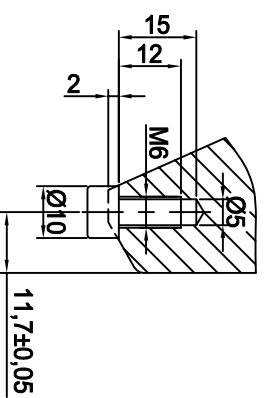
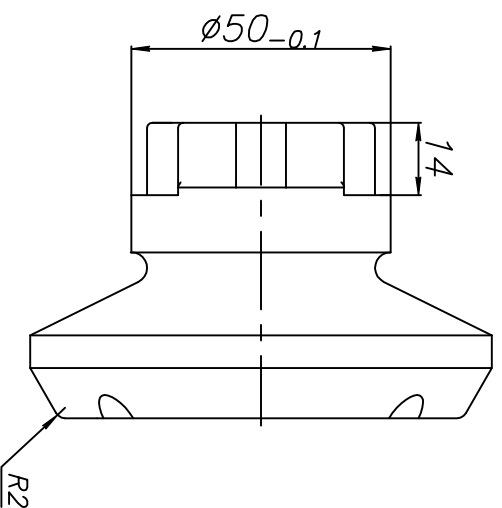


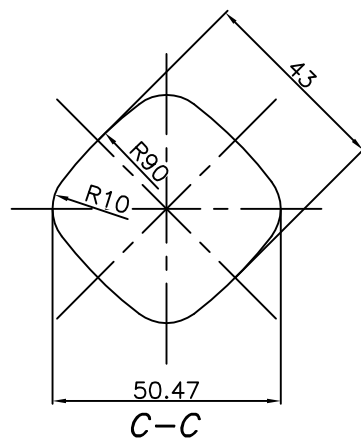
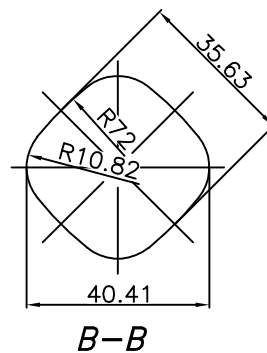
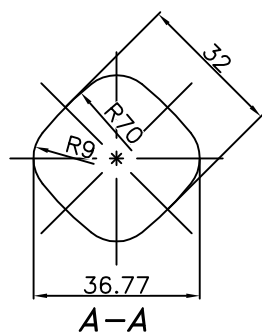
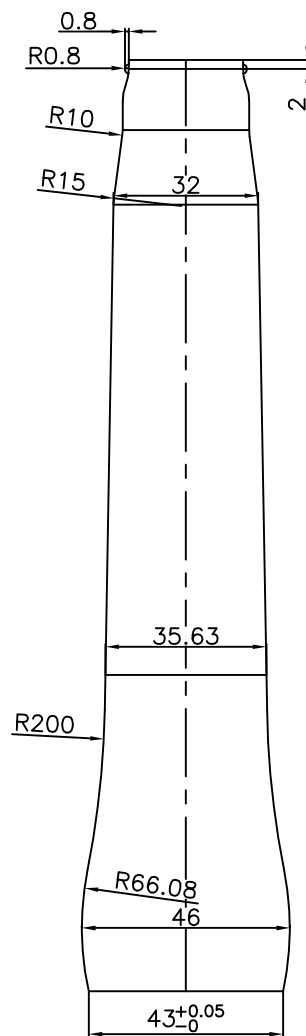
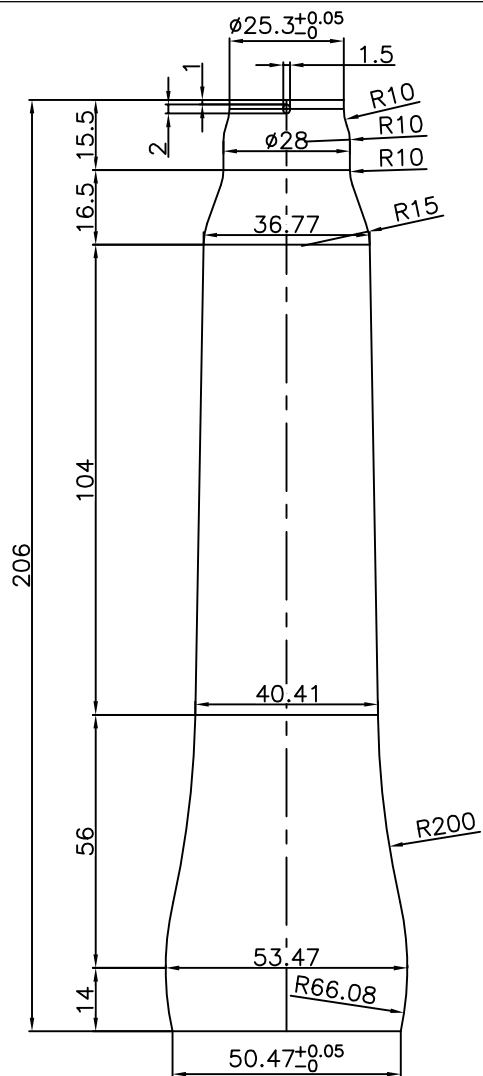
ENGRAVE: XXI-KTM-26-4-500-10
MOULD NO.

⑤



R2.50
COLUMN DETAIL S
SCALE 2:1

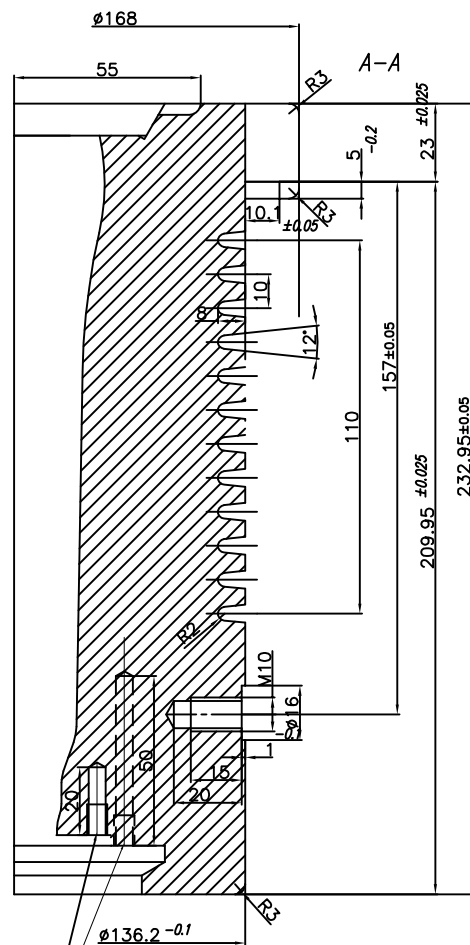
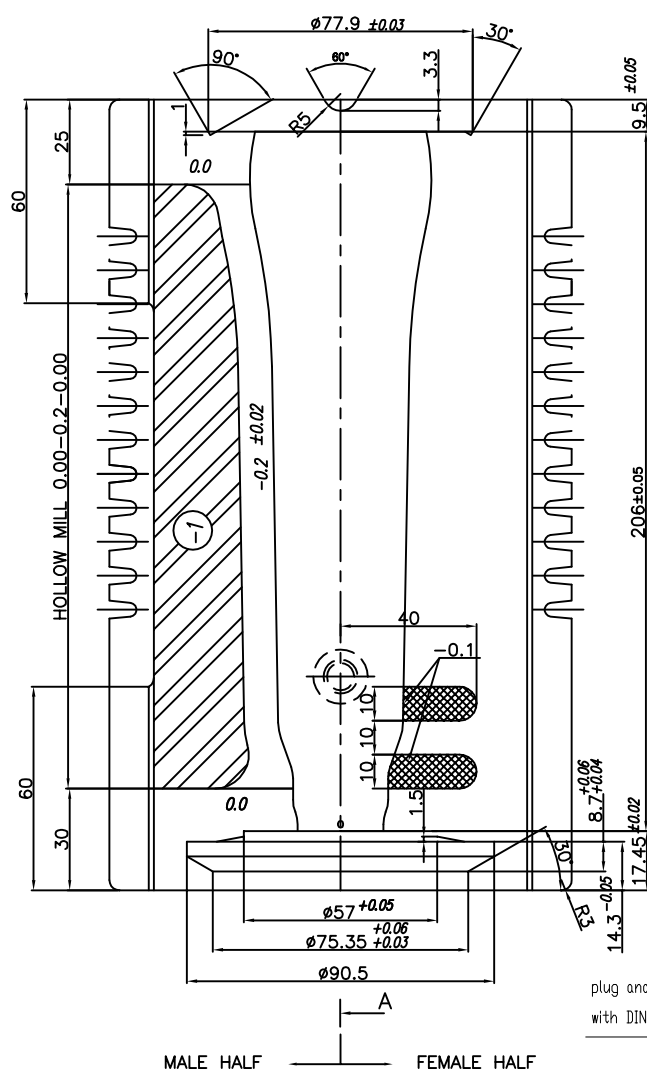
XXI-KTM-26-4-500-10			
BAFFLE			
SCALE	DRAWING NO.		
1:1	XXI-KTM-26-4-500-10 -BA-A1		
DRAW	CHECKED	APPROVED	
10/10/2019			
MATERIAL	CAST IRON		



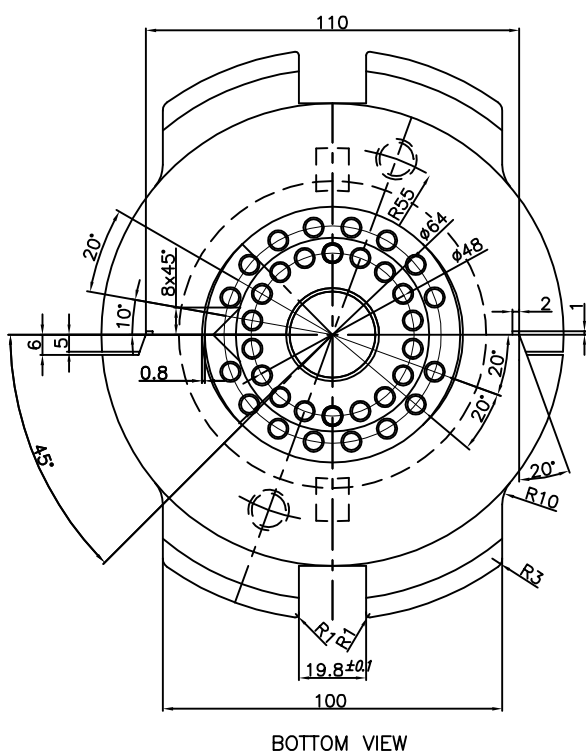
CALC. BM+BA DISPL. 239±1ml

XXI-KPM-26-4-500-10
BLANK CAVITY

SCALE	DRAWING NO.		
	XXI-KPM-26-4-500-10 -BMC-A1		
1:1	DRAW	CHECKED	APPROVED
	10/10/2019		

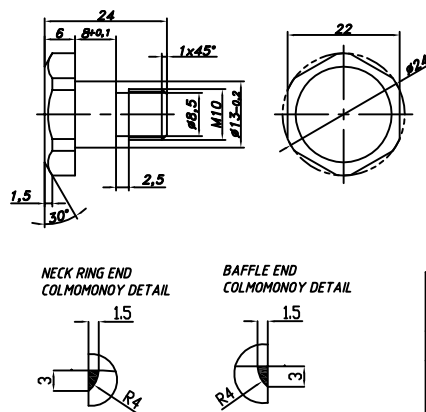


plug and tap 6 deep
with DIN 916 M5 plugs

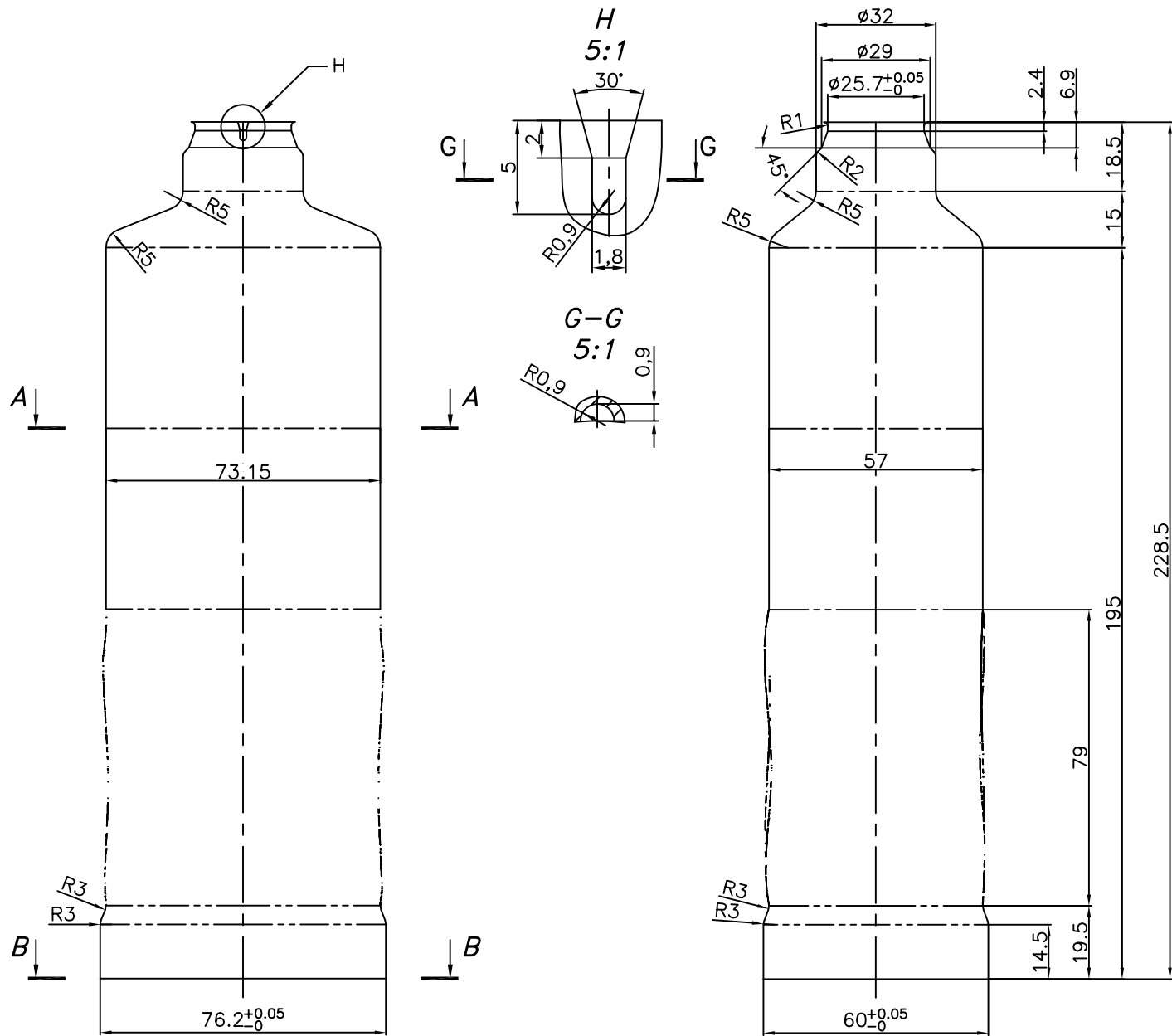


ENGRAVE: XXI-KPM-26-4-500-10
MOULD NO.

(S)

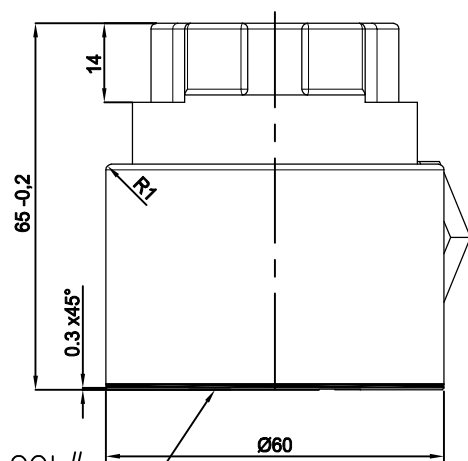
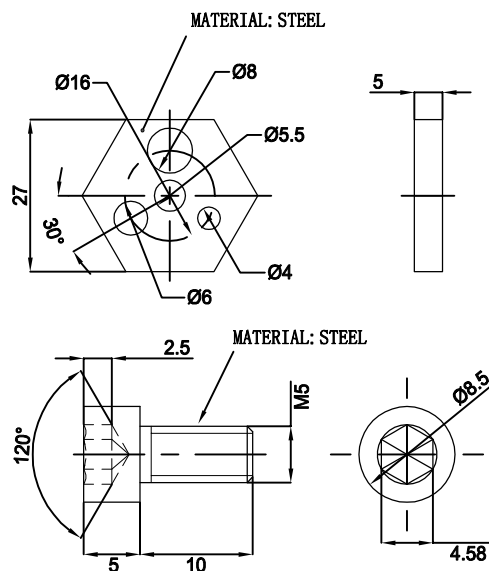
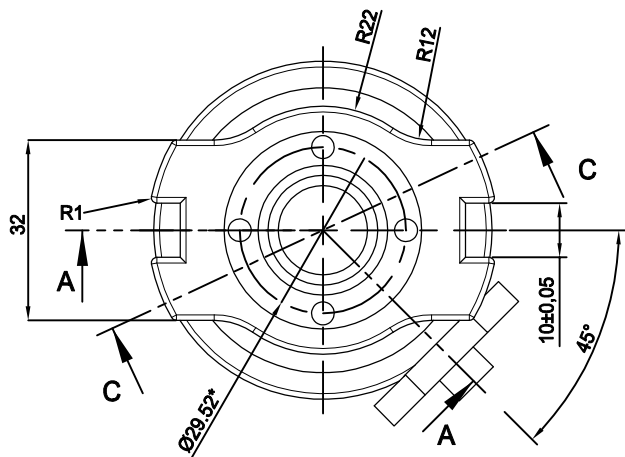


XXI-KPM-26-4-500-10 BLANK MOULD			
WEIGHT	420±10g		
BRIMFUL CAPACITY	513±7ml		
FILL POINT CAPACITY	500±10ml		
SCALE	DRAWING NO. XXI-KPM-26-4-500-10 -BM-A1		
1:1	DRAW	CHECKED	APPROVED
MACHINE TYPE	BOTTERO DG 5 1/2"	10/10/2019	
HOLDER SIZE	#23		
INVERT	75	MATERIAL	CAST IRON
"H" DIM.	117.5		

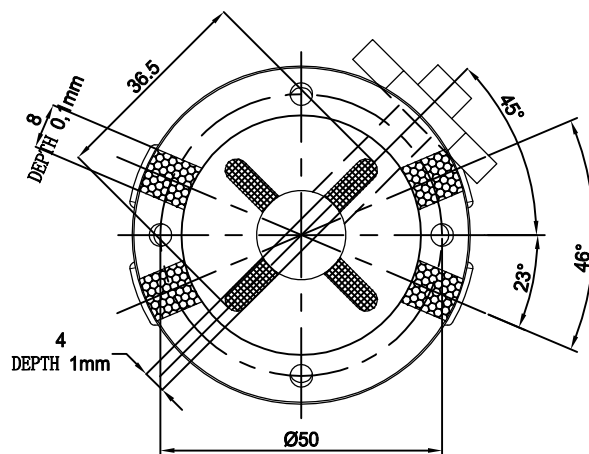
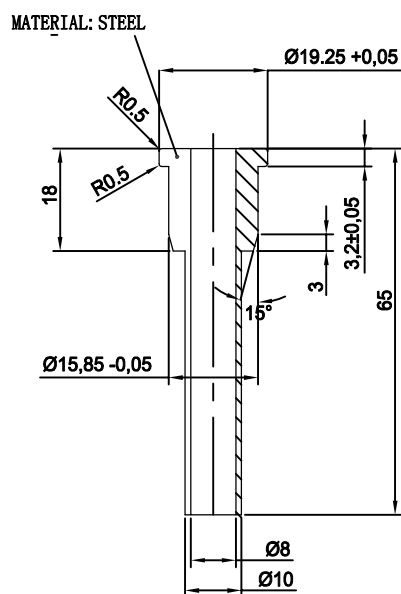
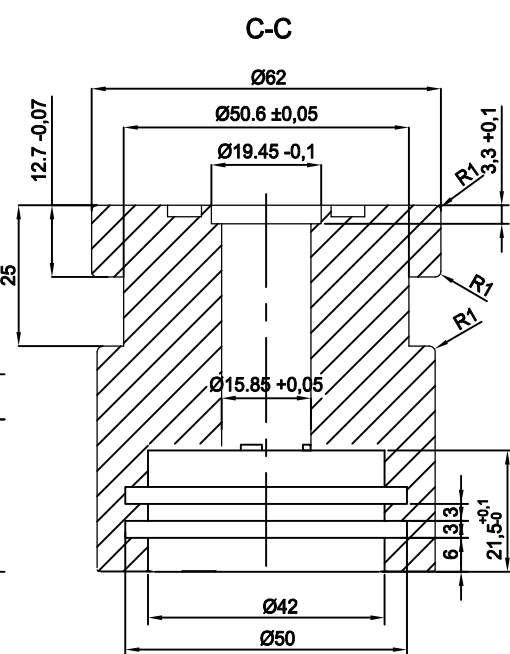
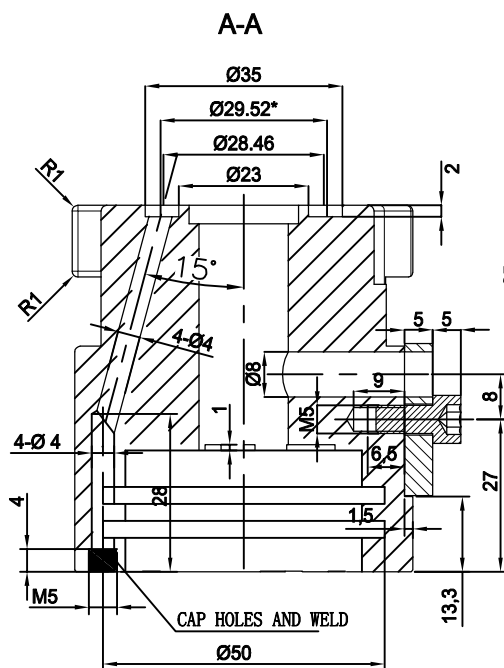


MLD & BTM DISPL. 680.5 ± 1.5 ml

XXI-KPM-26-4-500-10 BLOW CAVITY			
WEIGHT		420±10g	
BRIMFUL CAPACITY		513±7ml	
FILL POINT CAPACITY		500±10ml	
SCALE		DRAWING NO.	
1:1		XXI-KPM-26-4-500-10 -FMC-A1	
DRAW		CHECKED	APPROVED
10/10/2019			



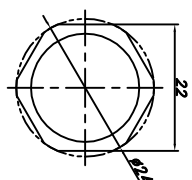
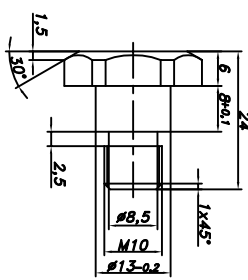
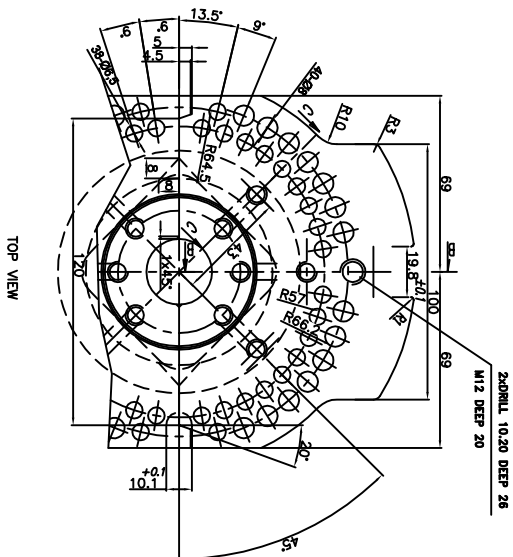
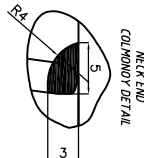
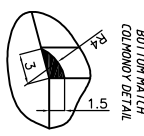
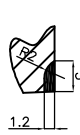
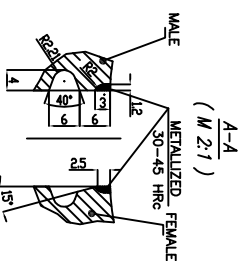
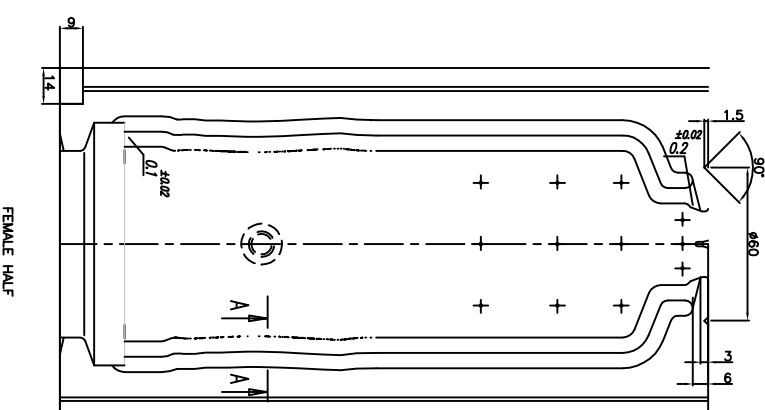
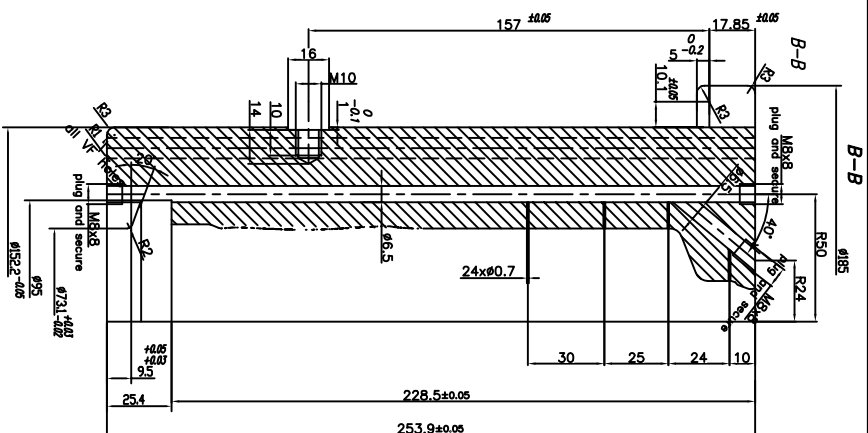
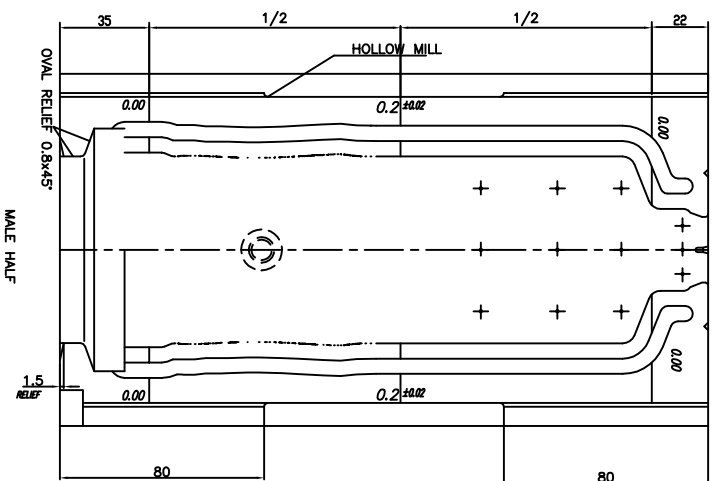
COL#
35-40 HRC
deep 1mm



ENGRAVE: XXI-KPM-26-4-500-10
MOULD NO.

(S)

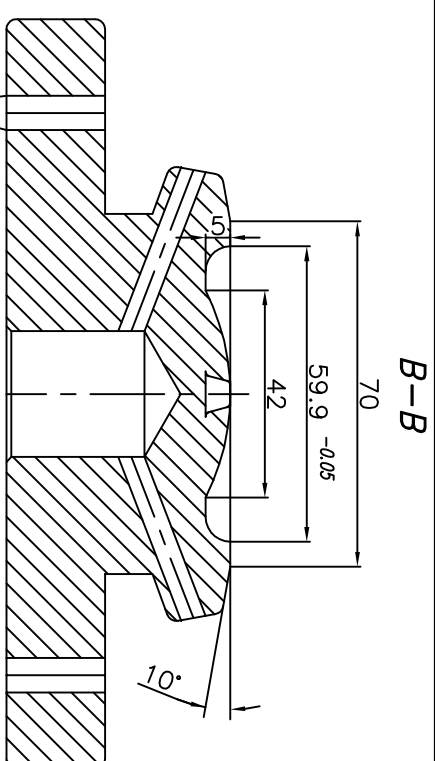
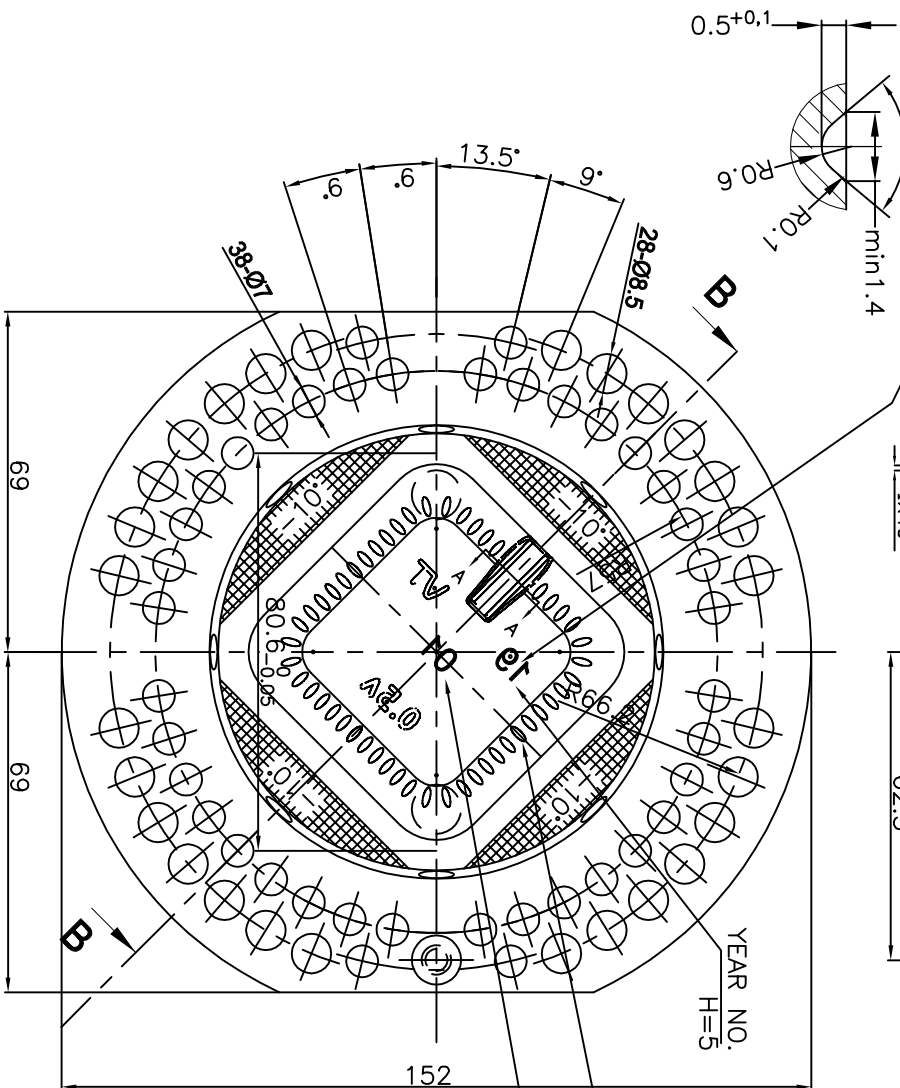
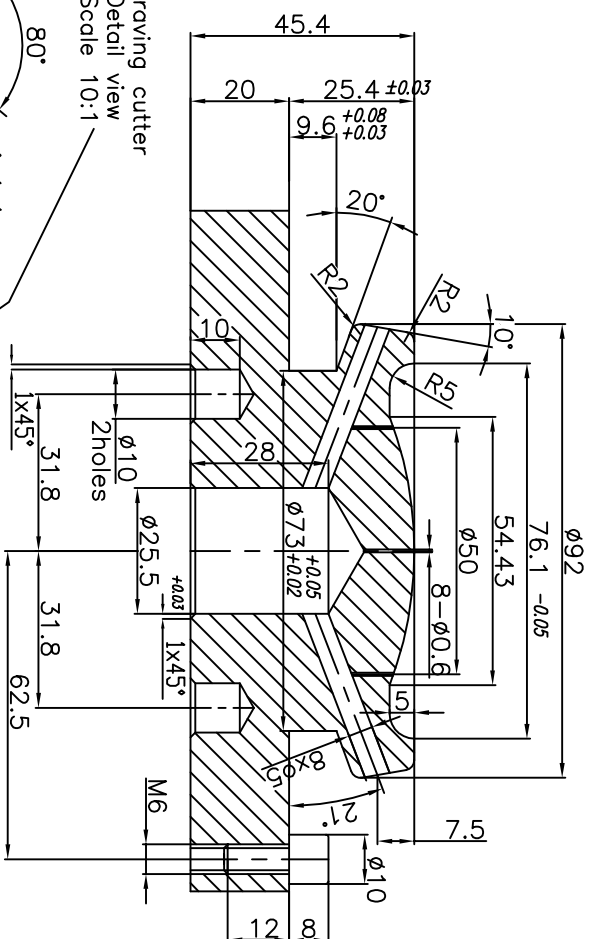
XXI-KPM-26-4-500-10 BLOW HEAD		
SCALE	DRAWING NO.	
1:1	XXI-KPM-26-4-500-10 -BH-A1	
DRAW	CHECKED	APPROVED
10/10/2019		
MATERIAL	CAST IRON	



ENGRAVE: XI-KTM-26-4-500-10
 MOULD NO. ⑤

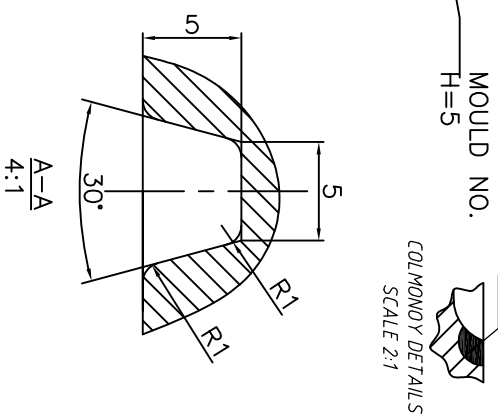
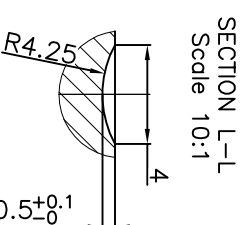
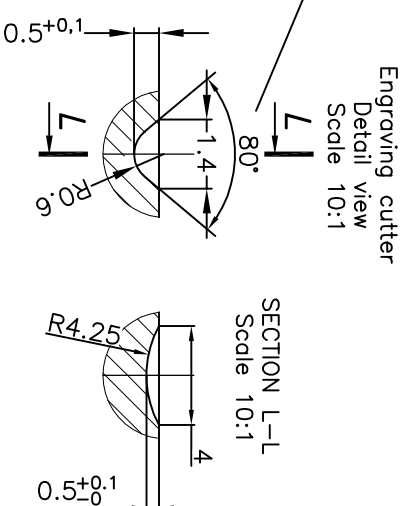
MACHINE TYPE	BOTERO DG 54	10/10/2019	CHECKED APPROVED
HOLDER SIZE	#53		
INVERT	75		
"H" DIM.	57.15		

XXI-KTM-26-4-500-10	WEIGHT	420±10g
BLOW MOULD	BRIMFUL CAPACITY	513±10ml
	FILL POINT CAPACITY	500±10ml
SCALE DRAWING NO.		
XXI-KTM-26-4-500-10		
-FM-A1		
DRAW		

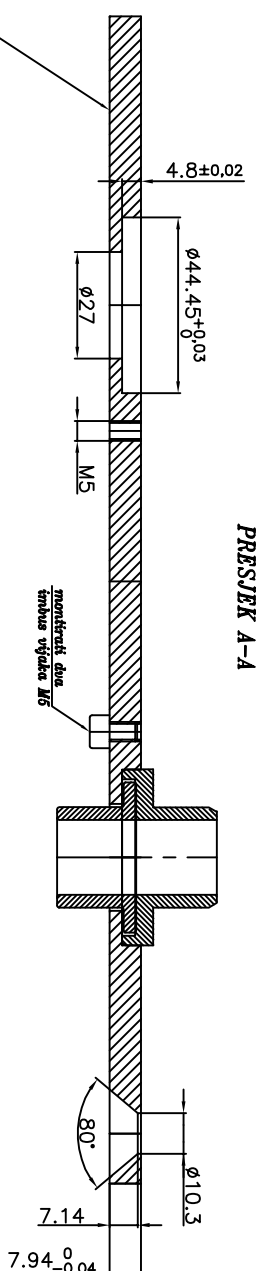
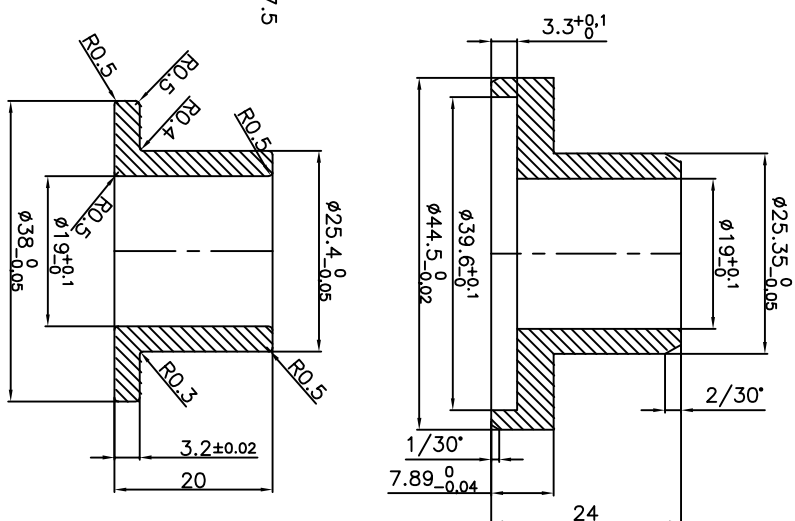
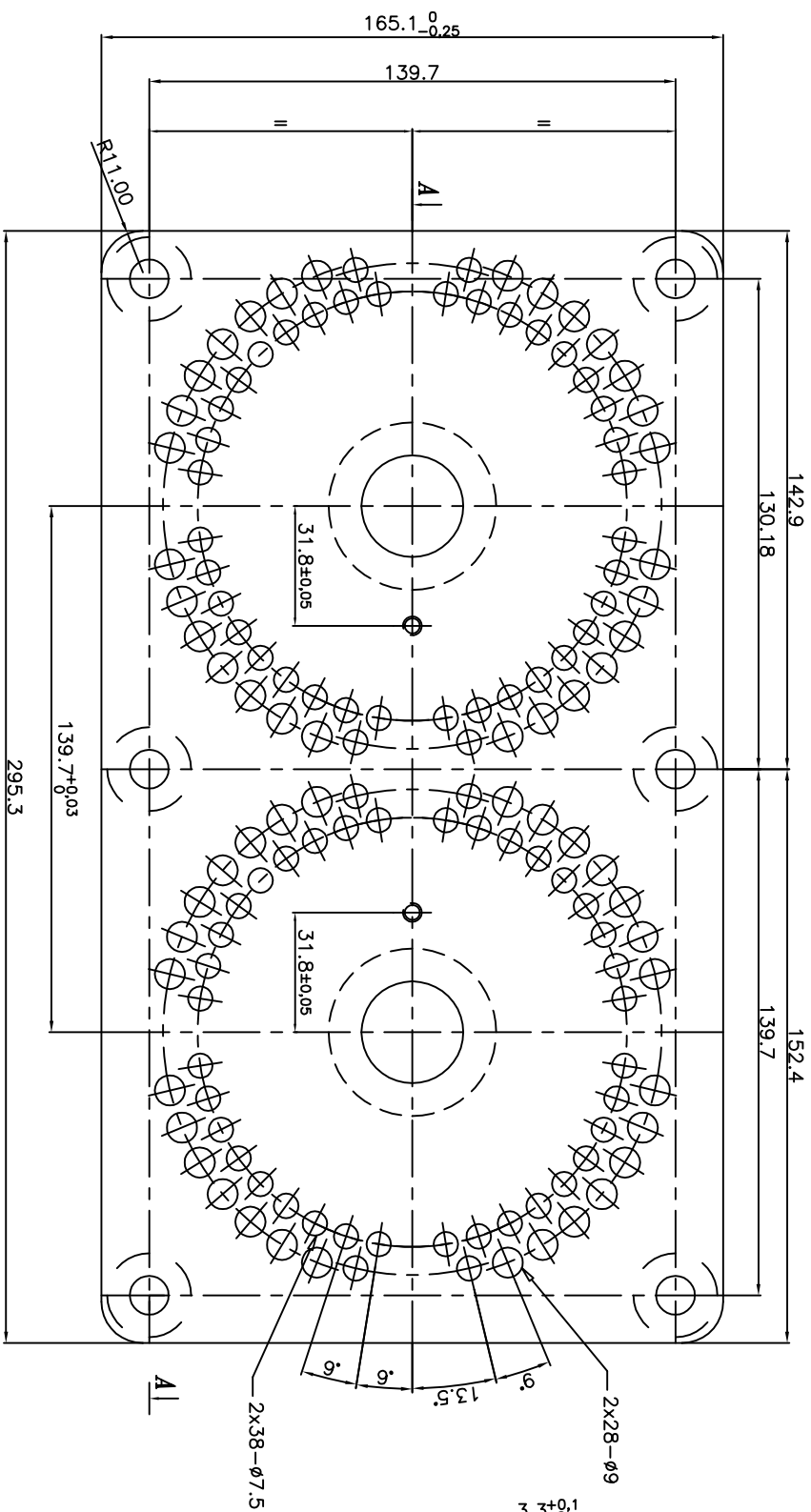


**R0.5 All VF
holes**

ENGRAVE:
XXI-KTM-26-4-500-10
MOULD NO.



XXI-KTM-26-4-500-10		
BOTTOM PLATE		
SCALE	DRAWING NO.	
1:1	XXI-KTM-26-4-500-10 -BP-A1	
DRAW	CHECKED	APPROVED
10/10/2019		
MATERIAL	CAST IRON	

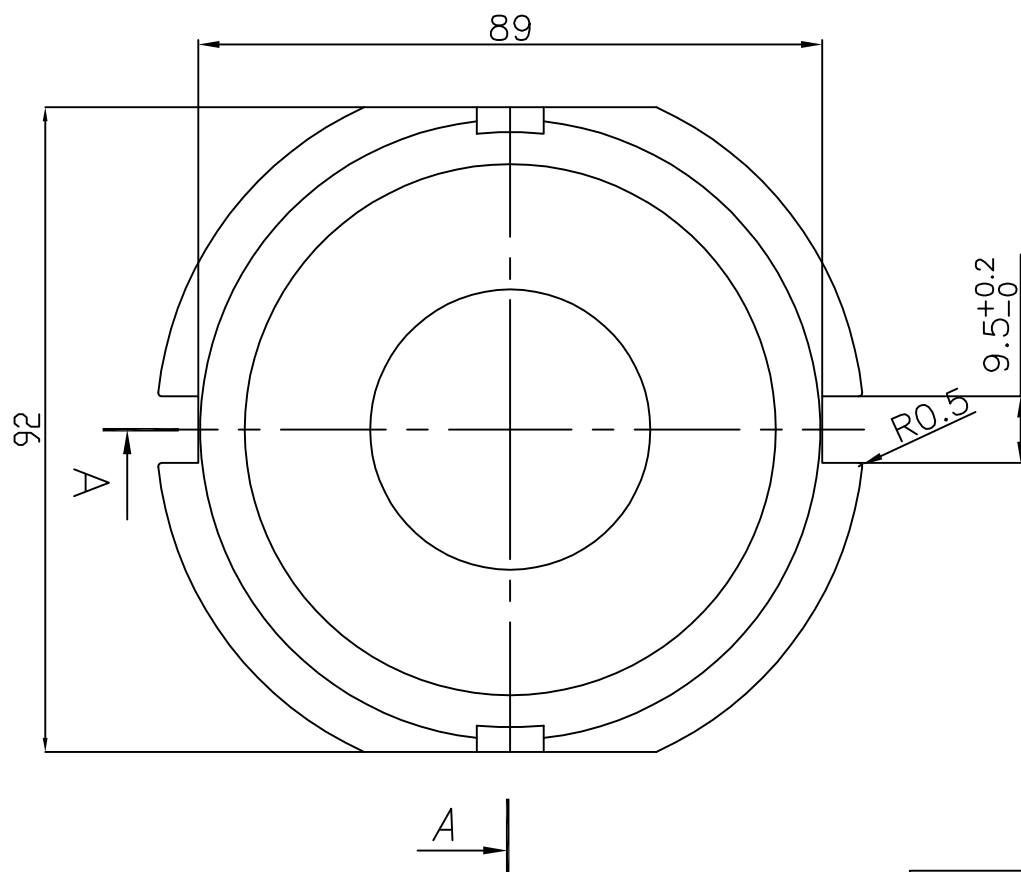
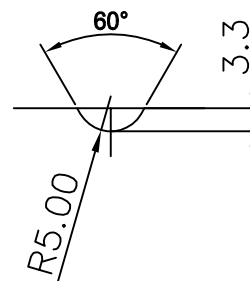
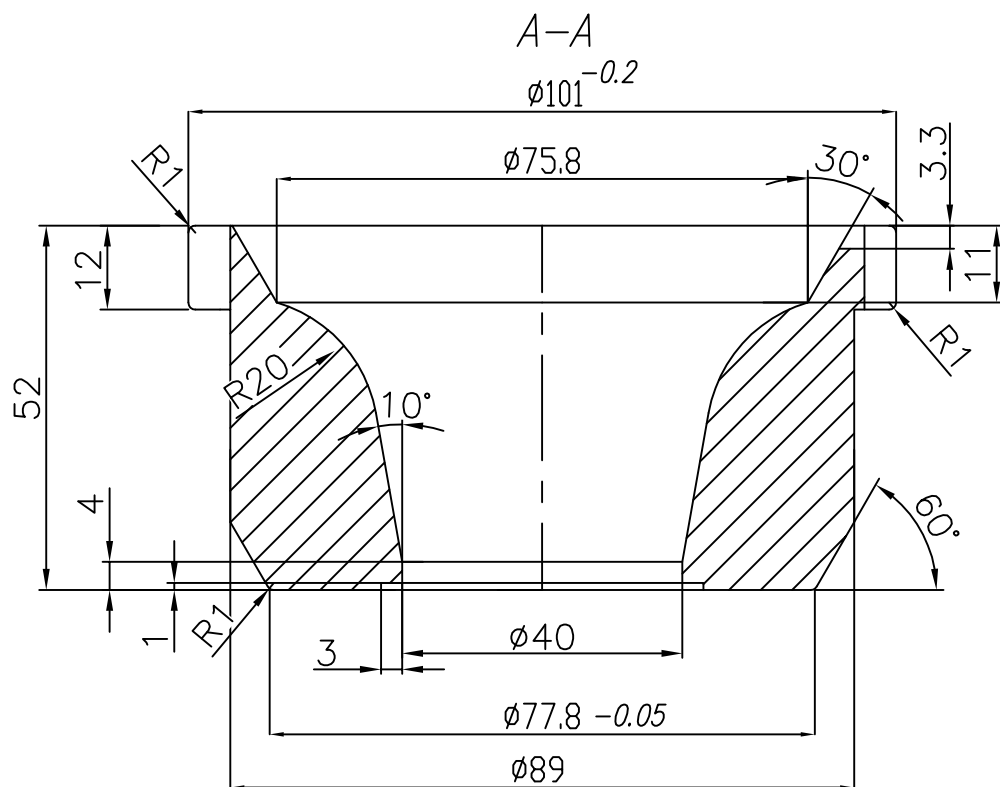


PŘESJEK A-A

ENGRAVE: XI-KTM-26-4-500-10
MOULD NO.

5

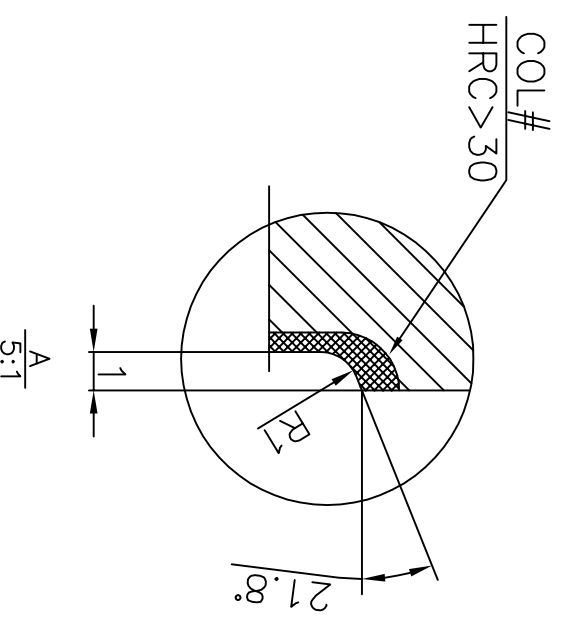
XI-KTM-26-4-500-10	
DISTRIBUTOR PLATE	
SCALE	DRAWING NO.
1:1	XI-KTM-26-4-500-10
DRAW	CHECKED APPROVED
10/10/2019	
MATERIAL	STEEL



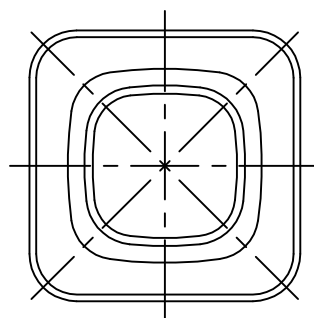
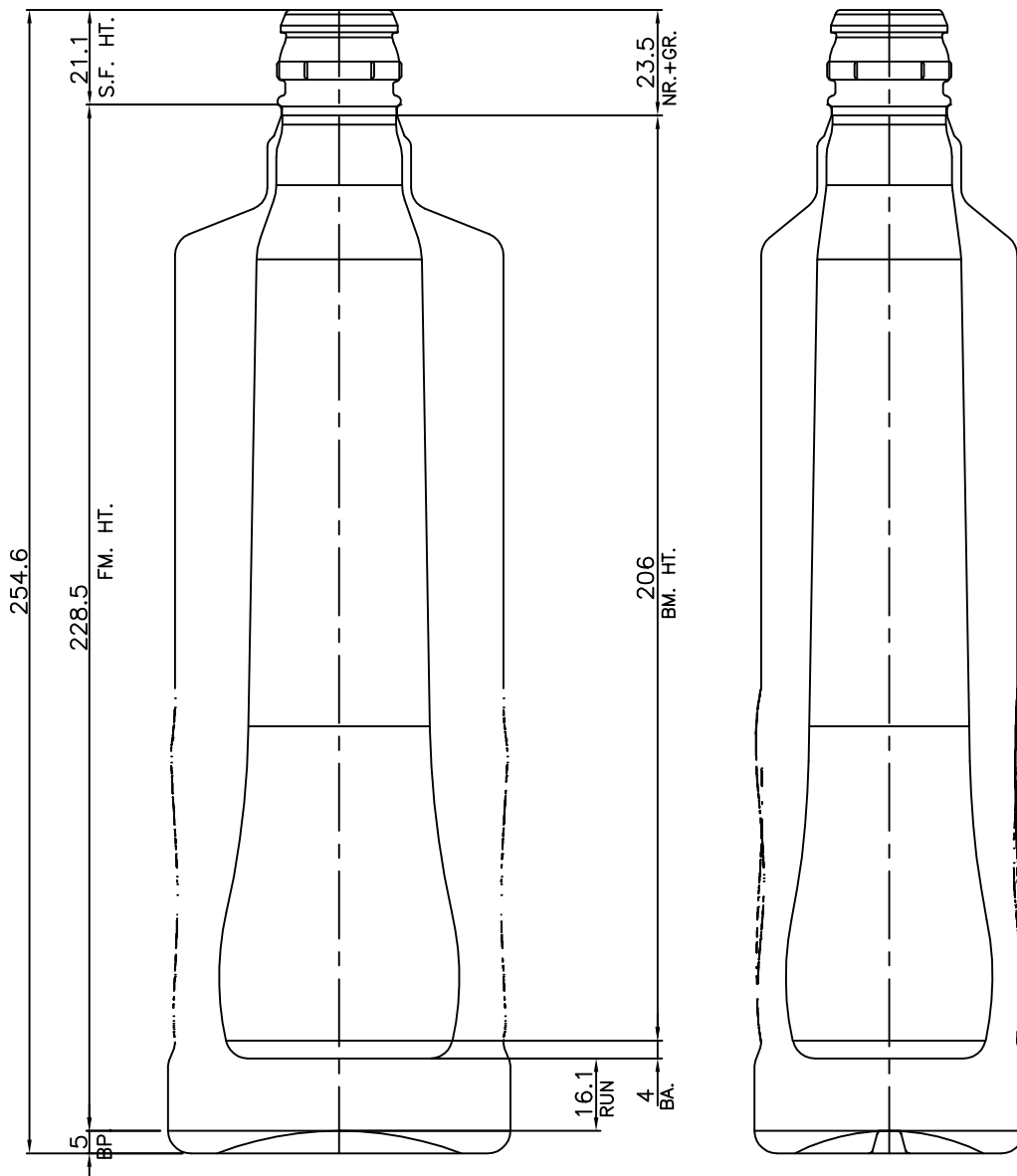
ENGRAVE: XXI-KPM-26-4-500-10
MOULD NO.

(S)

XXI-KPM-26-4-500-10 FUNNEL		
SCALE	DRAWING NO.	
1:1	XXI-KPM-26-4-500-10 -FU-A1	
DRAW	CHECKED	APPROVED
10/10/2019		
MATERIAL	CAST IRON	



XXI-KTMM-26-4-500-10		
GUIDE PLATE		
SCALE	DRAWING NO.	
1:1	XXI-KTMM-26-4-500-10 -GP-A1	
DRAW	CHECKED	APPROVED
10/10/2019		
MATERIAL	CAST IRON	

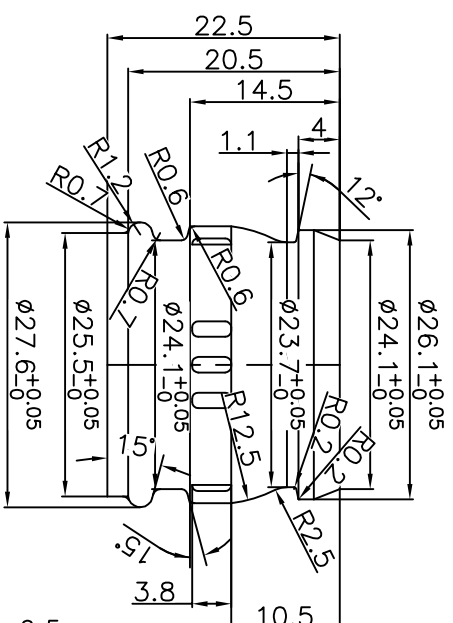
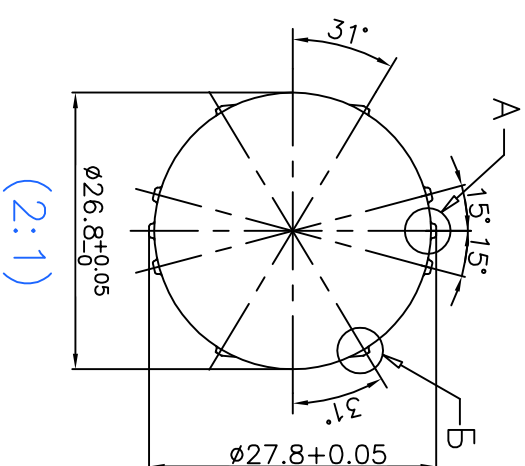
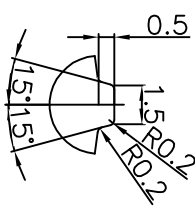
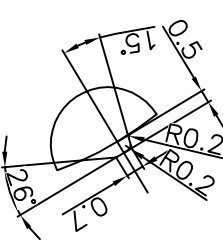


BLANK MOULD		
WEIGHT	420	g
HOT GLASS FACTOR	x0.41	
GOB CAPACITY	172.2	ml
OVERCAP 43.9%	+75.6	ml
NR NOL - PL VOL	-8.8	ml
12	3.2	
CALC. BLK+BA DISPL.	239	ml
'L' RATIO		
CAP. TO SETTLE LINE		ml
S.L.HT. FROM NR LINE		mm
INVERT	75	mm
"H" DIM.	117.5	mm
HOLDER SIZE	#23	

BLOW MOULD		
WEIGHT	420	g
COLD CLASS FACTOR	x0.4	
CAP. TO O'FLOW	168	ml
	+513	ml
SHRINKAGE (1.5%)	681	ml
	X1.015	
DISPL. OF SEATED FIN. ABOVE MOULD	691.2	ml
	-10.7	ml
MLD + BP DISPL.	680.5	ml
INVERT	75	mm
"H" DIM.	57.15	mm
HOLDER SIZE	#53	

FINISH:	
BLOW NECK	ø25.7
BLANK NECK	ø25.3
RING NECK	ø25.5
TONG NECK	
BLOW NECK RAD	R1
BLOW HEAD DEPTH	21.5

XXI-KPM-26-4-500-10		
WEIGHT	420±10g	
BRIMFUL CAPACITY	513±7ml	
FILL POINT CAPACITY	500±10ml	
FINISH TYPE:	KPM-26-4	
SCALE	MACHINE TYPE:	
1:1	BOTTERO DG 5 ¹ "	
DRAW	CHECKED	APPROVED
10/10/2019		

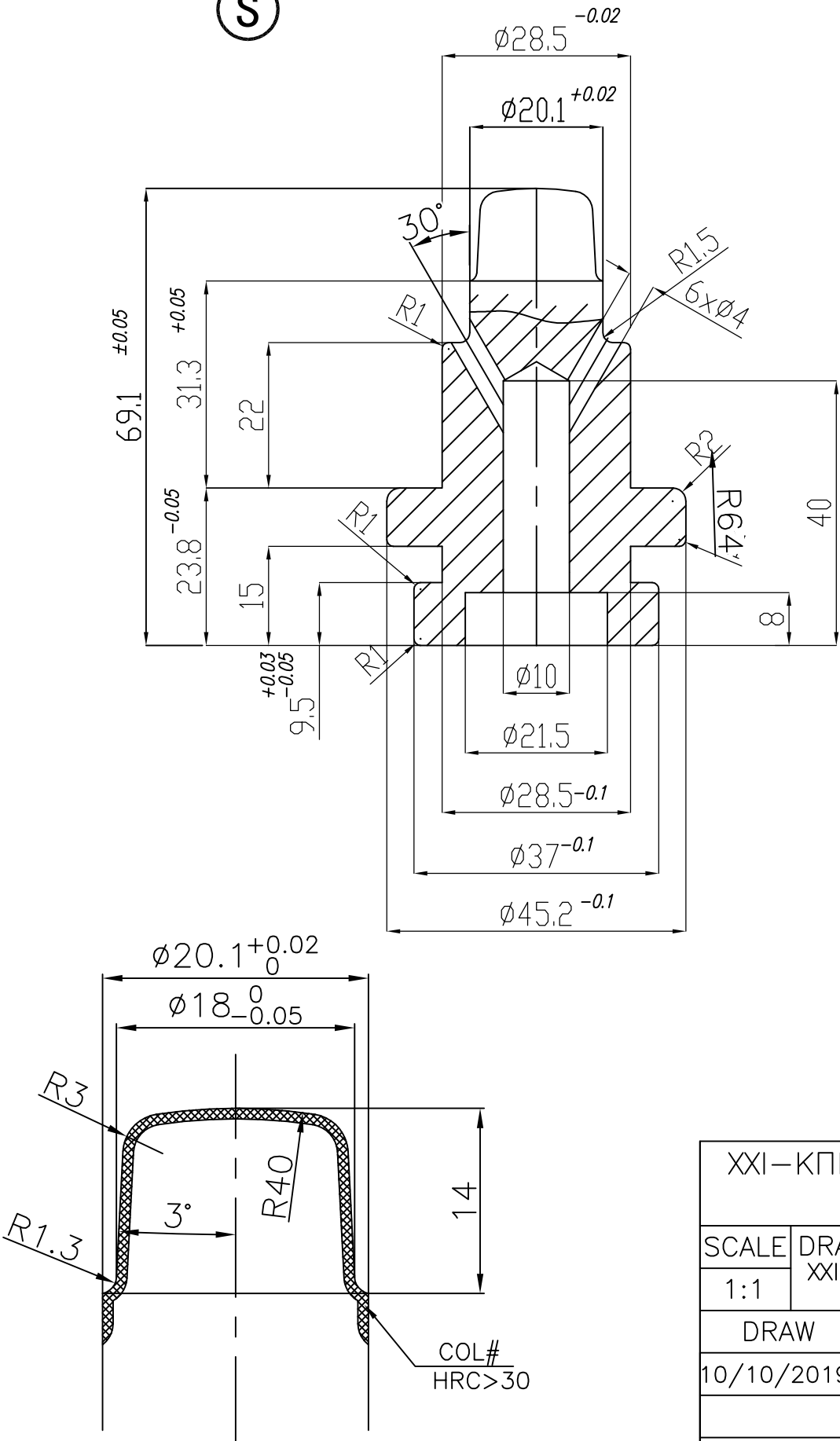

$$A(5:1)$$

$$E(5:1)$$


⑧

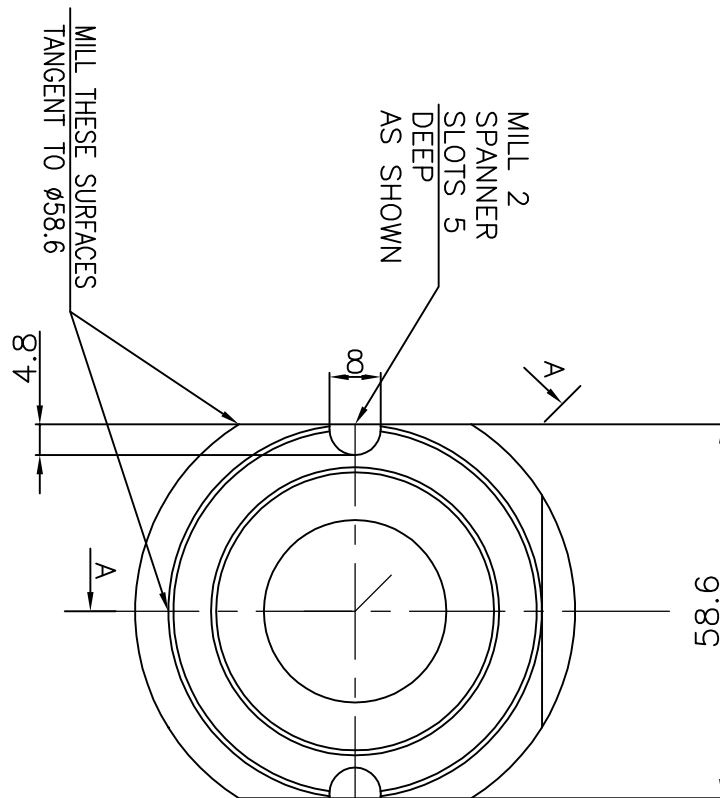
XXI-KT1M-26-4-500-10 NECKRING			
SCALE	DRAWING NO.		
1:1	XXI-KT1M-26-4-500-10 -NR-A1		
DRAW	CHECKED	APPROVED	
10/10/2019			
MATERIAL	BRONZE		

ENGRAVE: XXI-KPM-26-4-500-10
MOULD NO.

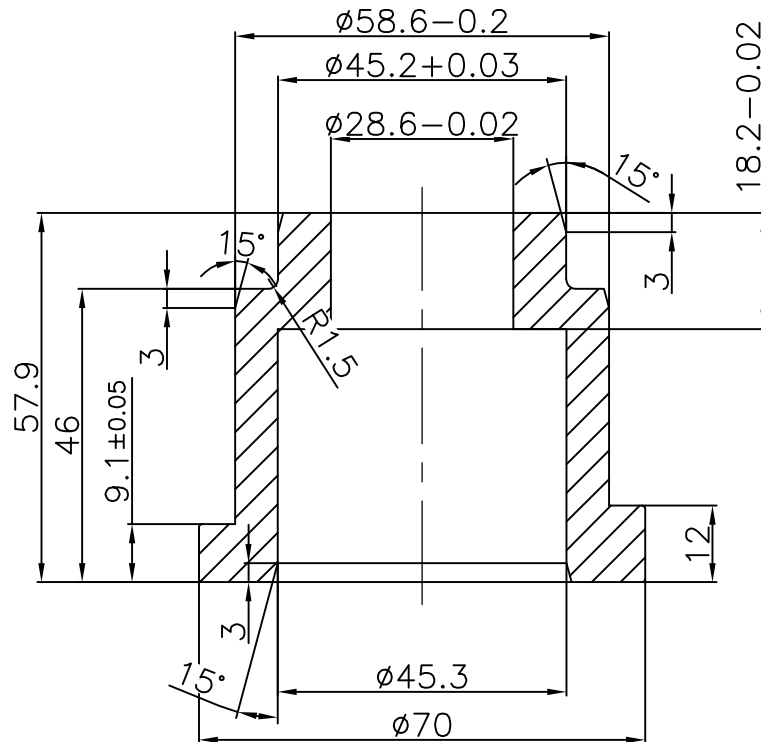
(S)



XXI-KPM-26-4-500-10 PLUNGER			
SCALE 1:1	DRAWING NO. XXI-KPM-26-4-500-10 -PL-A1		
	DRAW 10/10/2019	CHECKED	APPROVED
MATERIAL		STEEL	



SECTION A-A



ENGRAVE: XXI-KPM-26-4-500-10
MOULD NO.

(S)

XXI-KPM-26-4-500-10 THIMBLE			
SCALE		DRAWING NO.	
1:1		XXI-KPM-26-4-500-10 -TH-A1	
DRAW		CHECKED	APPROVED
10/10/2019			
MATERIAL		CAST IRON	