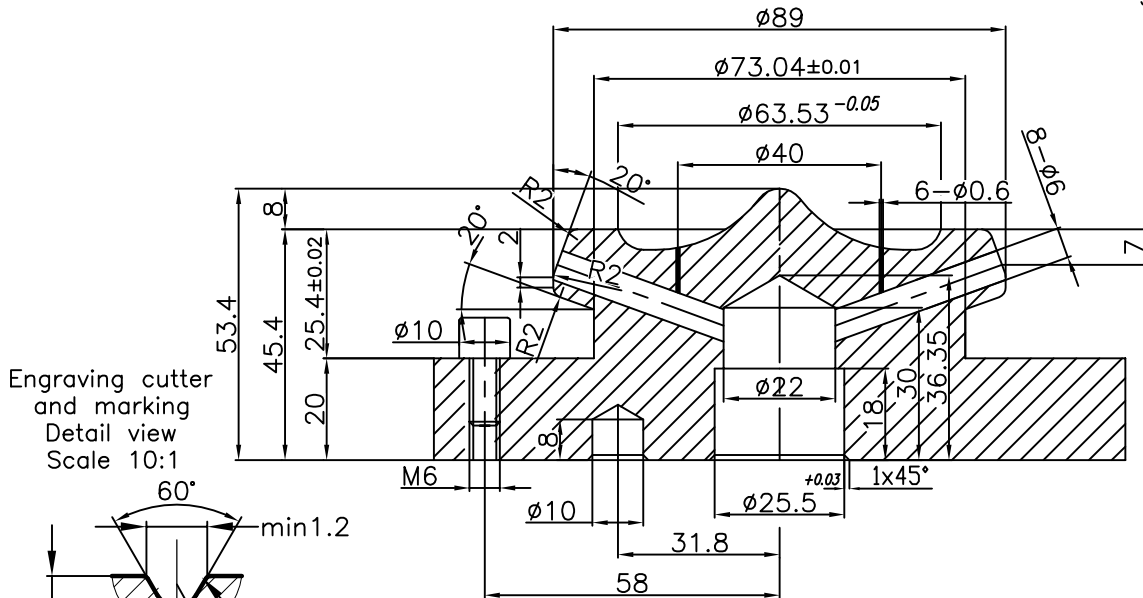
ENGRAVE: БАТЬКОВА 0,5  
MOULD NO.  
(S)

XXI-B-30-45-500-14 BLOW HEAD		
SCALE 1:1	DRAWING NO. XXI-B-30-45-500-14 -BH-A1	
DRAW	CHECKED	APPROVED
10/10/2019		
MATERIAL	CAST IRON	





R2.50  
COLMONOY DETAILS  
SCALE 2:1  
30-45 HRc



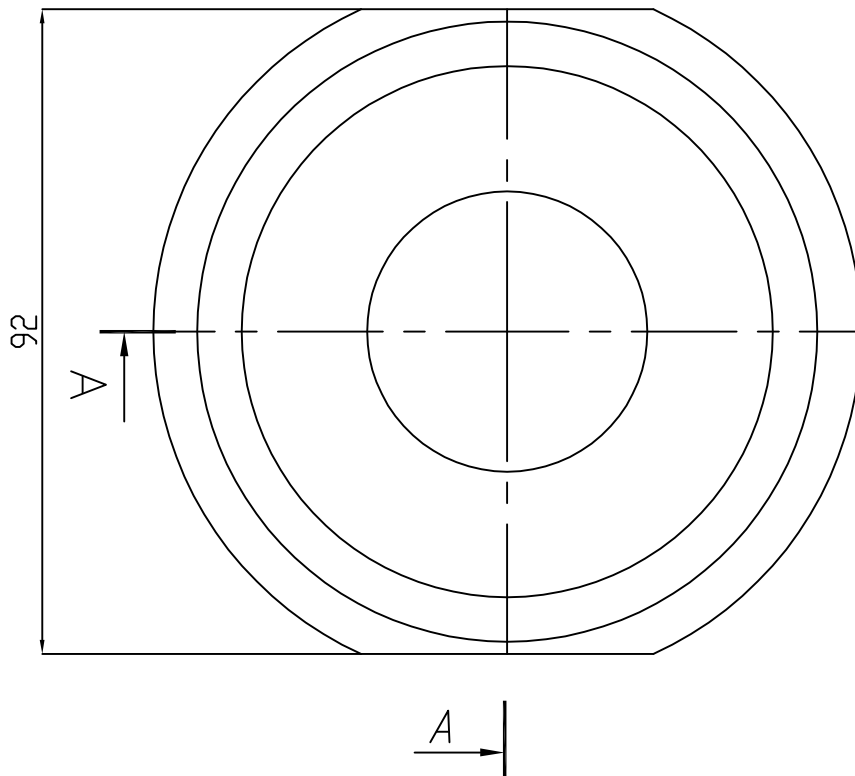
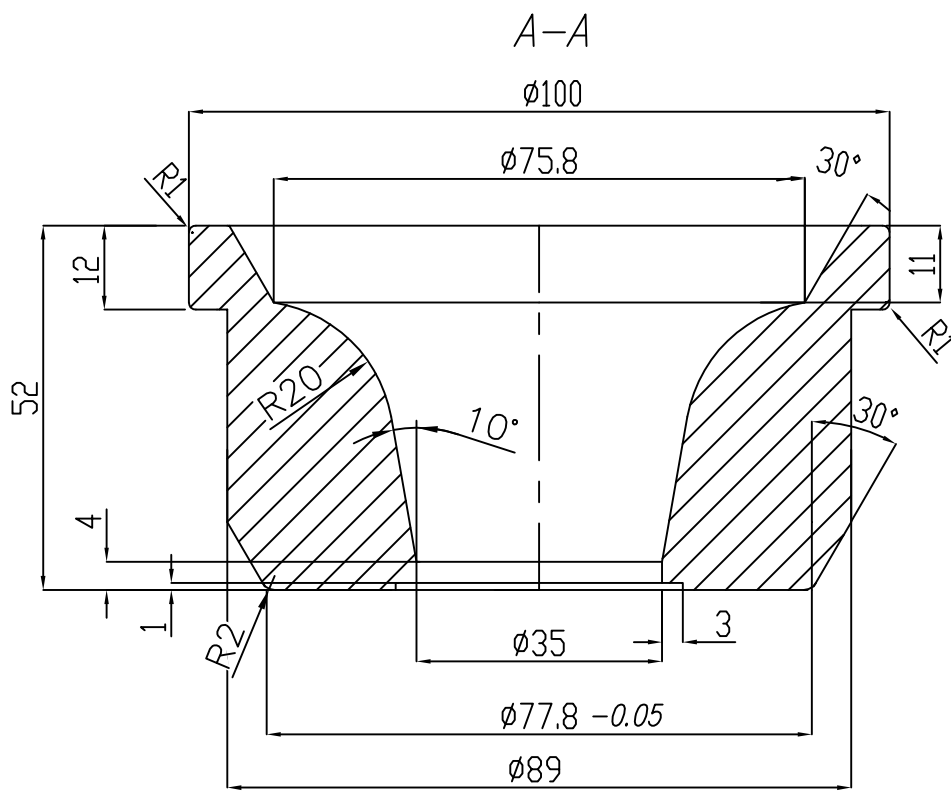
ENGRAVE: БАТЬКОВА 0,5  
MOULD NO.

Ⓢ

XXI-B-30-45-500-14 BOTTOM PLATE		
SCALE 1:1	DRAWING NO. XXI-B-30-45-500-14 -BP-A1	
DRAW 05/12/2019	CHECKED	APPROVED
MATERIAL	BRONZE	



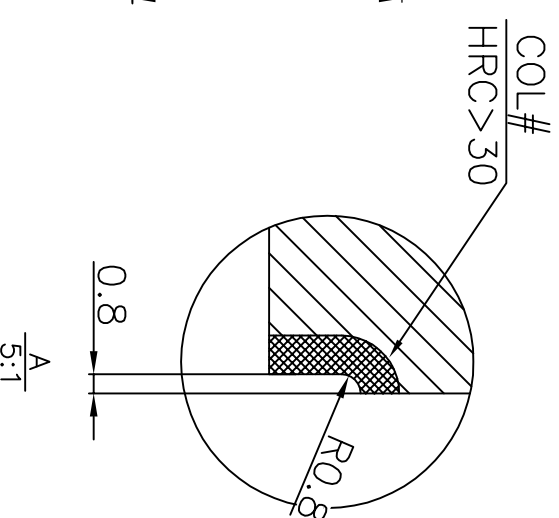
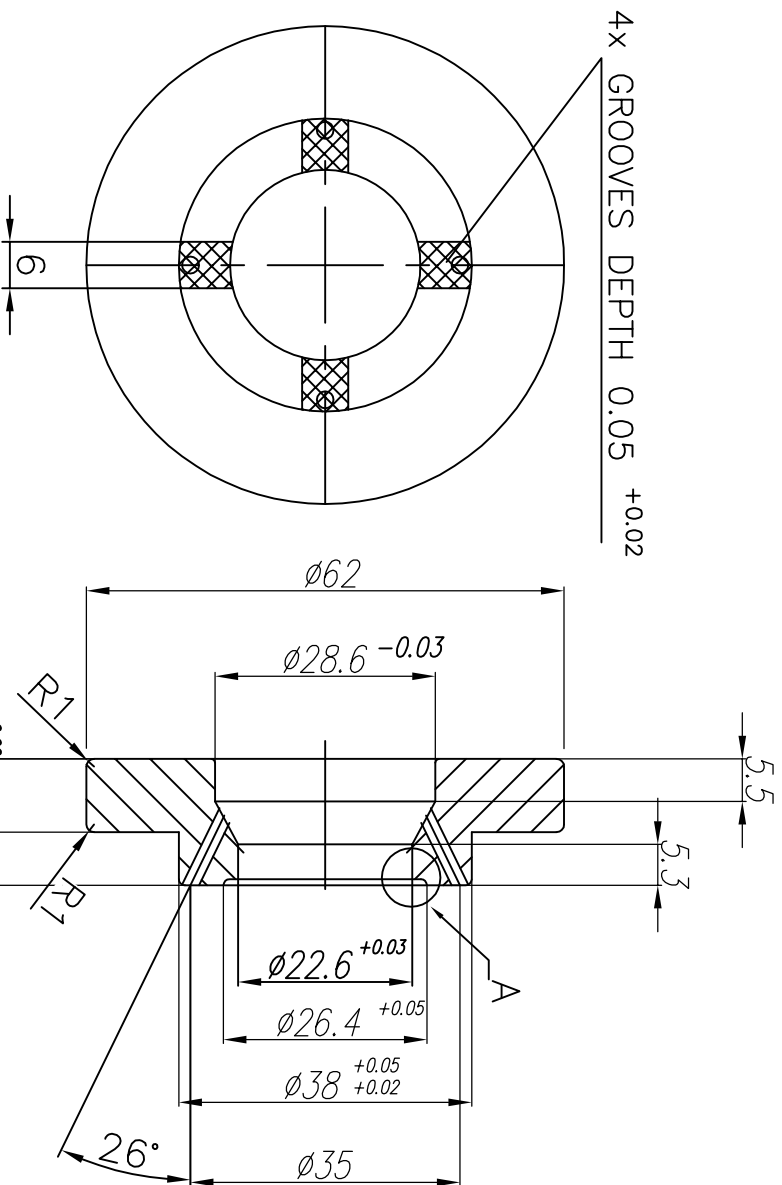




ENGRAVE: БАТЬКОВА 0,5  
MOULD NO.

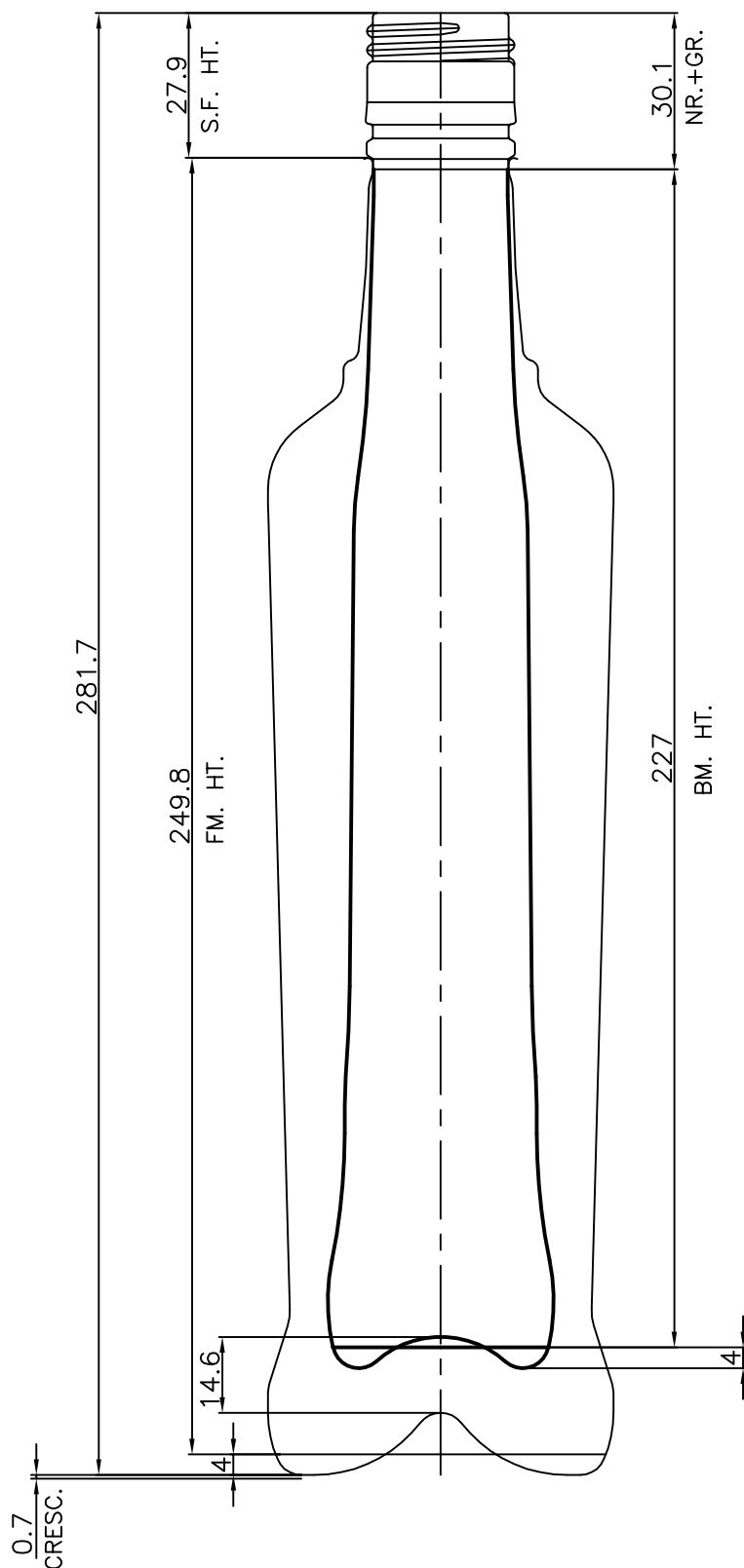
Ⓢ

XXI-B-30-4B-500-14		
FUNNEL		
SCALE	DRAWING NO.	
1:1	XXI-B-30-4B-500-14	
	-FU-A1	
DRAW	CHECKED	APPROVED
10/10/2019		
MATERIAL	CAST IRON	



ENGRAVE: БАТБКОВА 0,5  
 MOULD NO. ⑤

XXI-B-30-45-500-14			
GUIDE PLATE			
SCALE		DRAWING NO.	
1:1		XXI-B-30-45-500-14 -GP-A2	
DRAW	CHECKED	APPROVED	
10/10/2019			
MATERIAL	CAST IRON		

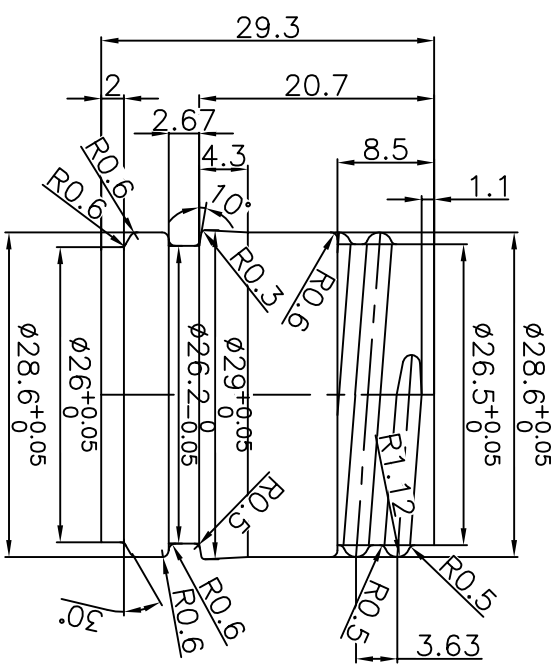
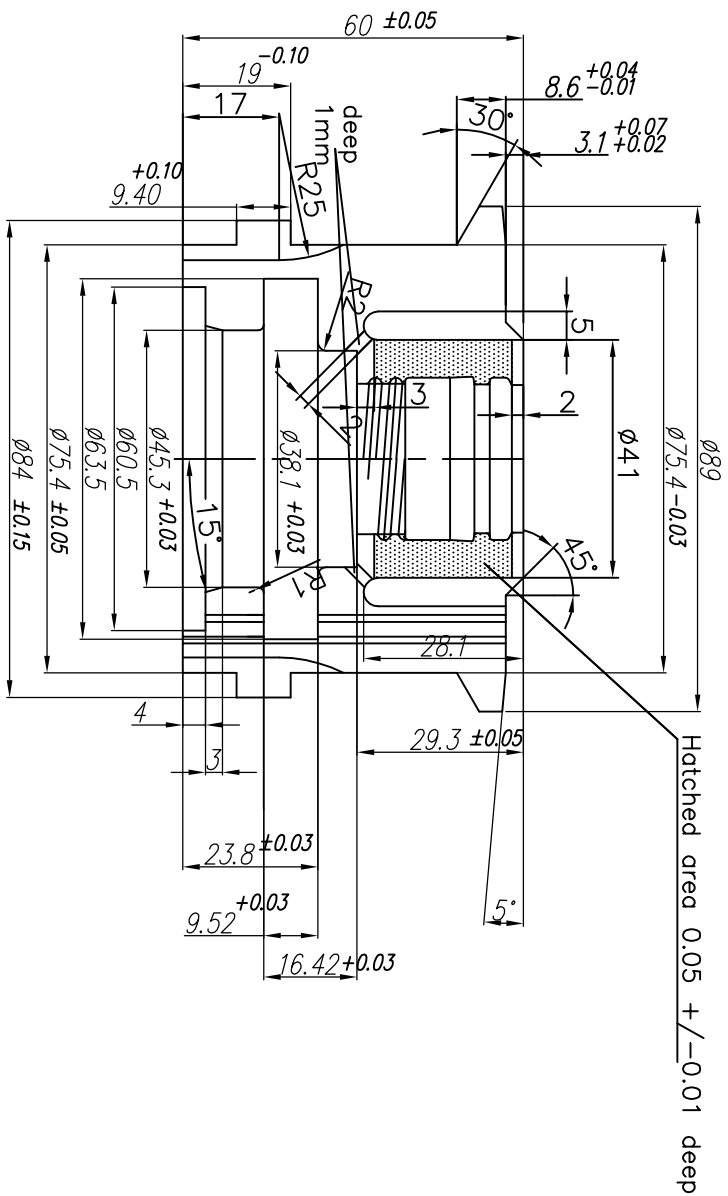


FINISH:	
BLOW NECK	ø26.2
BLANK NECK	ø25.8
RING NECK	ø26
TONG NECK	
BLOW NECK RAD	R1
BLOW HEAD DEPTH	28.2

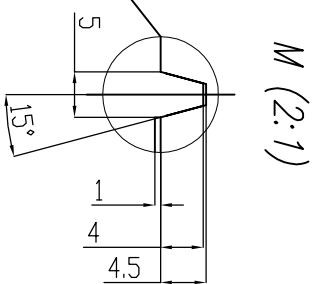
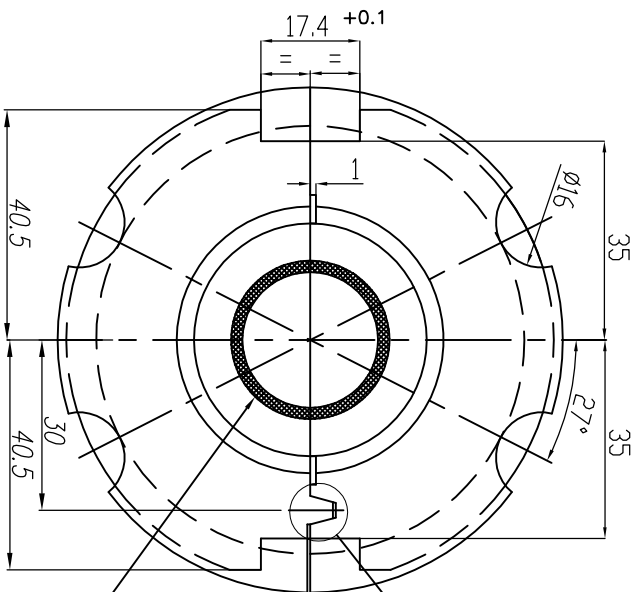
BLANK MOULD	
WEIGHT HOT GLASS FACTOR	380 g x0.41
GOB CAPACITY	155.8 ml
OVERCAP 44%	+68.6 ml
NR NOL - PL VOL	-14 ml
18	4
CALC. BLK+BA DISPL.	210.4 ml
'L' RATIO	
CAP. TO SETTLE LINE	ml
S.L.HT. FROM NR LINE	mm
INVERT	90 mm
"H" DIM.	117.5 mm
HOLDER SIZE	#23

BLOW MOULD	
WEIGHT COLD CLASS FACTOR	380 g x0.4
CAP. TO O'FLOW	152 ml +520 ml
SHRINKAGE (1.5%)	672 ml x1.01
DISPL. OF SEATED FIN. ABOVE MOULD	678.8 ml -16.8 ml
MLD + BP DISPL.	662 ml
INVERT	90 mm
"H" DIM.	57.15 mm
HOLDER SIZE	#53

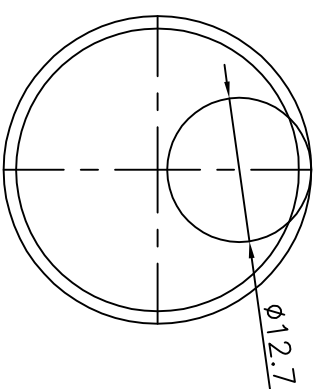
XXI-B-30-45-500-14			
WEIGHT		380±10g	
BRIMFUL CAPACITY		520±10ml	
FILL POINT CAPACITY		500±10ml	
FINISH TYPE:			
SCALE		MACHINE TYPE:	
1:1		Emhart DG 5 <sub>2</sub> "	
DRAW		CHECKED	APPROVED
10/10/2019			



SCALE 2 : 1



M (2:1)



ENGRAVE: БАНКОБА 0,5  
MOULD NO.

COL #  
HRC>30

⑤

XXI-B-30-45-500-14	
NECKRING	
SCALE	DRAWING NO.
1:1	XXI-B-31-45-500-14
DRAW	CHECKED APPROVED
10/10/2019	
MATERIAL	BRONZE

⑤

