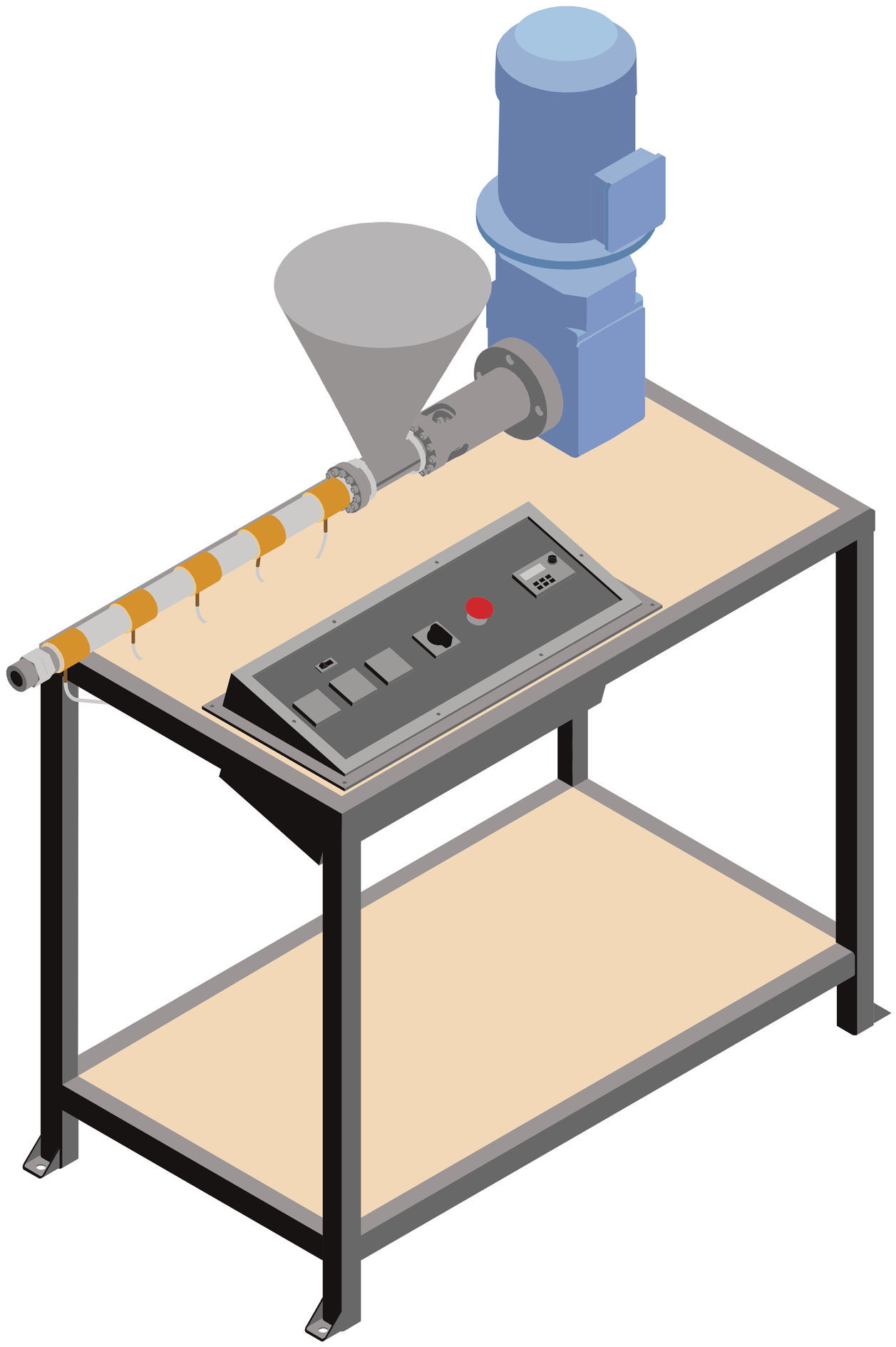


EXTRUSION PRO

Watch the instruction video
to build this machine on

www.preciousplastic.com

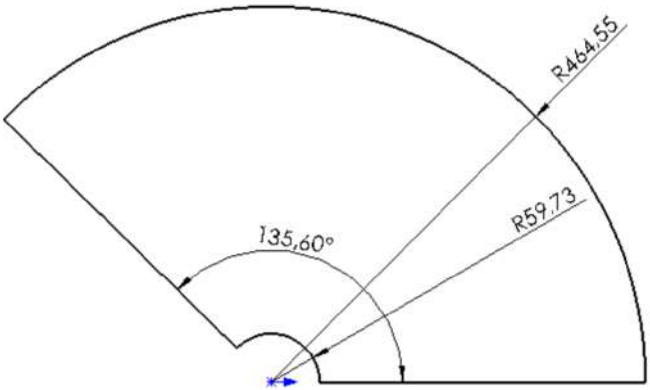
HOW TO BUILD THE CONE HOPPER

MATERIAL

- 500 X 1000 mm steel sheet 0.5mm Thickness
- Wooden bar, 2 screws, a protractor, a drilling machine, a hammer
- Jigsaw or cutting plier
- Sanding machine
- 8 rivets Ø 2 / Ø 2.5 for 1mm thickness and riveting pliers

SHEET CUTTING

We need to cut this pattern to obtain the cone hopper :

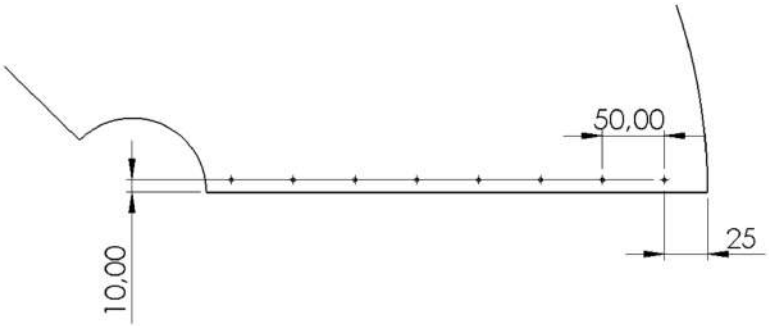


The easiest way to mark and cut it is to use a wooden bar as a compass. You can mark the two diameter using two screw.

1) Tighten the two screws in the center of the wooden bar at a distance of 464.5 mm from each other
2) Hammer the first screw for the center of the cone at the extremity of the sheet
3) Rotate the wooden bar to mark the plate with the tip of the second screw.
4) Repeat for the inner diameter of 59.7 mm.
5) Use a protractor to determine the angle of 135.6°.
6) Use a Jigsaw or cutting plier to cut the sheet.
7) Use your sanding machine for finishing touch and polish it to clear imperfections.

SHEET BENDING

Before bending the cone :
- Draw 2 lines with a pencil 10 mm from the edge on both side
- Then drill ONE side of the sheet according to the drawing below (8 holes / the drilling diameter is determined by the diameter of your rivets.)



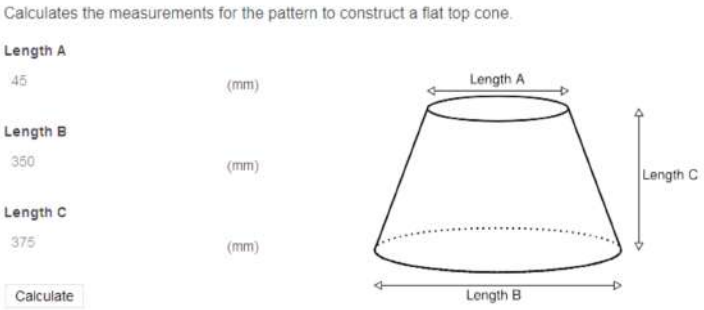
Then you can start to bend manually to make the shape of the cone and get help with a conical shaped object and roll the sheet.
When you have reached a sufficient form, you can overlap both parts, be careful to overlap the 2 lines located at 10 mm from the edge.
Start to make the first hole on the top of the cone to drill the bottom sheet. You can put your first rivet.
Then drill the second hole while maintaining the overlap of the lines. Put the second rivet and so on.
Finally the last folding is done after finishing the cone and putting the rivets. The folding consists in completing the hollow shape of the EXTPRO-V1 1200.01-A Top part
This folding is done manually using the barrel inlet part (EXTPRO-V1 1200.01-A Top) and copy the same hollow shape in order to weld the two parts more easily.

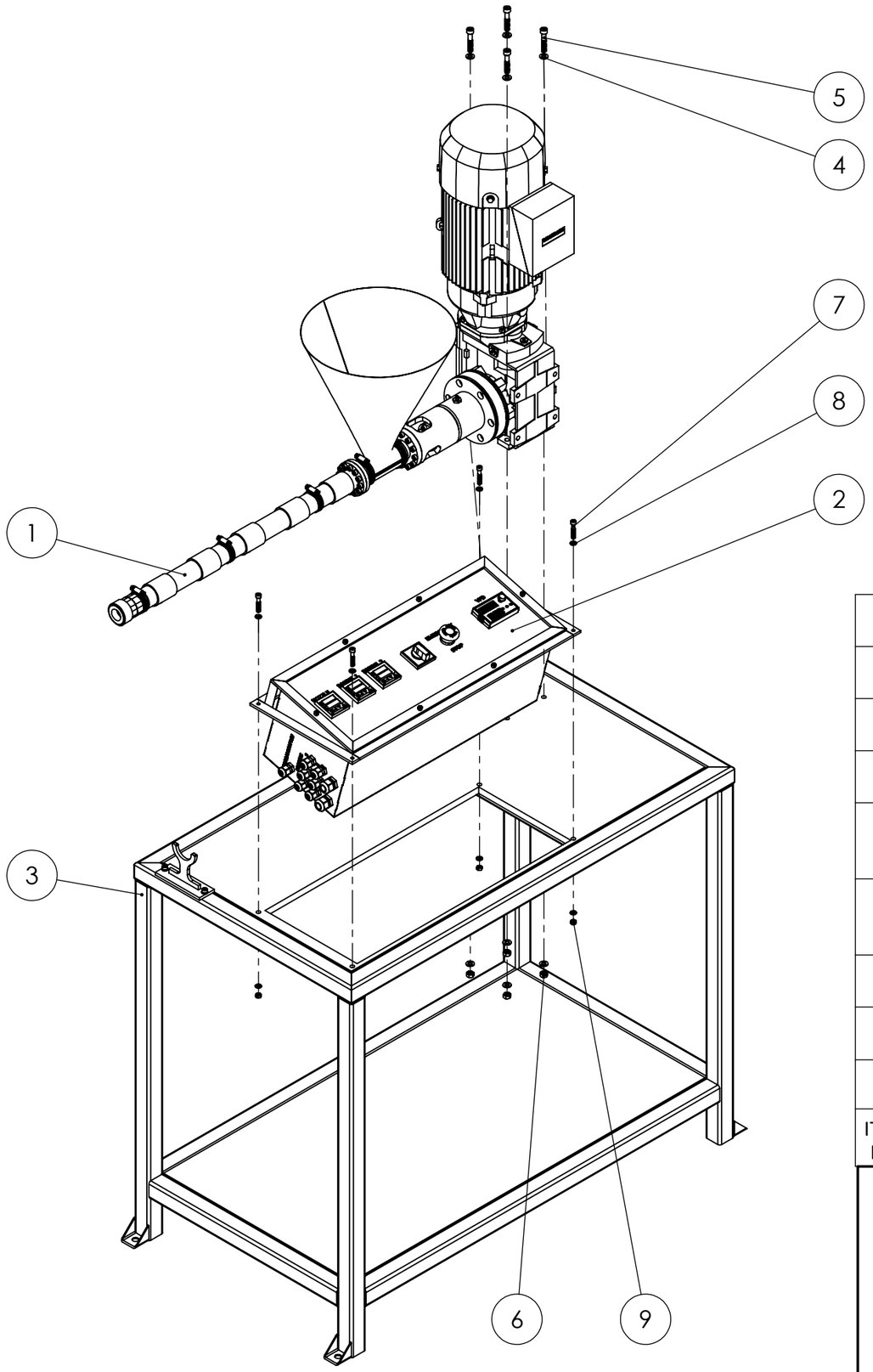
Caution when welding, the cone is very thin.

OPTIONS

You can change the dimension of your cone hopper (length B and C) as your convenience :

Cone calculator :
http://craig-russell.co.uk/demos/cone_calculator/

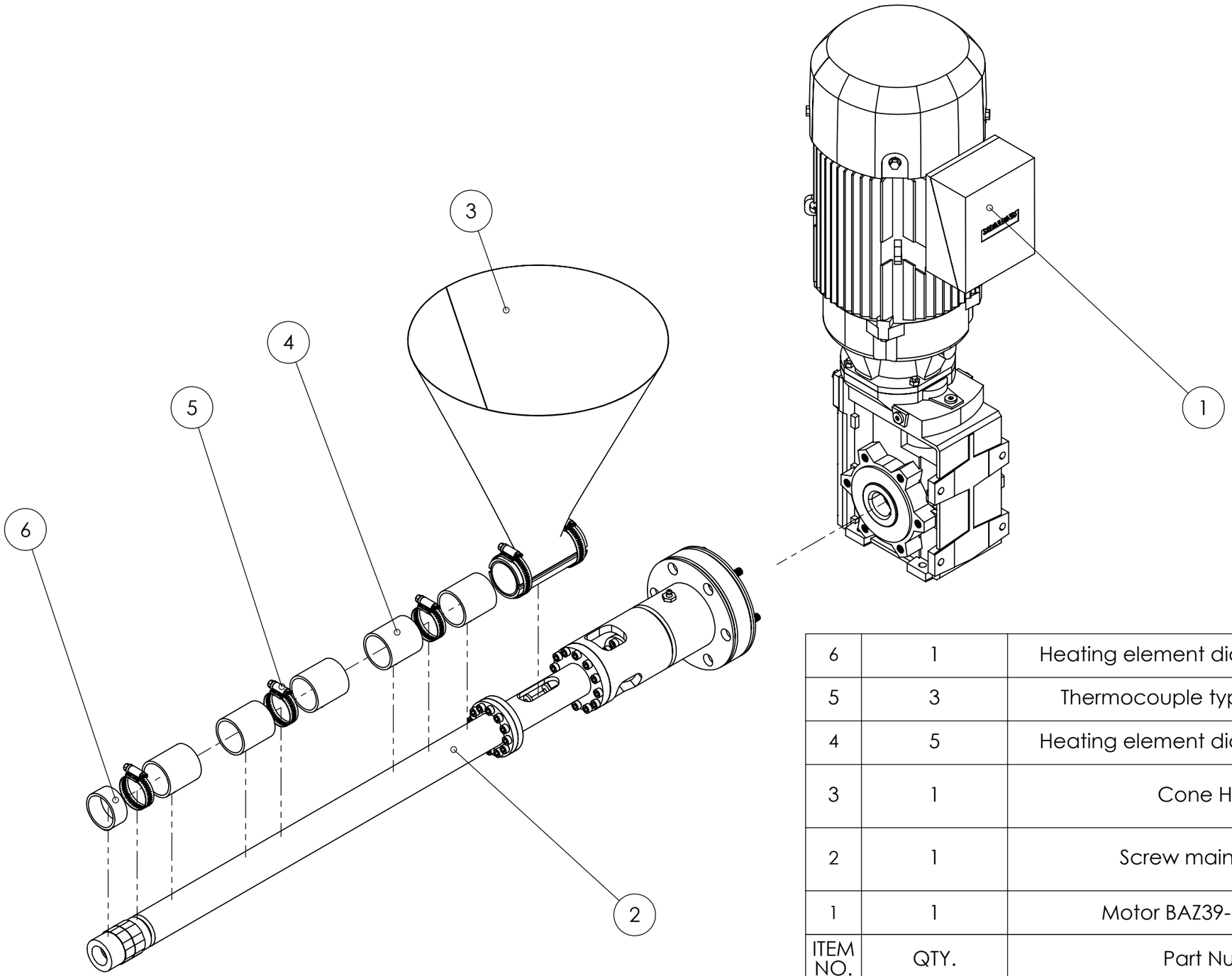




ITEM NO.	QTY.	DESCRIPTION	PART NO.	MATERIAL
9	4	M6 Nut DIN 934	EXTPRO-V1 34	Zinc plated steel
8	8	M6 Washer DIN 125	EXTPRO-V1 33	Zinc plated steel
7	4	M6 x 35 mm Socket head screw	EXTPRO-V1 32	Zinc plated steel
6	4	M8 Nut DIN 934	EXTPRO-V1 31	Zinc plated steel
5	4	M8 x 45 mm Socket head screw DIN 912	EXTPRO-V1 30	Zinc plated steel
4	8	M8 Waher DIN 125	EXTPRO-V1 29	Zinc plated steel
3	1	Frame	EXTPRO-V1 3000.00	-
2	1	Electronics	EXTPRO-V1 2000.00	-
1	1	Extruder	EXTPRO-V1 1000.00	-

PRECIOUS PLASTIC

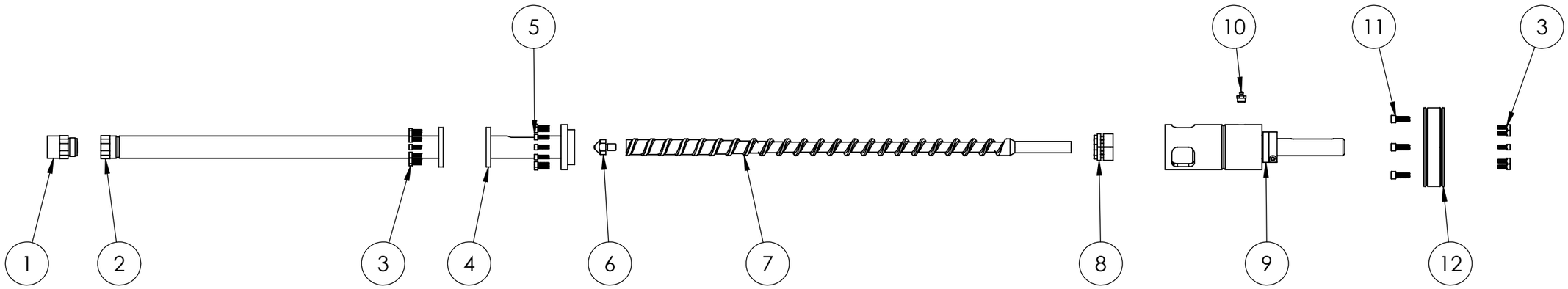
Machine: Extruder PRO			Description: Extruder Assembly		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 0000.00			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

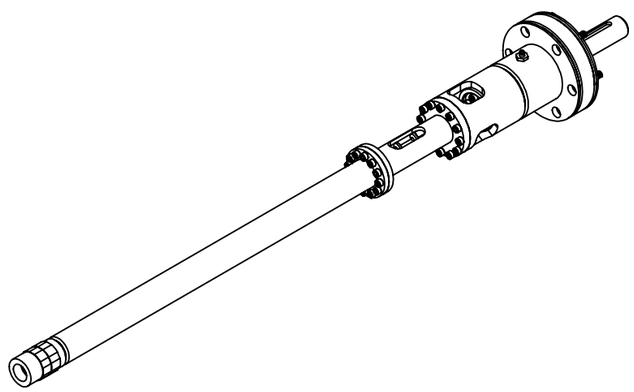


ITEM NO.	QTY.	Part Number	PART NO.	MATERIAL
6	1	Heating element dia. 40x20 mm 150W	EXTPRO-V1 13	-
5	3	Thermocouple type J dia. 40 mm	EXTPRO-V1 12	-
4	5	Heating element dia. 40x50 mm 350W	EXTPRO-V1 11	-
3	1	Cone Hopper	EXTPRO-V1 1200.00	-
2	1	Screw main assembly	EXTPRO-V1 1100.00	-
1	1	Motor BAZ39-LE100ZLSB4P	EXTPRO-V1 01	-

PRECIOUS PLASTIC

Machine: Extruder PRO			Description: Extruder			
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1000.00			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 1 / 1

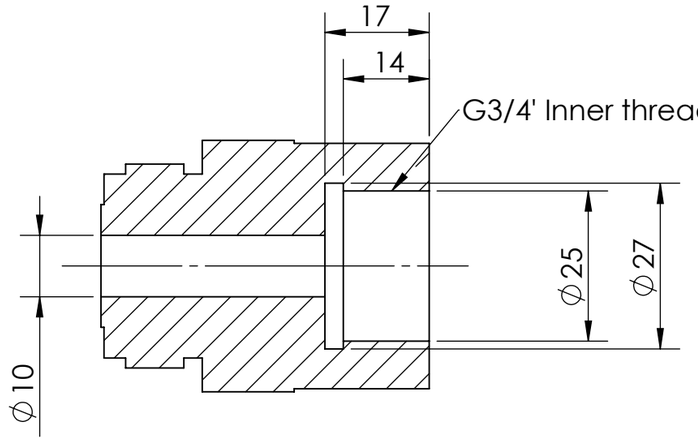




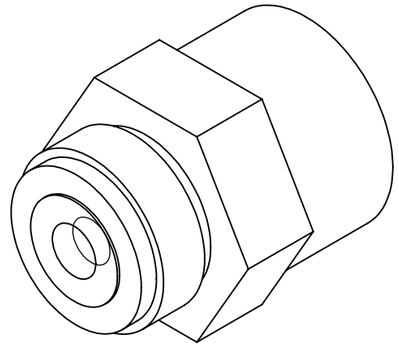
ITEM NO.	QTY.	DESCRIPTION	PART NUMBER	Material
12	1	Gearbox flange	EXTPRO-V1 1110.00	Mild Steel
11	6	M8 X 25 mm socket head screw DIN 912	EXTPRO-V1 09	Black oxyde steel
10	1	Greasing nozzle	EXTPRO-V1 06	Steel
9	1	Bearing Body & Shaft	EXTPRO-V1 1120.00	-
8	1	Clip bushing	EXTPRO-V1 05	Steel
7	1	Screw	EXTPRO-V1 1100.02	1.8509 (38CrMoAlA)
6	1	Screw tip	EXTPRO-V1 1100.03	1.7225 (42CrMo4)
5	12	M6 X 20 mm socket head screw DIN 912	EXTPRO-V1 07	Black oxyde steel
4	1	Barrel inlet	EXTPRO-V1 1130.00	-
3	20	M6 x 16 mm socket head screw DIN 912	EXTPRO-V1 08	Black oxyde steel
2	1	Barrel assembly	EXTPRO-V1 1140.00	-
1	1	Intermediate nozzle	EXTPRO-V1 1100.01	1.0037 (S235JR)

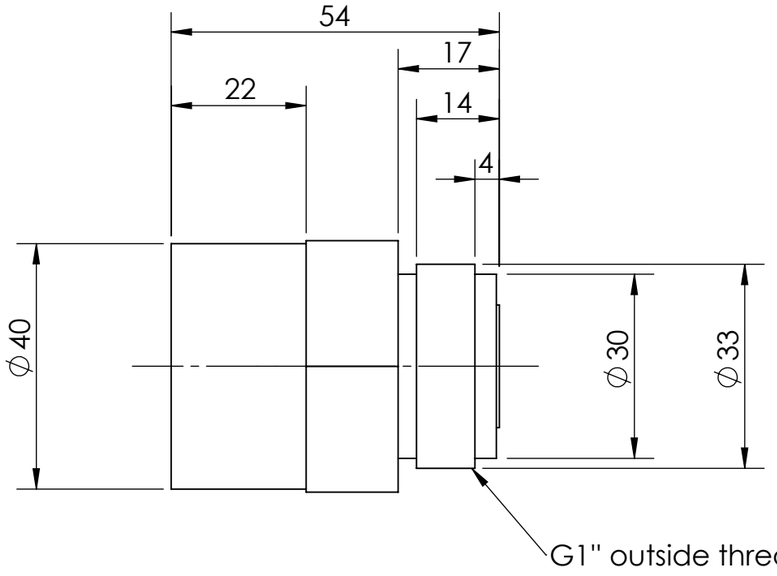
PRECIOUS PLASTIC

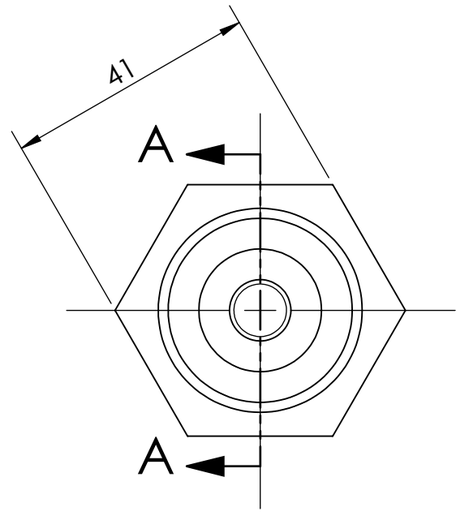
Machine: Extruder PRO			Description: Screw Assembly		
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1100.00		Rev.: A
General tolerances: ISO 2768-m	Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 1 / 1



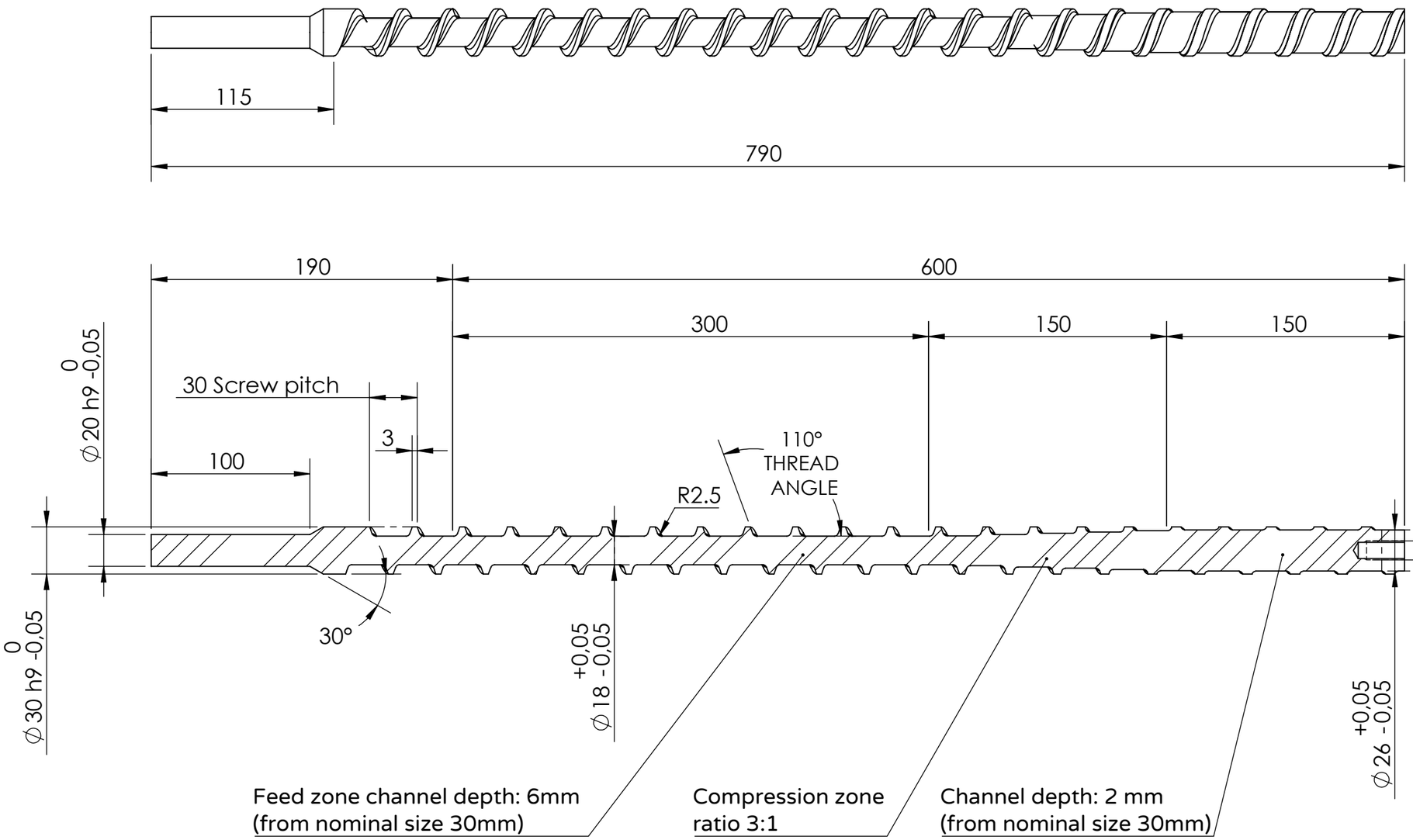
SECTION A-A



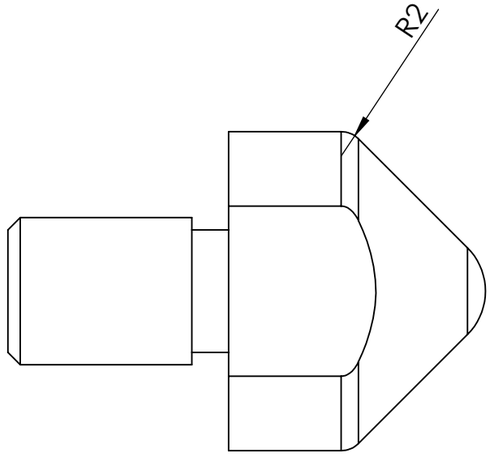


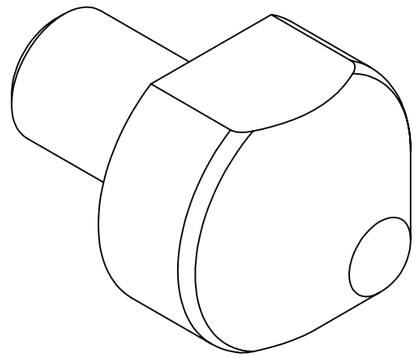


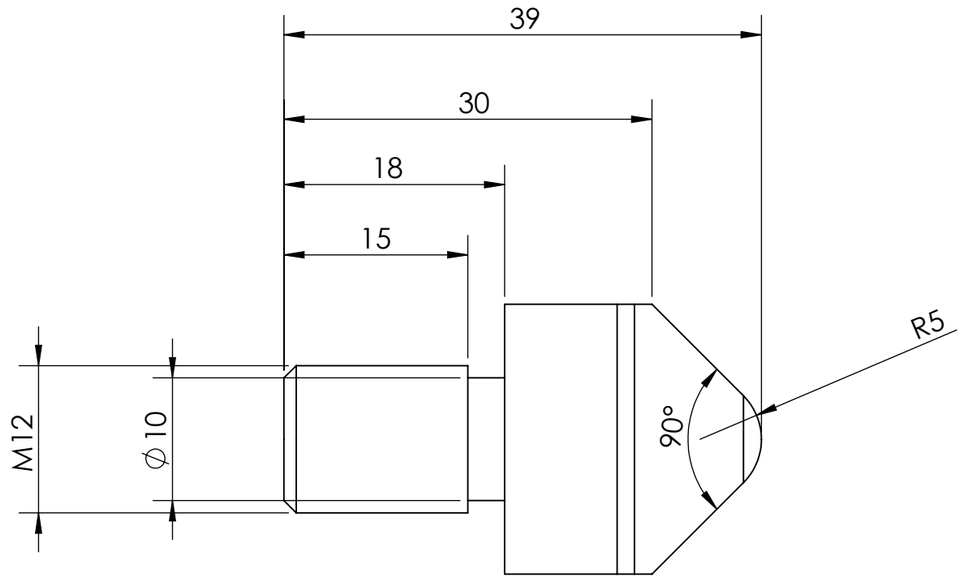
Weight: 0.4 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Nozzle			
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1100.01		Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

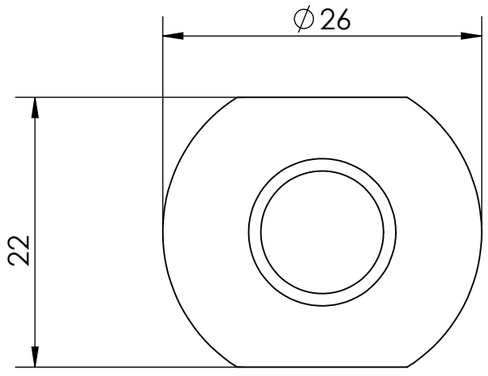


Weight: 2.4 kg			Material: 1.8509 (38CrMoAlA)		
Machine: Extruder PRO			Description: Screw		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1100.02			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1





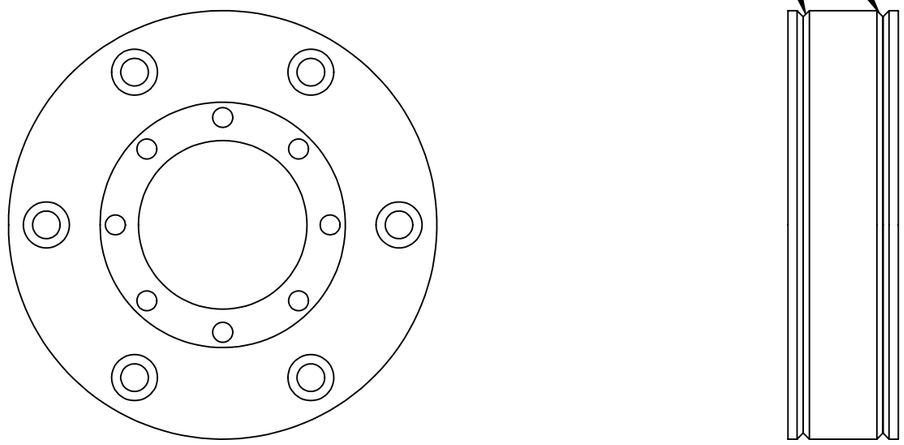


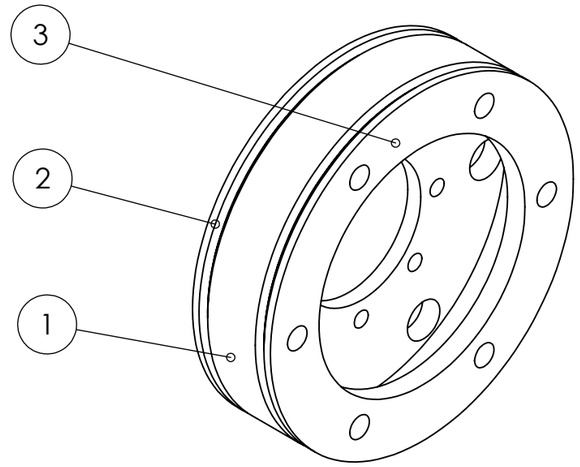


Weight: 0.1 kg			Material: 1.7225 (42CrMo4)		
Machine: Extruder PRO			Description: Screw Tip		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1100.03			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 2:1	Sheet: 1 / 1

NOTES:

- 2 LASER CUT PARTS : MOTOR SIDE FLANGE, SCREW SIDE FLANGE
- ALIGN THE BOLT PATTERNS BY INSTERTING
- SCREWS & NUTS IN A FEW HOLES.
- POINT WELD THE PARTS.
- TIG WELD ALL AROUND THE FLANGES FILLING THE CHAMFERS.

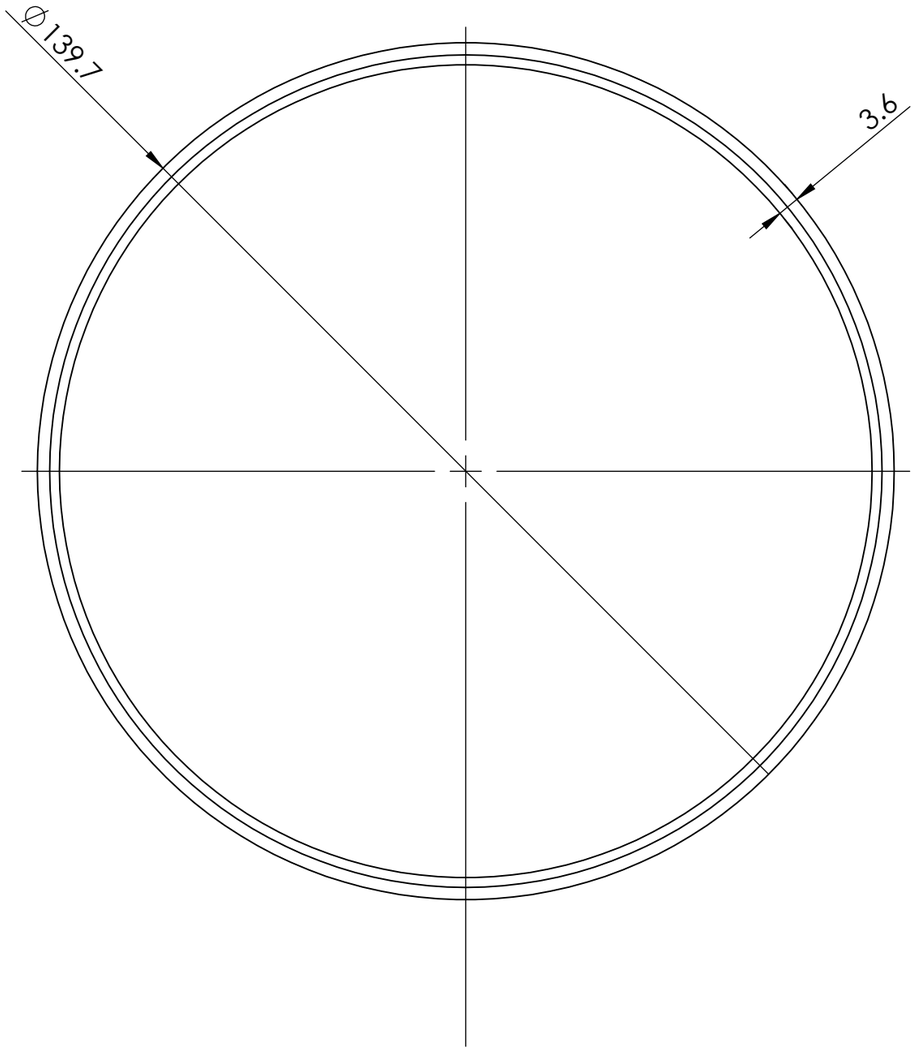


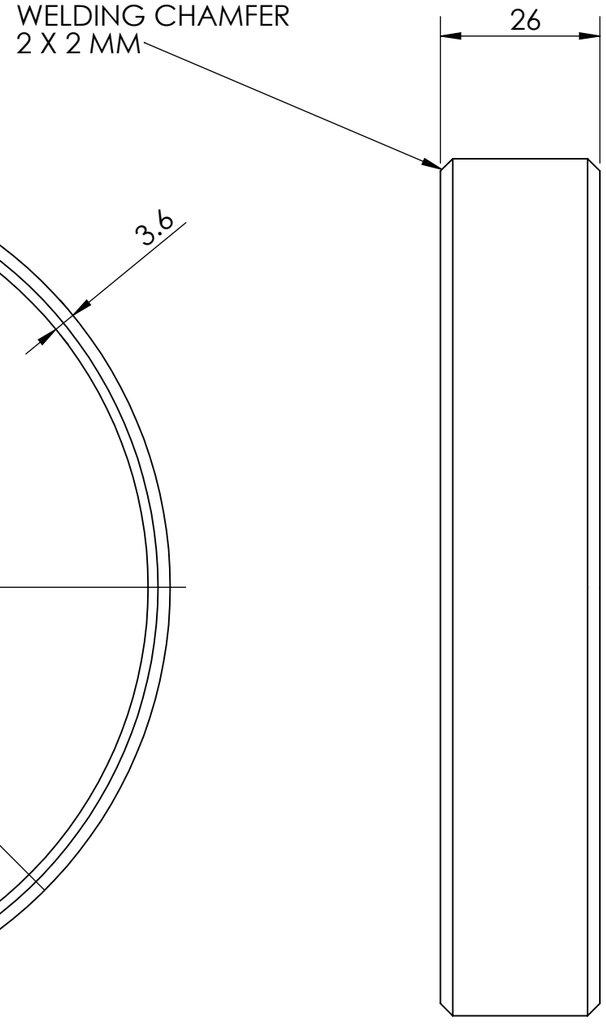


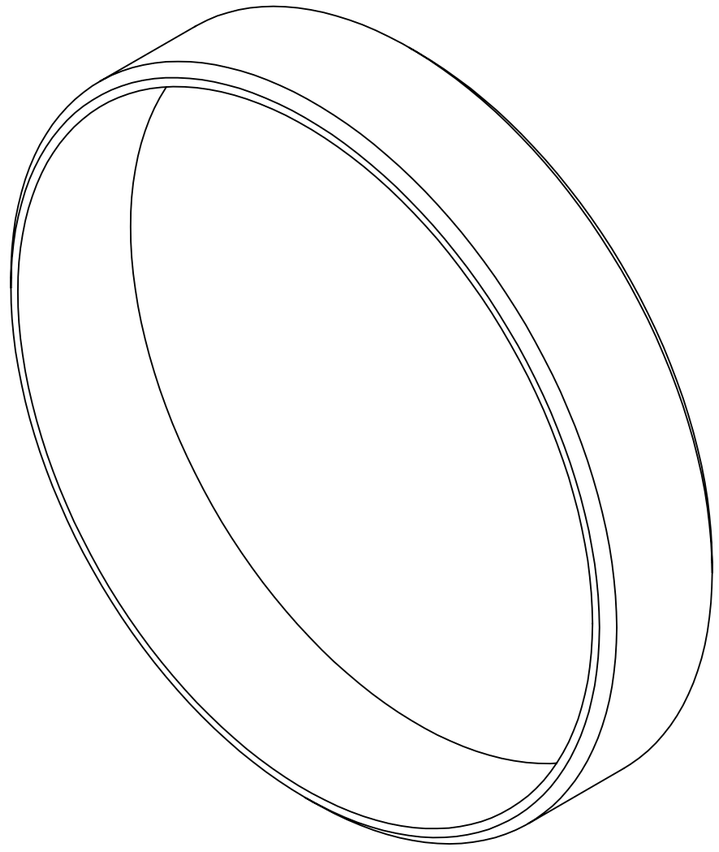
ITEM NO.	QTY.	DESCRIPTION	PART NO.	MATERIAL
3	1	Motor side flange	EXTPRO-V1 1110.03	Mild Steel
2	1	Screw side flange	EXTPRO-V1 1110.02	Mild Steel
1	1	Flange spacer	EXTPRO-V1 1110.01	Mild Steel

PRECIOUS PLASTIC

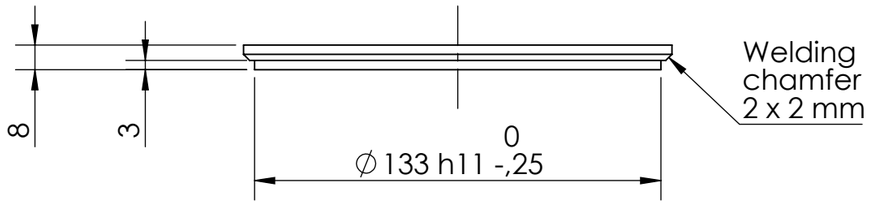
Machine: Extruder PRO			Description: Gearbox flange			
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1110.00			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:2	Sheet: 1 / 1	

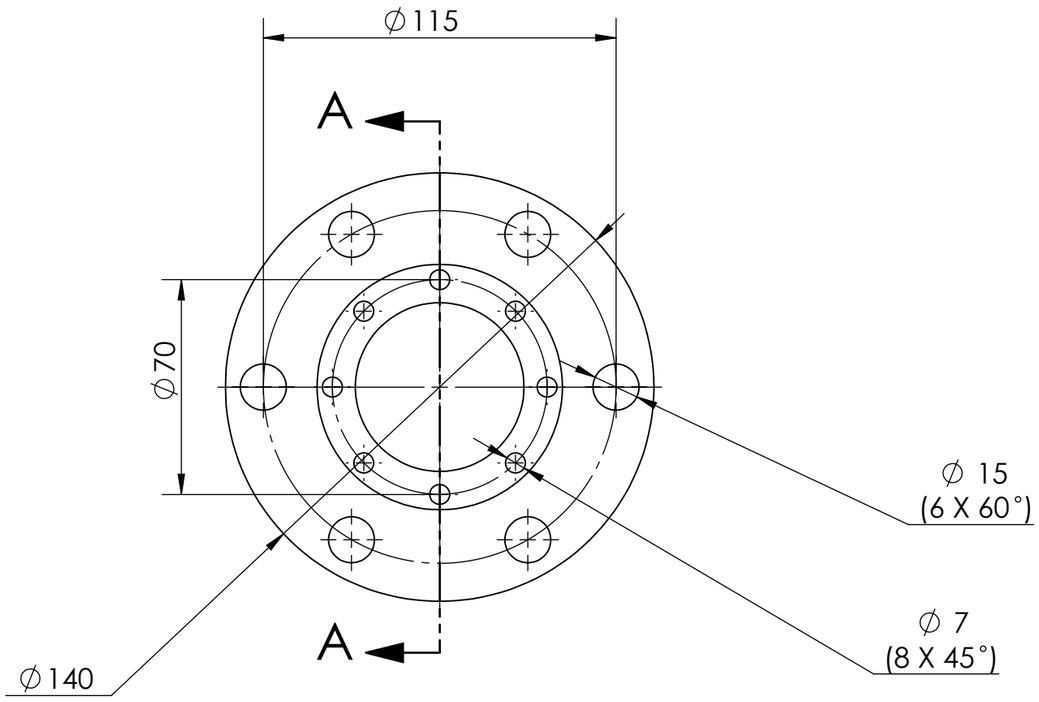


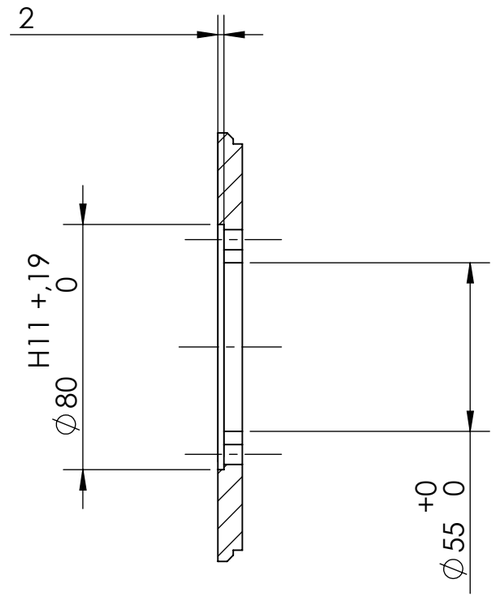




Weight: 0.5 kg		Material: Mild Steel				
Machine: Extruder PRO		Description: Motor side flange				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1110.01			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:1	Sheet: 1 / 1





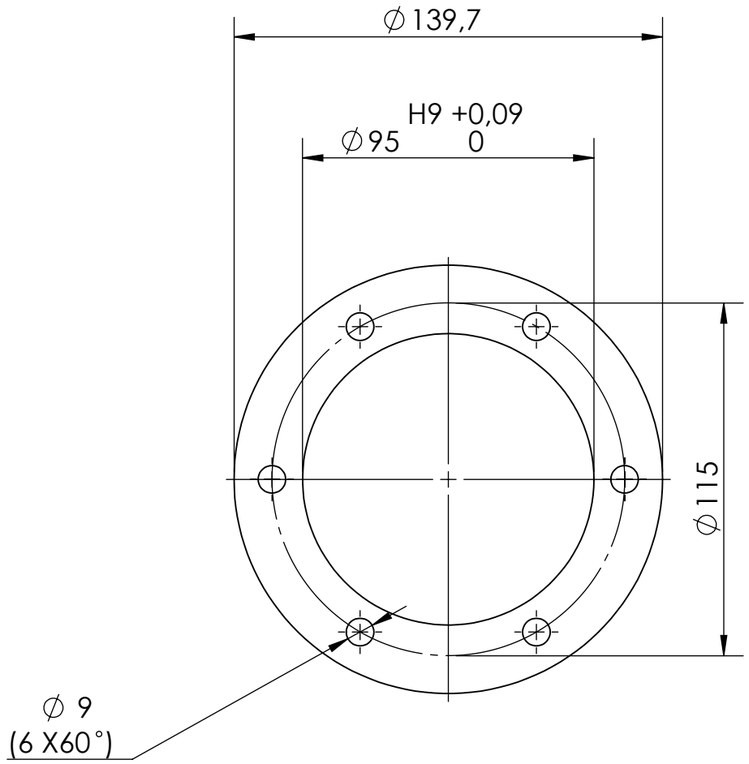


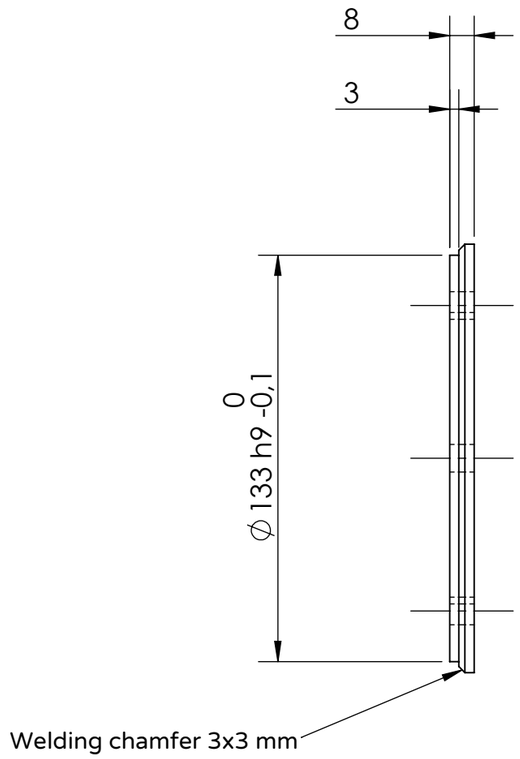
SECTION A-A

Stock material: laser cut plate 8mm S235JR

Weight: 0.6 kg	Material: Mild Steel				
Machine: Extruder PRO	Description: Screw side flange				
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1110.02			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

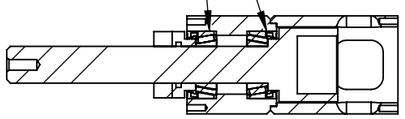
NOTES
1- USE LATHE TO CLAMP ON THE OUTER PART OF
THE PLANGE -» MACHINE INNER DIAMETER TO 95 MM H9
2 - CLAMP THE PART ON THE INSIDE -» MACHINE
THE OUTSIDE FEATURES (132.5 h9, 3MM DEEP)
AND MACHINE THE CHAMFER FOR WELDING



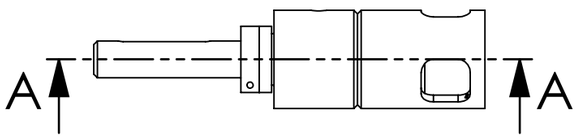


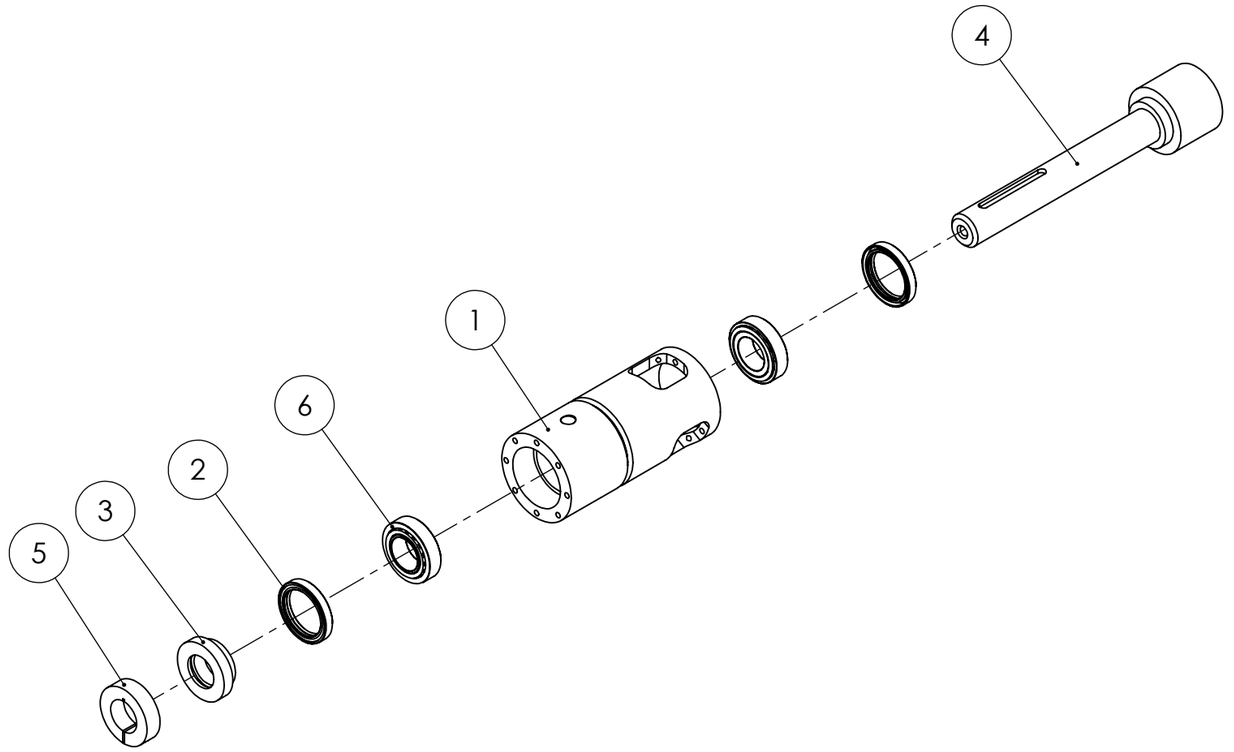
Weight: 0.5 kg	Material: Mild Steel				
Machine: Extruder PRO	Description: Motor side flange				
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1110.03			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

PAY ATTENTION TO THE TAPER BEARINGS ORIENTATION



SECTION A-A



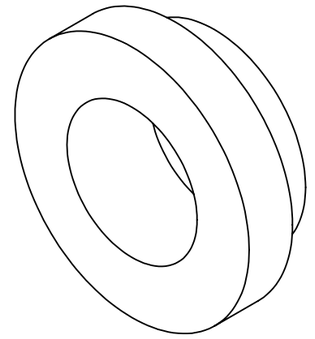


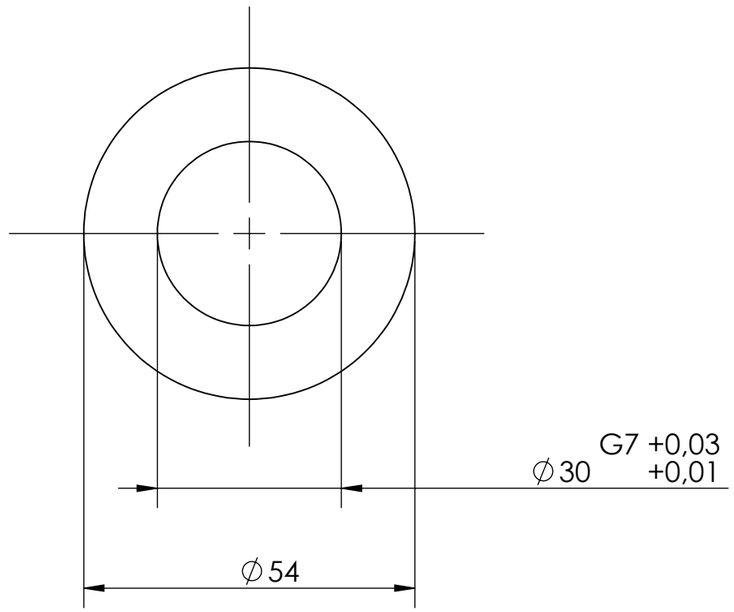
LUBRIFY THE BEARINGS WITH BALL BEARING GREASE BEFORE ASSEMBLY.
GREASE EVERY MONTH.

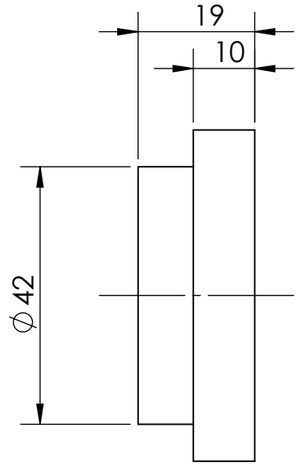
ITEM NO.	QTY.	DESCRIPTION	PART NO.	MATERIAL
6	2	Tapered bearing 32006X	EXTPRO-V1 04	-
5	1	Shaft Clamp	EXTPRO-V1 03	Steel
4	1	Coupling Shaft	EXTPRO-V1 1120.02	C45
3	1	Seal bearing spacer	EXTPRO-V1 1120.01	Mild Steel
2	2	Bearing seal - DIN3760 AS 42x55x8	EXTPRO-V1 02	Rubber
1	1	Bearing body	EXTPRO-V1 1121.00	-

PRECIOUS PLASTIC

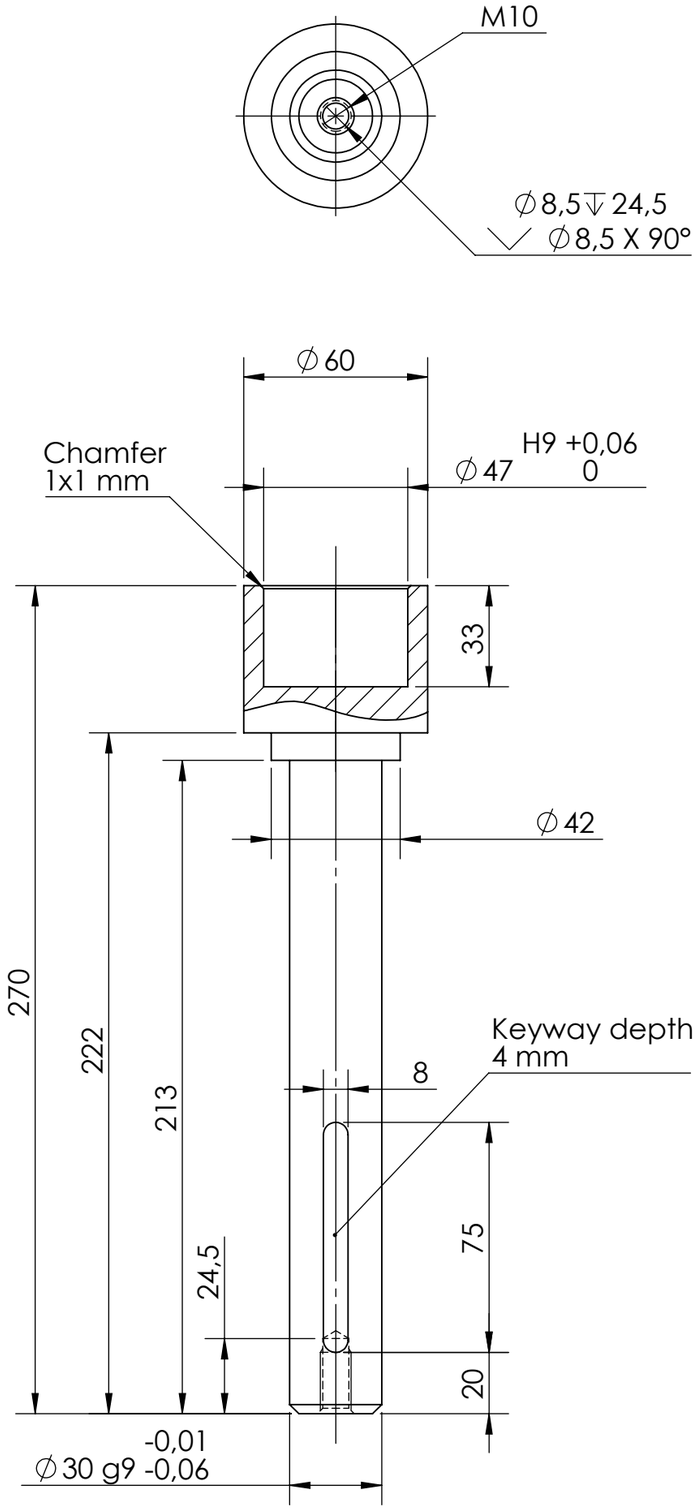
Machine: Extruder PRO			Description: Bearing Body Assembly			
Projection method: First angle			Release date: 07/01/20	Drawing no.: EXTPRO-V1 1121.00		Rev.: A
General tolerances: ISO 2768-m			Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:2	Sheet: 1 / 1

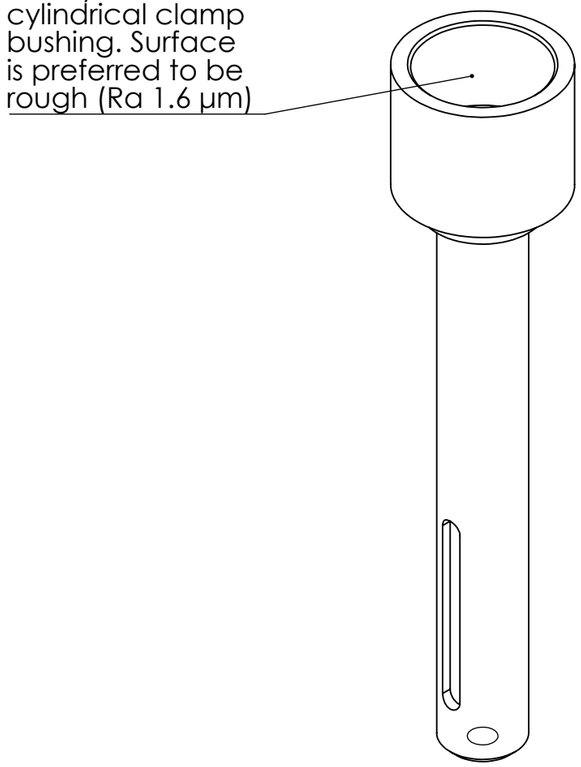






Weight: 0.2 kg			Material: Mild Steel		
Machine: Extruder PRO			Description: Seal bearing spacer		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1120.01			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1



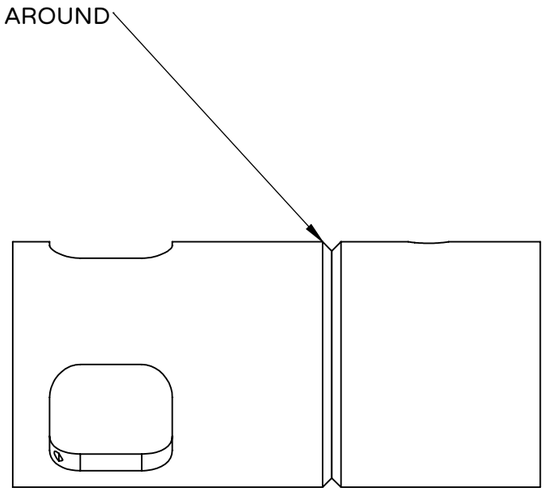


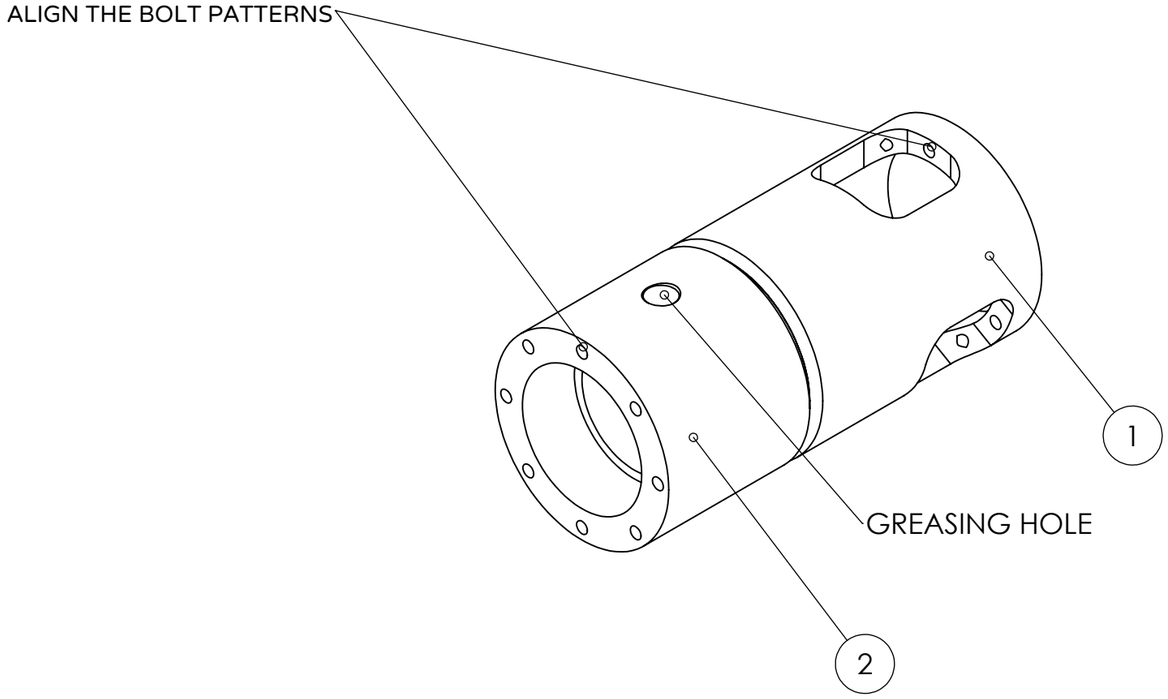
NOTE: Shaft length & diameter may vary, depending on choice of motor and transmission.

Weight: 1.8 kg		Material: C45			
Machine: Extruder PRO		Description: Coupling Shaft			
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1120.02			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

NOTES:

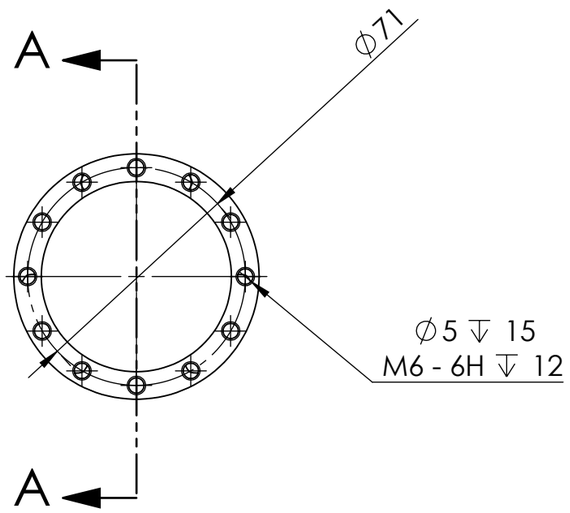
- POINT WELD TO ASSEMBLE THE PARTS
- TIG WELD ALL AROUND

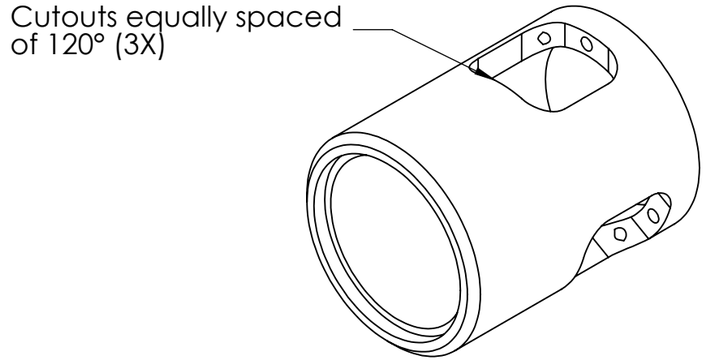


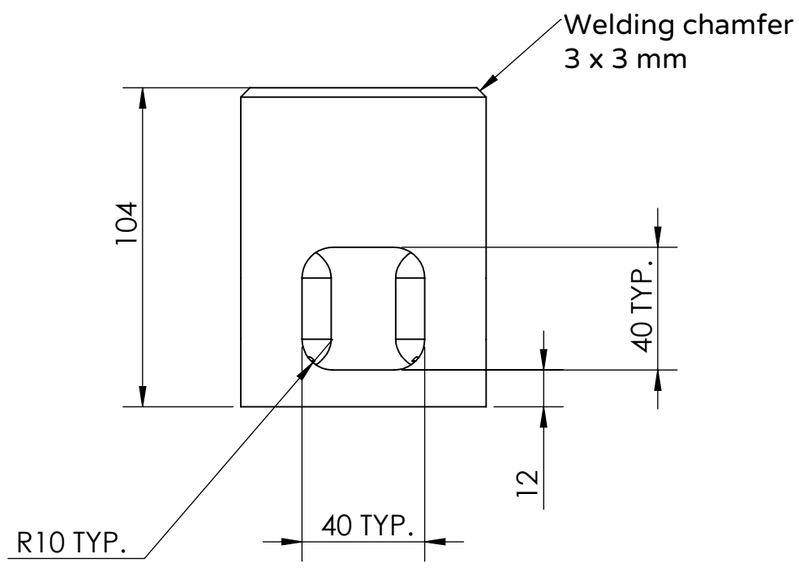


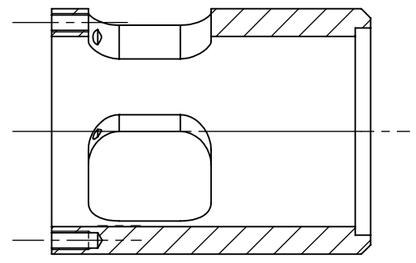
ITEM NO.	QTY.	Part number	DRAWING NO.	MATERIAL
2	1	Bearing body	EXTPRO-V1 1121.02	Mild Steel
1	1	Transition Piece	EXTPRO-V1 1121.01	Mild Steel

	Machine: Extruder PRO		Description: Bearing body			
	Projection method: First angle		Release date: 07/11/20	Drawing no.: EXTPRO-V1 1121.00		Rev.: A
	General tolerances: ISO 2768-m		Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:2	Sheet: 1 / 1



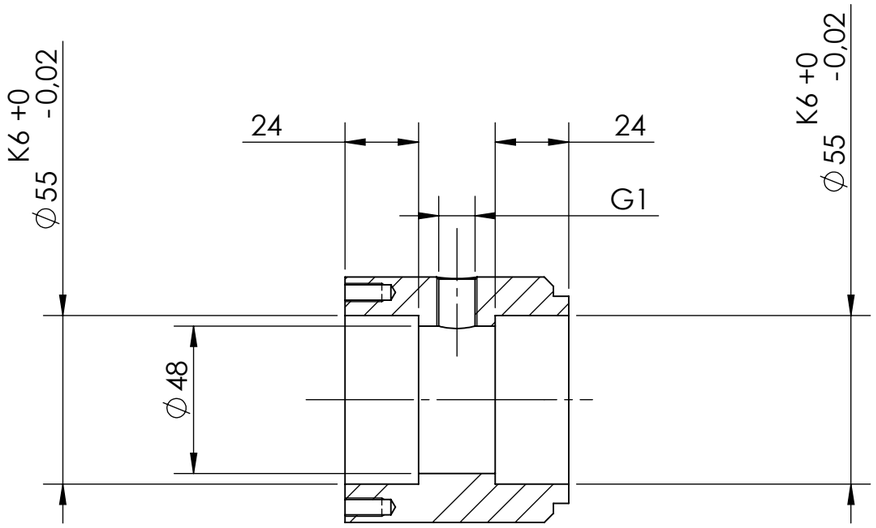




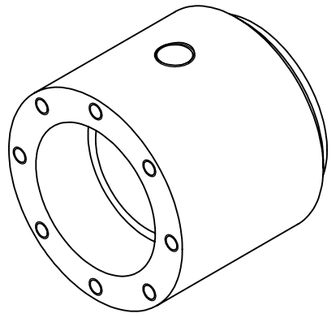


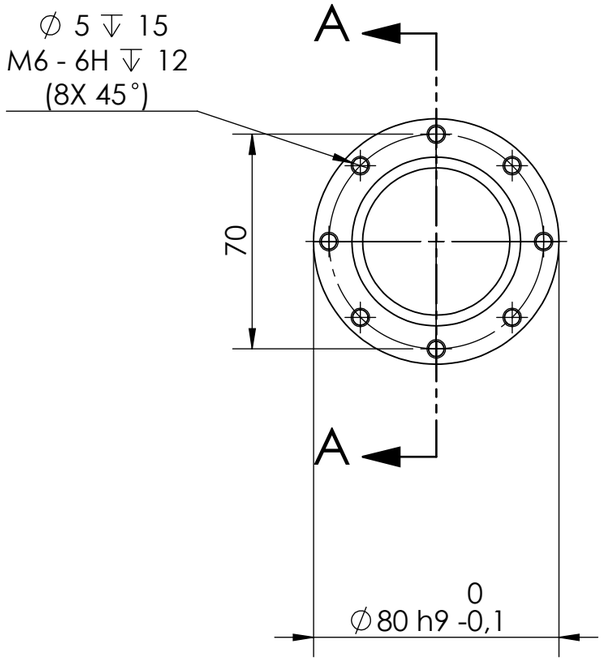
SECTION A-A

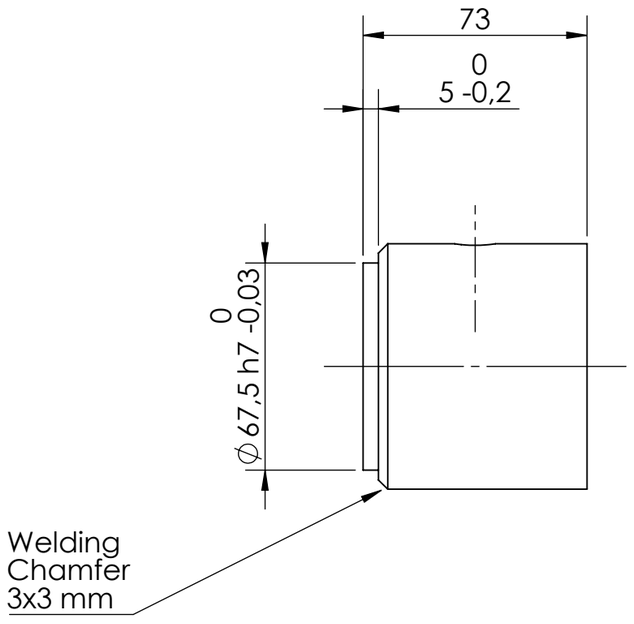
Weight: 1.2 kg	Material: Mild Steel				
Machine: Extruder PRO	Description: Transition piece				
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1121.01			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1



SECTION A-A

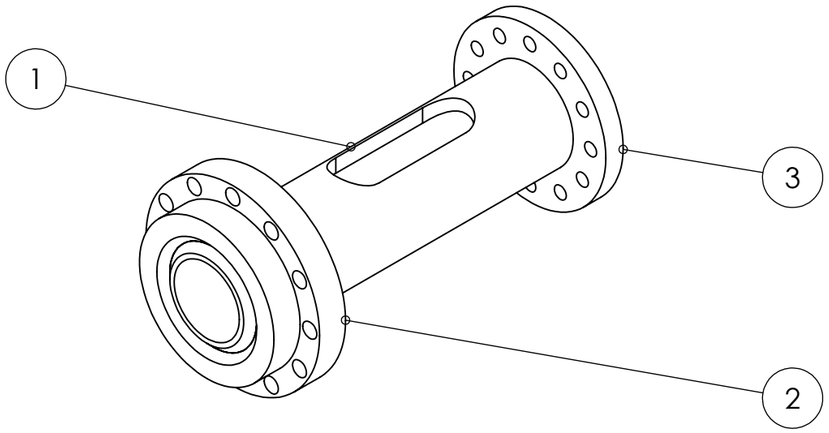


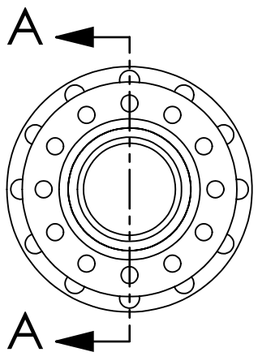


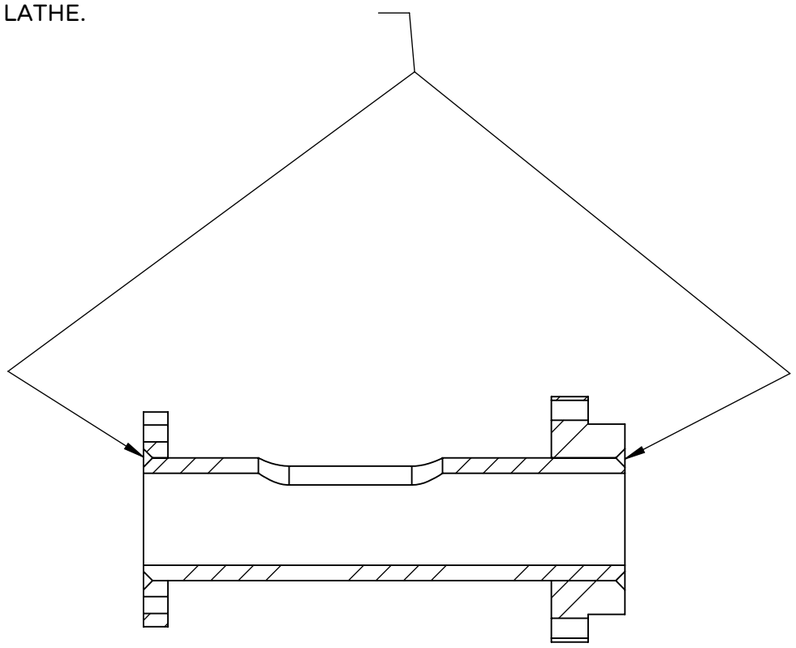


Weight: 1.5 kg		Material: Mild Steel				
Machine: Extruder PRO		Description: Bearing Body				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1121.02			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

NOTES:
- ALIGN THE BOLT PATTERNS TOGETHER (YOU CAN USE LONG BOLTS).
- POINT WELD AND MAKE SURE EVERYTHING IS SQUARE.
- TIG WELD IN THE CHAMFERS ALL AROUND THE PARTS.
- FACE THE WELDING EXCESS ON THE LATHE.





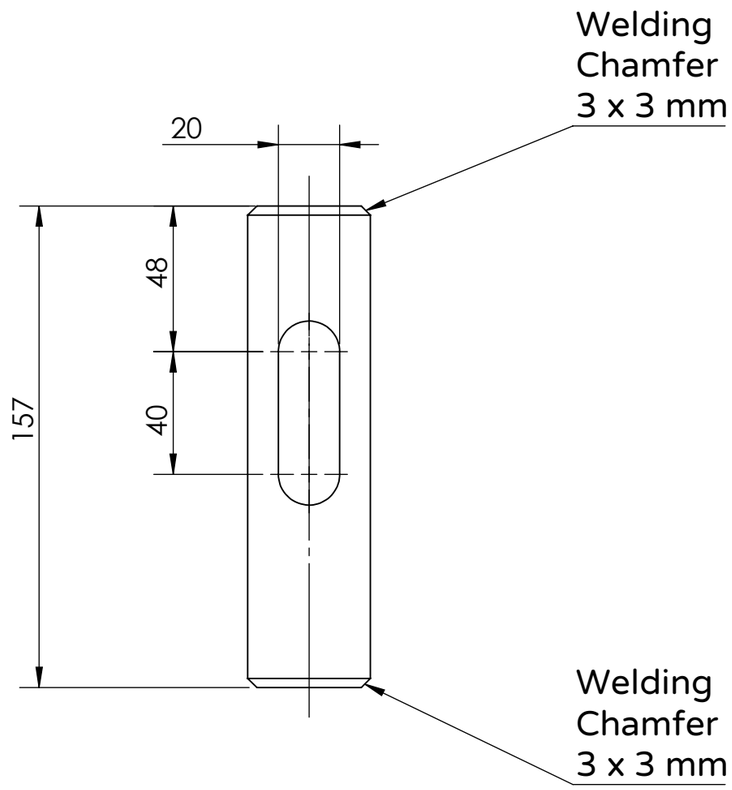


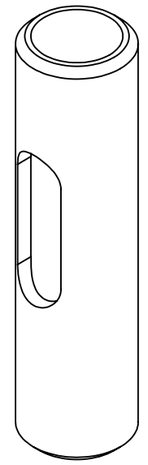
SECTION A-A

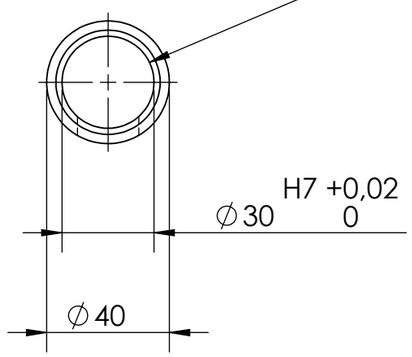
ITEM NO.	QTY.	Numéro de pièce	PART NO.	MATERIAL
3	1	Barrel flange 2	EXTPRO-V1 1130.03	Mild Steel
2	1	Barrel flange 1	EXTPRO-V1 1130.02	Mild Steel
1	1	Barrel inlet	EXTPRO-V1 1130.01	Mild Steel

PRECIOUS PLASTIC

Machine: Extruder PRO		Description: Barrel inlet			
Projection method: First angle	Release date: 07/11/20	Drawing no.: EXTPRO-V1 1130.00	Rev.: A		
General tolerances: ISO 2768-m	Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:2	Sheet: 1 / 1

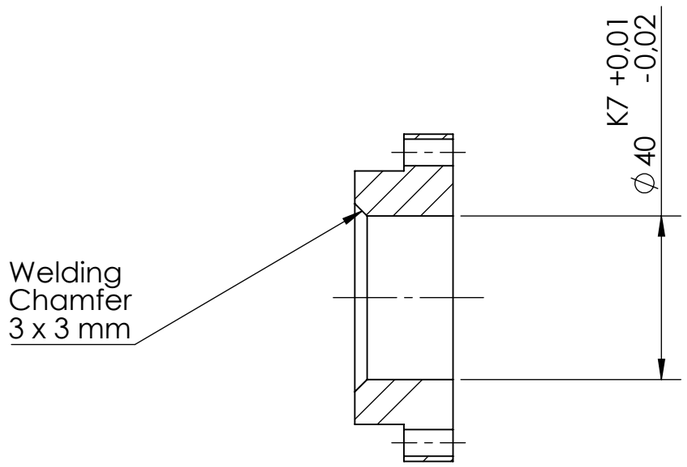




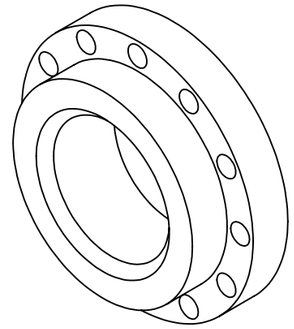


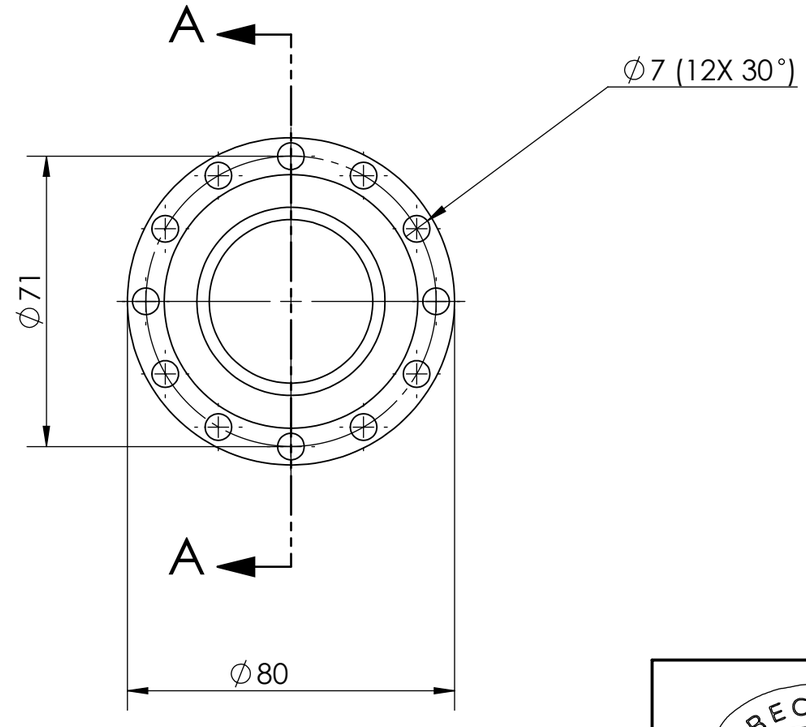
Stock material: Seamless tube 40 x 5 mm,
according to DIN 2391 standard

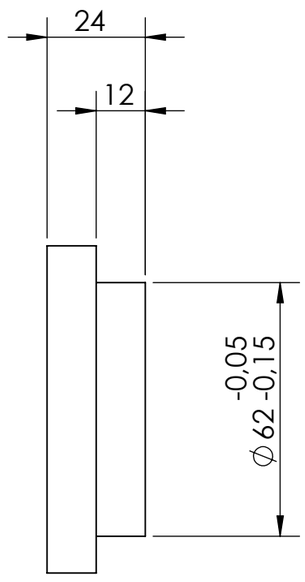
Weight: 0.6 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Barrel inlet			
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1130.01			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1



SECTION A-A

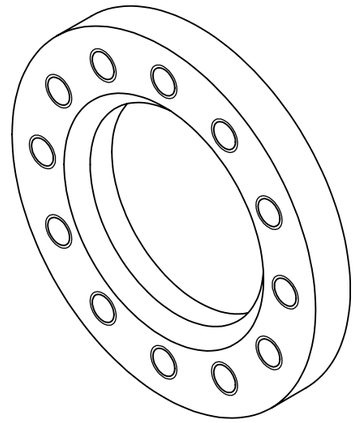


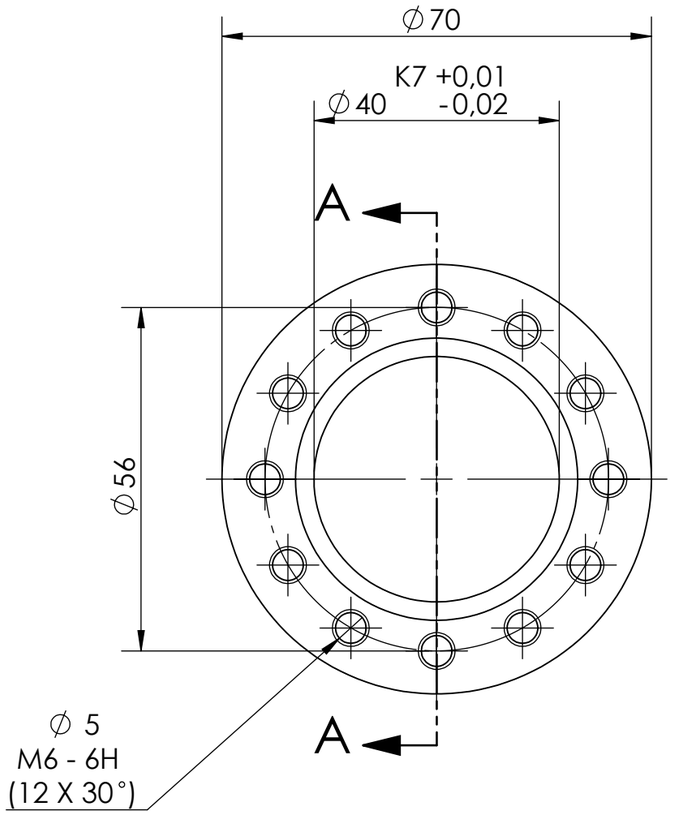


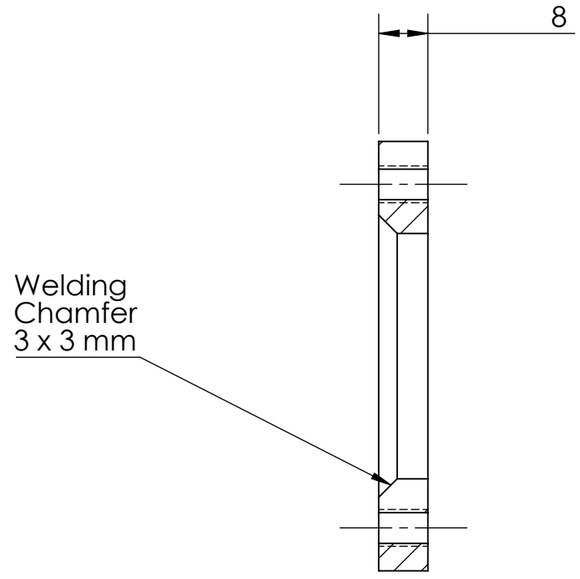


Weight: 0.5 kg		Material: Mild Steel				
Machine: Extruder PRO		Description: Barrel flange 1				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1130.02			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

- Base part is a laser cutted part.
- Material to be S235JR or stronger with good weldability
- Inner diameter and chamfer to be machined on a lathe has 2 mm extra material
- Holes to be drilled and tapped, position to be determined using either this drawing as a template, or spotting by a laser cutter



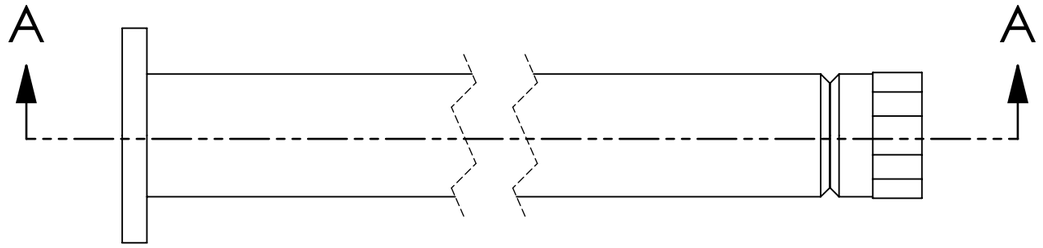




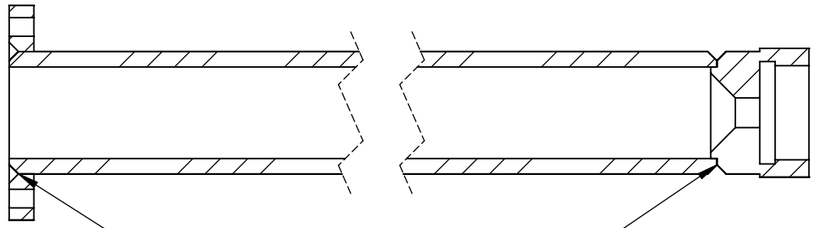
SECTION A-A

Stock material: laser cutted plate 8mm S235JR

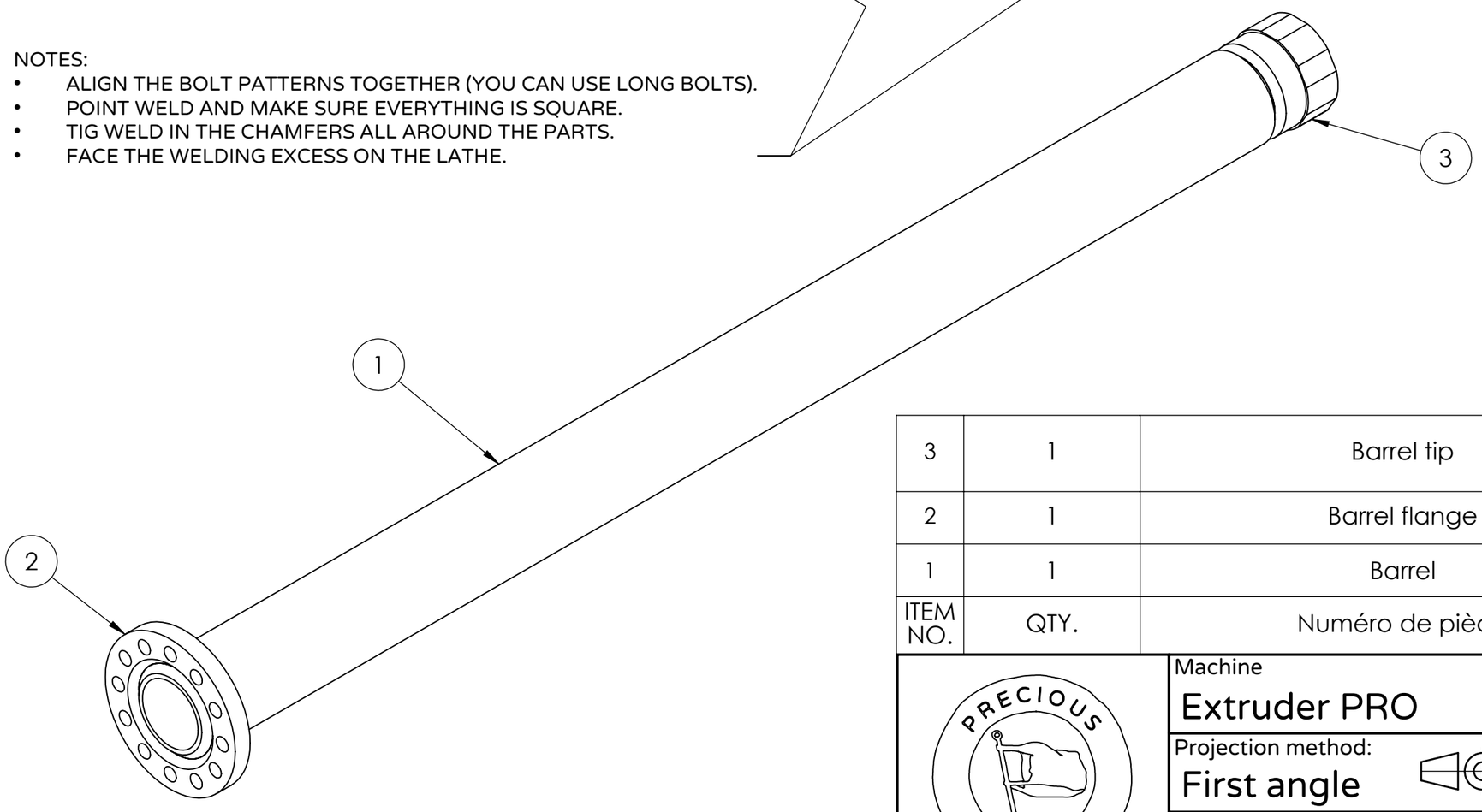
Weight: 0.1 kg		Material: Mild Steel				
Machine: Extruder PRO		Description: Barrel Flange 2				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1130.03			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1



SECTION A-A



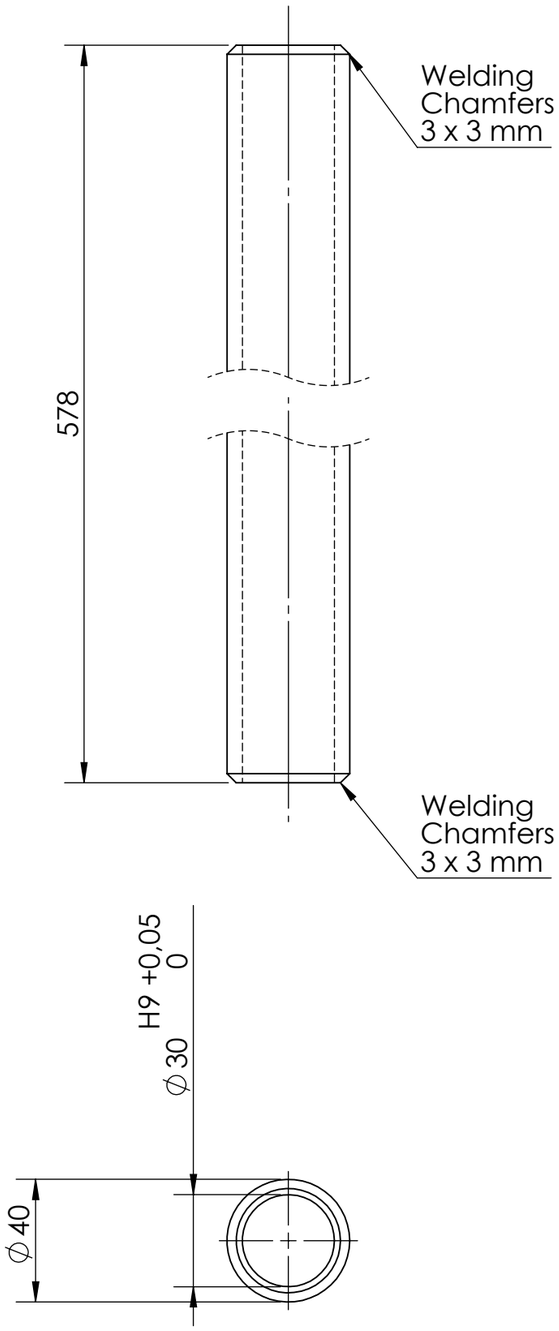
NOTES:
- ALIGN THE BOLT PATTERNS TOGETHER (YOU CAN USE LONG BOLTS).
- POINT WELD AND MAKE SURE EVERYTHING IS SQUARE.
- TIG WELD IN THE CHAMFERS ALL AROUND THE PARTS.
- FACE THE WELDING EXCESS ON THE LATHE.

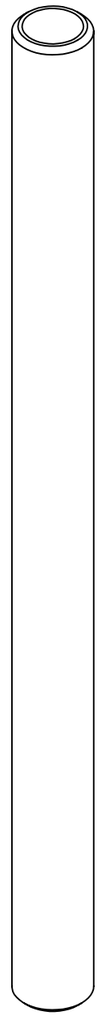


ITEM NO.	QTY.	Numéro de pièce	PART NO.	MATERIAL
3	1	Barrel tip	EXTPRO-V1 1140.03	Mild Steel
2	1	Barrel flange	EXTPRO-V1 1140.02	Mild Steel
1	1	Barrel	EXTPRO-V1 1140.01	Mild Steel

PRECIOUS PLASTIC

Machine: Extruder PRO			Description: Barrel			
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1140.00			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:2	Sheet: 1 / 1



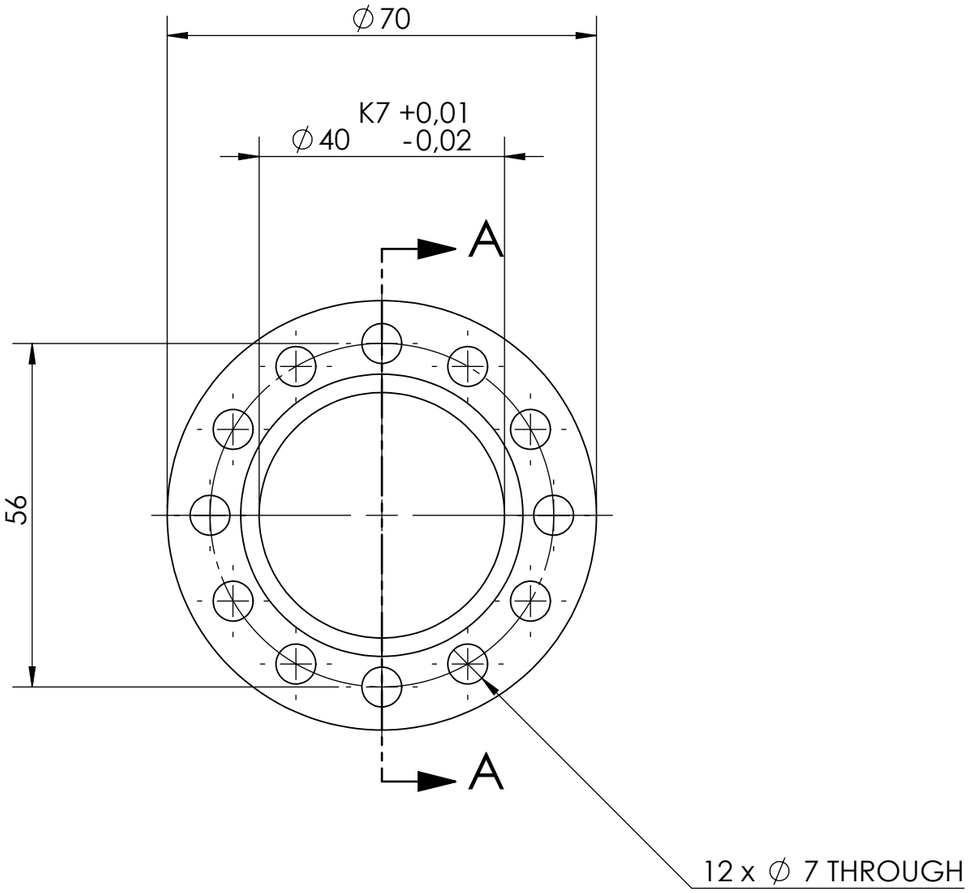


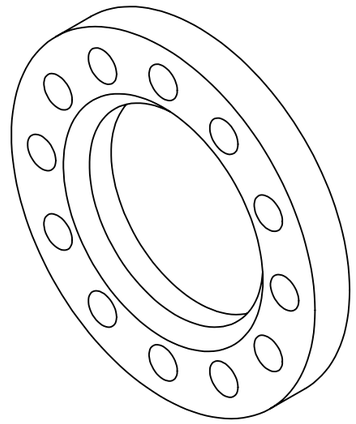
Tube has to have a
loose fit with the screw.
Use a hand reamer
(30 mm H9) if neccesary
to clean up the inner

Stock material: Seamless tube according to DIN 2391,
outside diameter: 40 mm, Wall thickness: 5 mm

Weight: 2.5 kg		Material: Mild Steel				
Machine: Extruder PRO		Description: Barrel				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1140.01			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

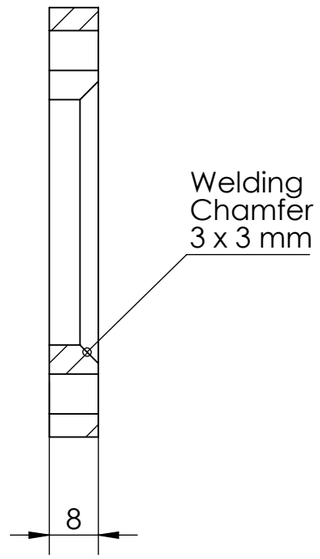
- Base part is a laser cutted part.
- Material to be s235JR or stronger with good weldability
- Inner diameter and chamfer to be machined on a lathe has 2 mm extra material
- Holes to be drilled, position to be determined using either this drawing as a template, or spotting by a laser cutter





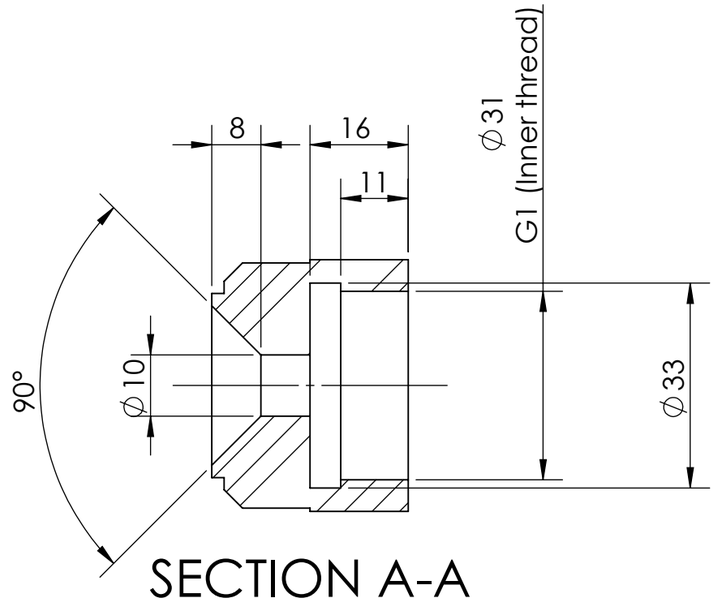
Section

A-A

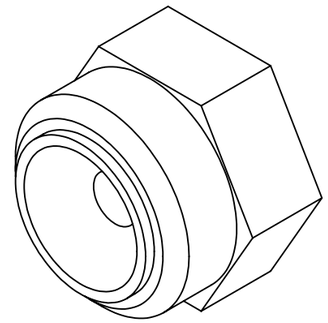


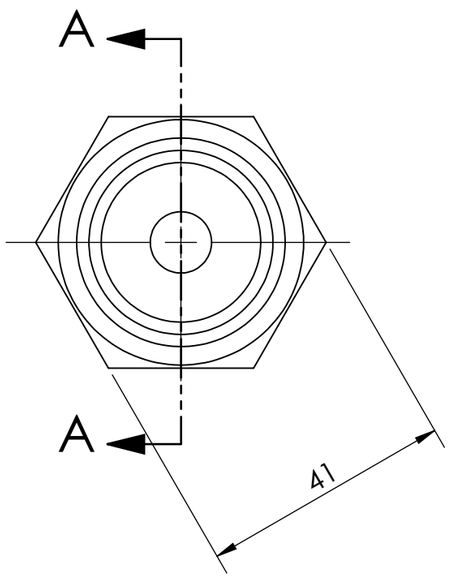
Stock material: Laser cutted plate, 8mm S235JR

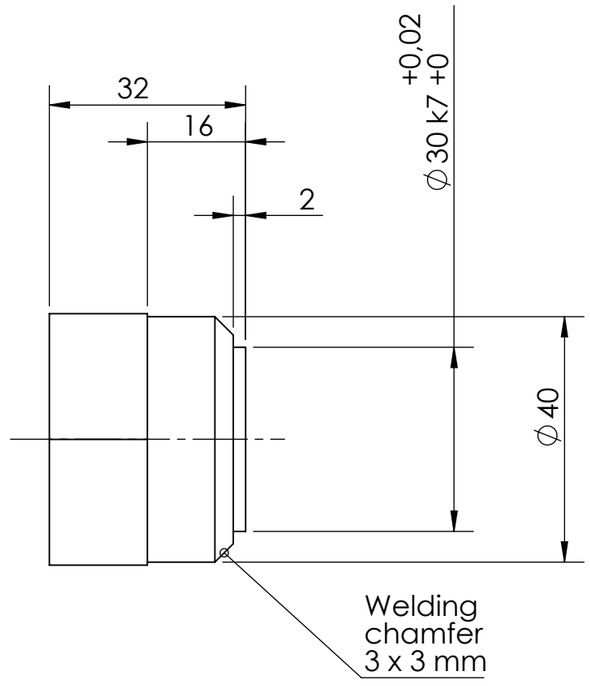
Weight: 0.1 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Barrel flange			
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 1140.02			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1



SECTION A-A

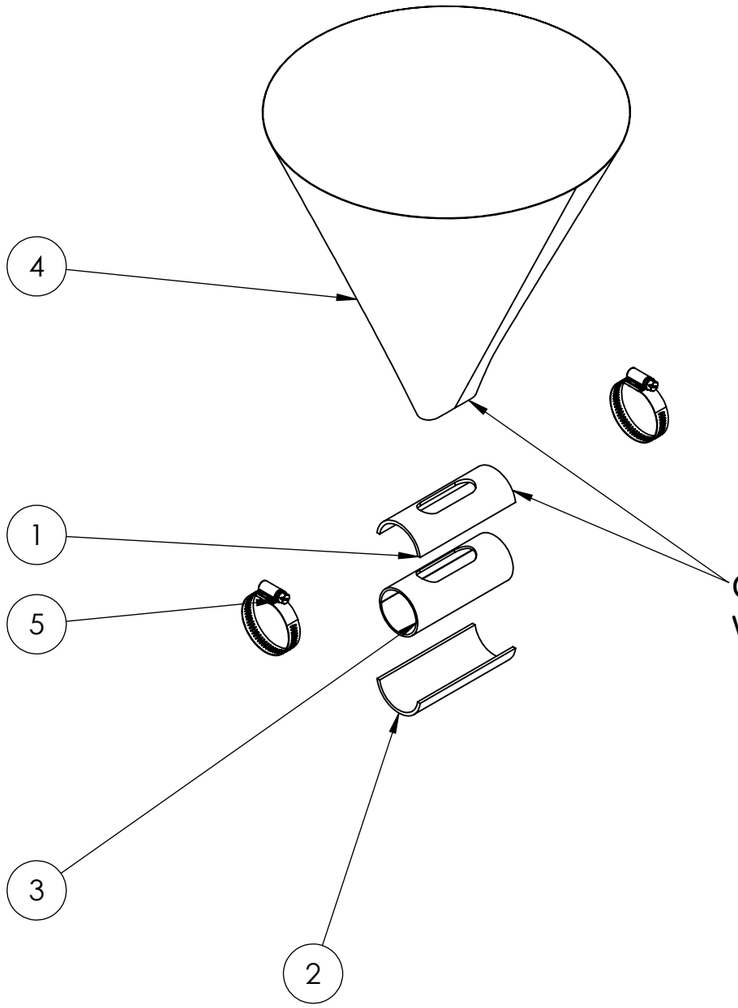






Stock material: Hexagon rod 41 mm, S235JR or stronger
(has to be weldable)

Weight: 0.2 kg	Material: Mild Steel				
Machine: Extruder PRO	Description: Barrel Tip				
Projection method: First angle	Release date: 11/2019	Drawing no.: EXTPRO-V1 1140.03			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

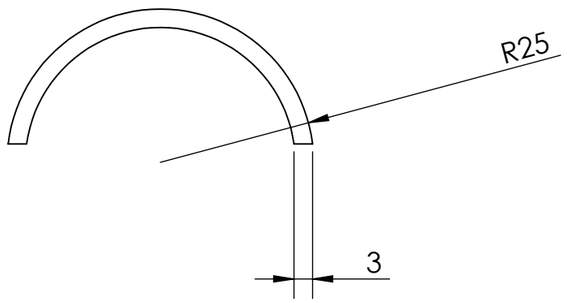


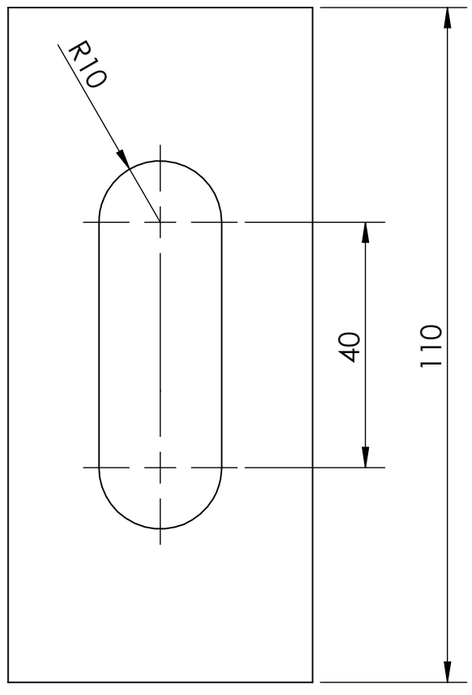
Carefully weld Item 4 onto Item 1. Be careful not to go through.
Welding from inside the Item 1 and sanding afterwards might be easier.

ITEM NO.	QTY.	DESCRIPTION	PART NO.	MATERIAL
5	2	Worm drive clamp 50 mm	EXTPRO-V1 10	Steel
4	1	Cone	EXTPRO-V1 1200.04	Mild Steel
3	1	Insulation	EXTPRO-V1 1200.03	Insulation Paper
2	1	Bottom	EXTPRO-V1 1200.02	Mild Steel
1	1	Top	EXTPRO-V1 1200.01	Mild Steel

PRECIOUS PLASTIC

Machine: Extruder PRO			Description: Cone Hopper Assembly		
Projection method: First angle			Release date: 07/01/20	Drawing no.: EXTPRO-V1 1201.00	Rev.: A
General tolerances: ISO 2768-m			Doc. type: Assembly	Units unless specified: mm	Sheet size: A3 / Scale: 1:3 / Sheet: 1 / 1

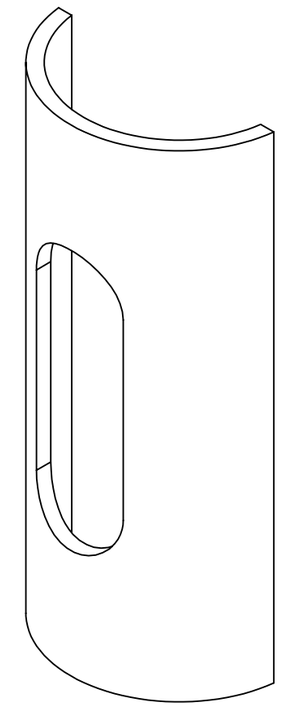




NOTES :

THIS PART IS MADE OUT OF A 50 MM DIAMETER PIPE CUT IN HALF ON THE LENGHT

THE OTHER HALF IS USED FOR THE PART : EXTPRO-V1 1200.02

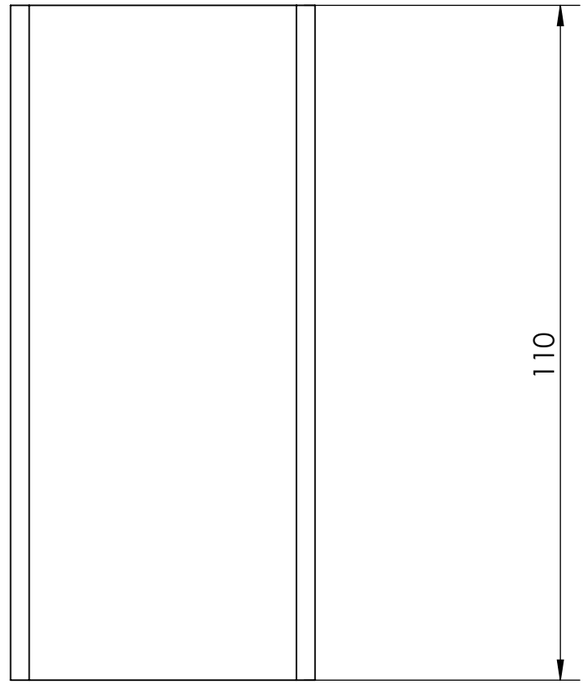


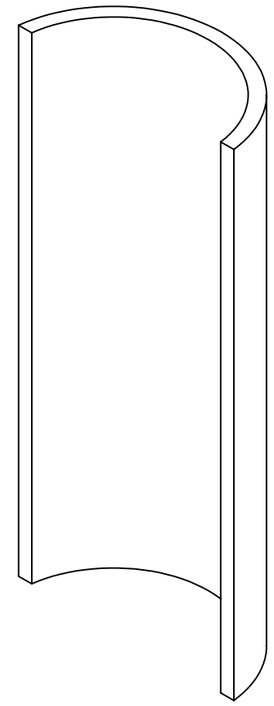
Weight: 0.6 kg		Material: Mild Steel				
Machine: Extruder PRO		Description: Top				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1200.01			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:1	Sheet: 1 / 1

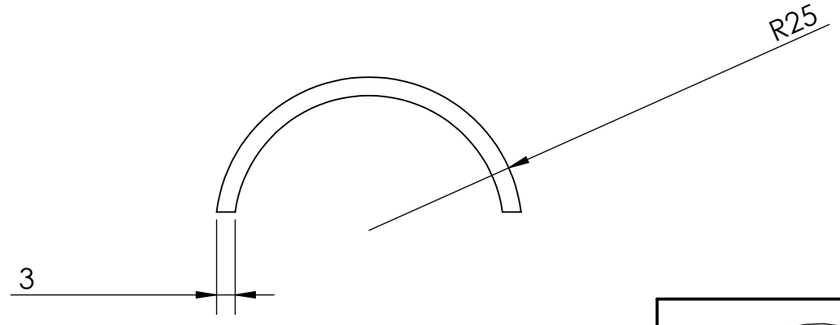
NOTES :

THIS PART IS MADE OUT OF A 50 MM DIAMETER PIPE CUT IN HALF ON THE LENGHT

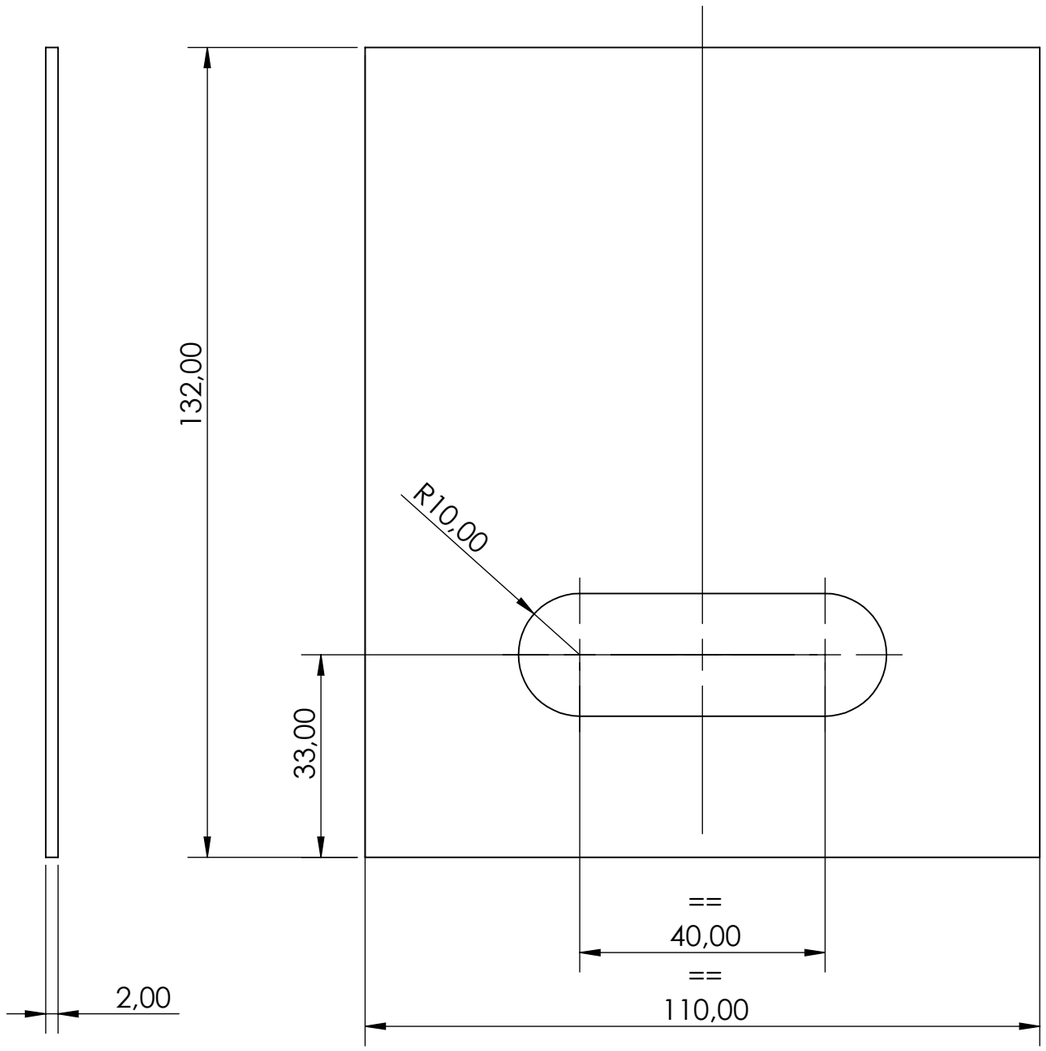
THE OTHER HALF IS USED FOR THE PART : EXTPRO-V1 1200.01

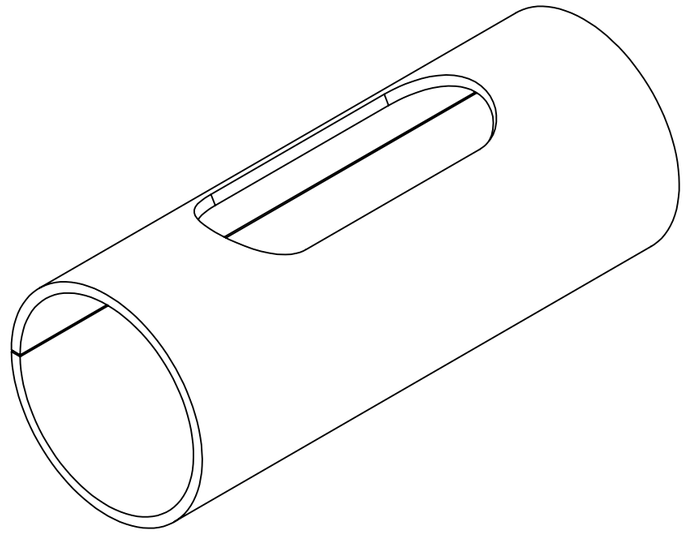






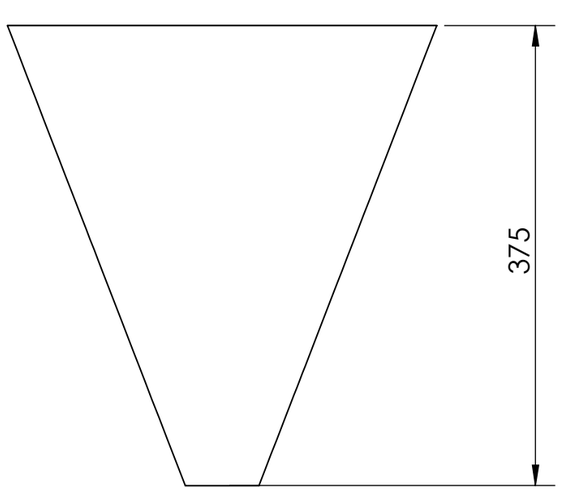
Weight: 0.6 kg			Material: Mild Steel		
Machine: Extruder PRO			Description: Bottom		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 120002			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:1	Sheet: 1 / 1

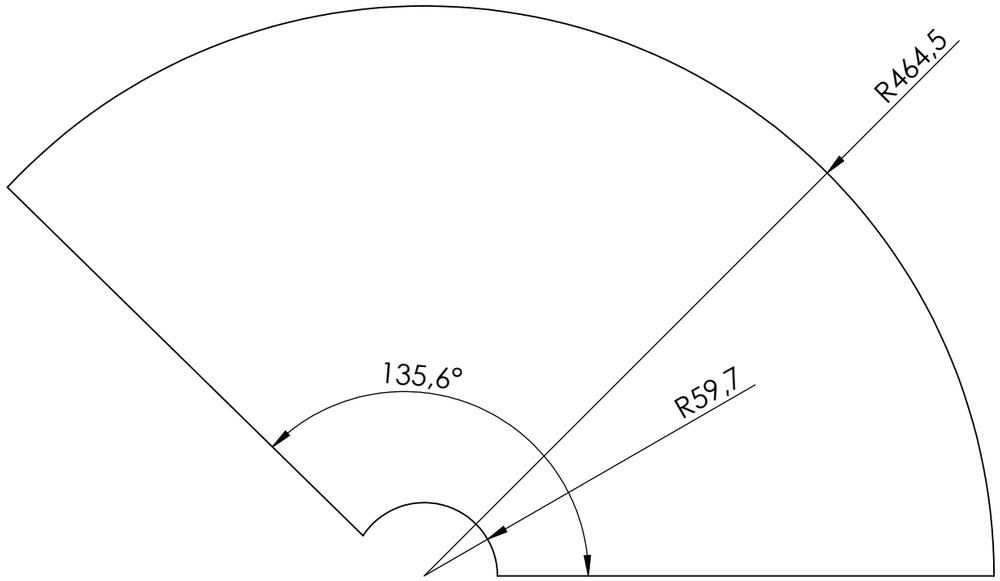


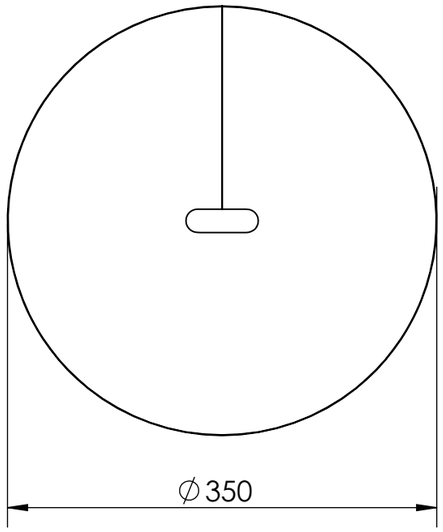


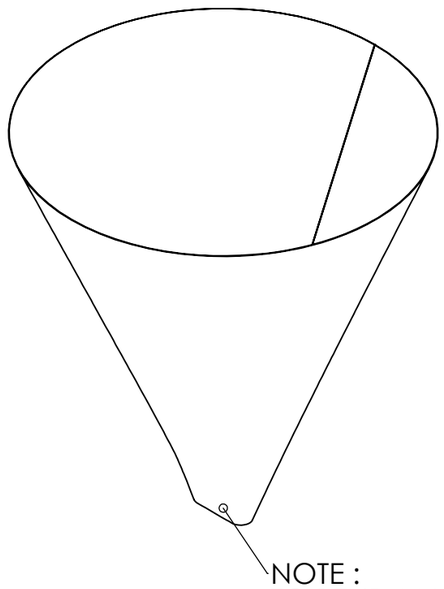
NOTES:
INSULATION CORK TO ROLL AROUND THE DIAMETER 40MM BARREL INLET

Weight: 0.1 kg		Material: Cork				
Machine: Extruder PRO		Description: Insulation				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1200.03			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:1	Sheet: 1 / 1



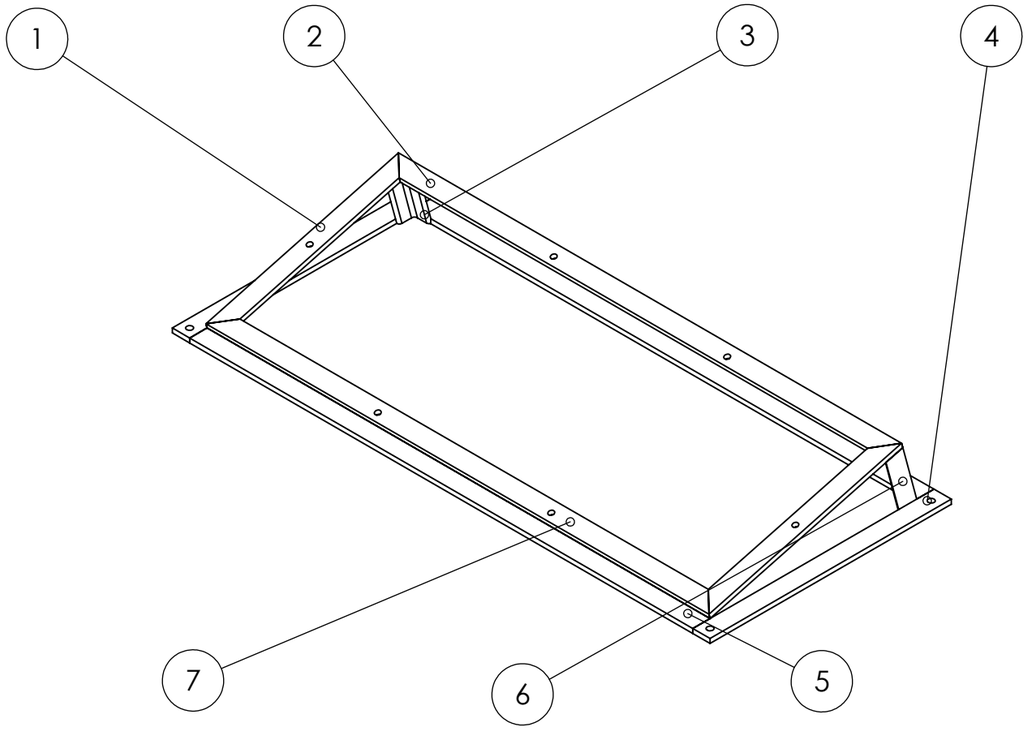


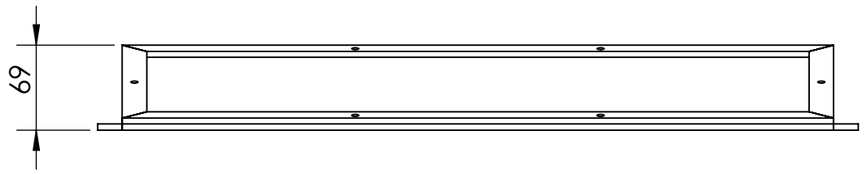


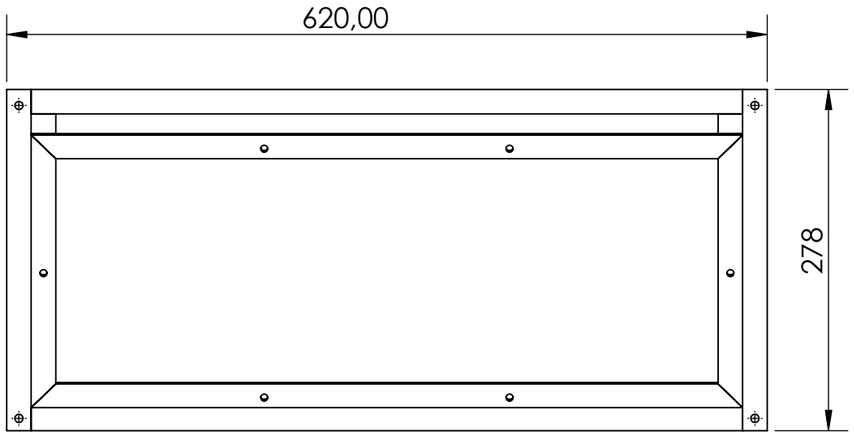


NOTE :
TO BEND MANUALY TO FIT THE HALF TUBE INLET

Weight: 0.6 kg			Material: 0.5 mm thick steel sheet		
Machine: Extruder PRO			Description: Cone hopper		
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 1200.04		Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 1 / 1



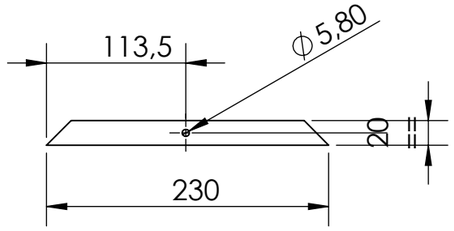




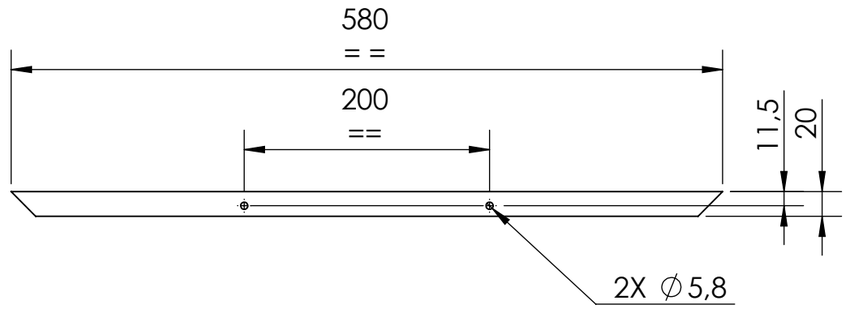
ITEM NO.	QTY.	DESCRIPTION	LENGTH	ANGLE1	ANGLE2	MATERIAL
7	1	Flat bar 20 x 5 mm	580	45°	45°	Mild steel
6	1	L angle 20 x 20 x 3 mm	66,5	-	0°	Mild steel
5	2	Flat bar 20 x 5	580	0°	0°	Mild steel
4	2	Flat bar 20 x 5 mm	278	0°	0°	Mild steel
3	1	L angle 20 x 20 x 3 mm	66,5	-	0°	Mild steel
2	1	Flat bar 20 x 5 mm	580	45°	45°	Mild steel
1	2	Flat bar 20 x 5 mm	230	45°	45°	Mild steel

PRECIOUS PLASTIC

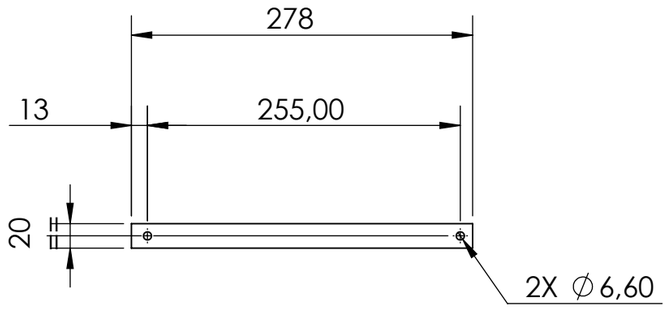
Weight: 2,6 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Electronics box support			
Projection method: First angle	Release date: 07/11/20	Drawing no.: EXTPRO-V1 2000.01	Rev.: A		
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 1 / 2



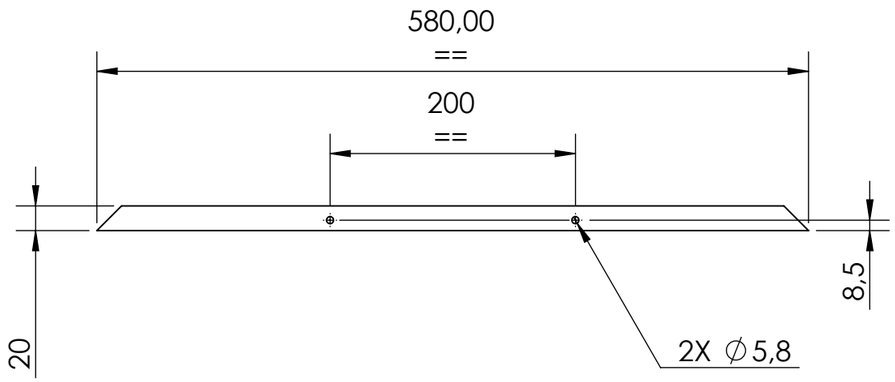
ITEM 1 : FLAT BAR 20 X 5 MM



ITEM 2 : FLAT BAR 20 X 5 MM

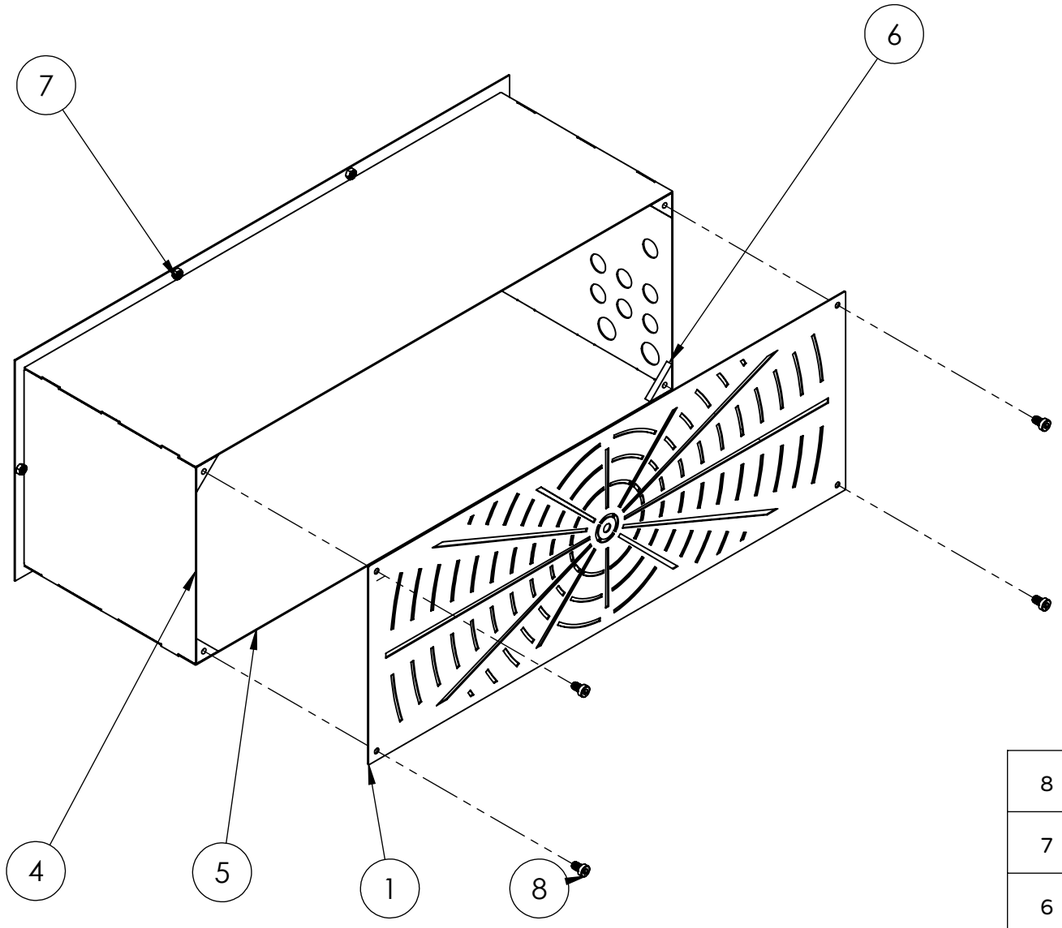


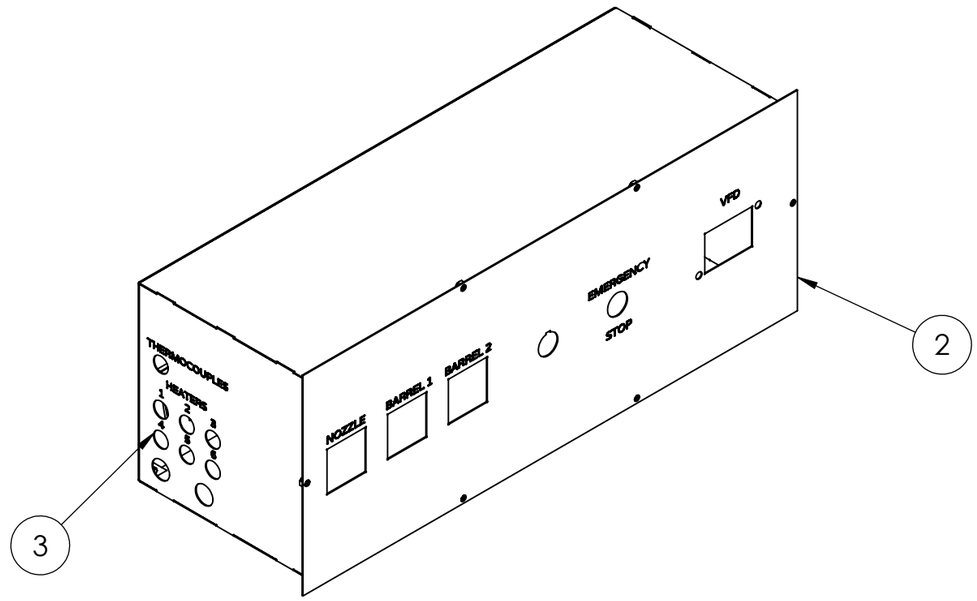
ITEM 4 FLAT BAR 20 X 5 MM



ITEM 7: FLAT BAR 20 X 5 MM

Weight: 2,6 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Electronics box support			
Projection method: First angle		Release date: 07/11/20	Drawing no.: EXTPRO-V1 2000.01		Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 2/2



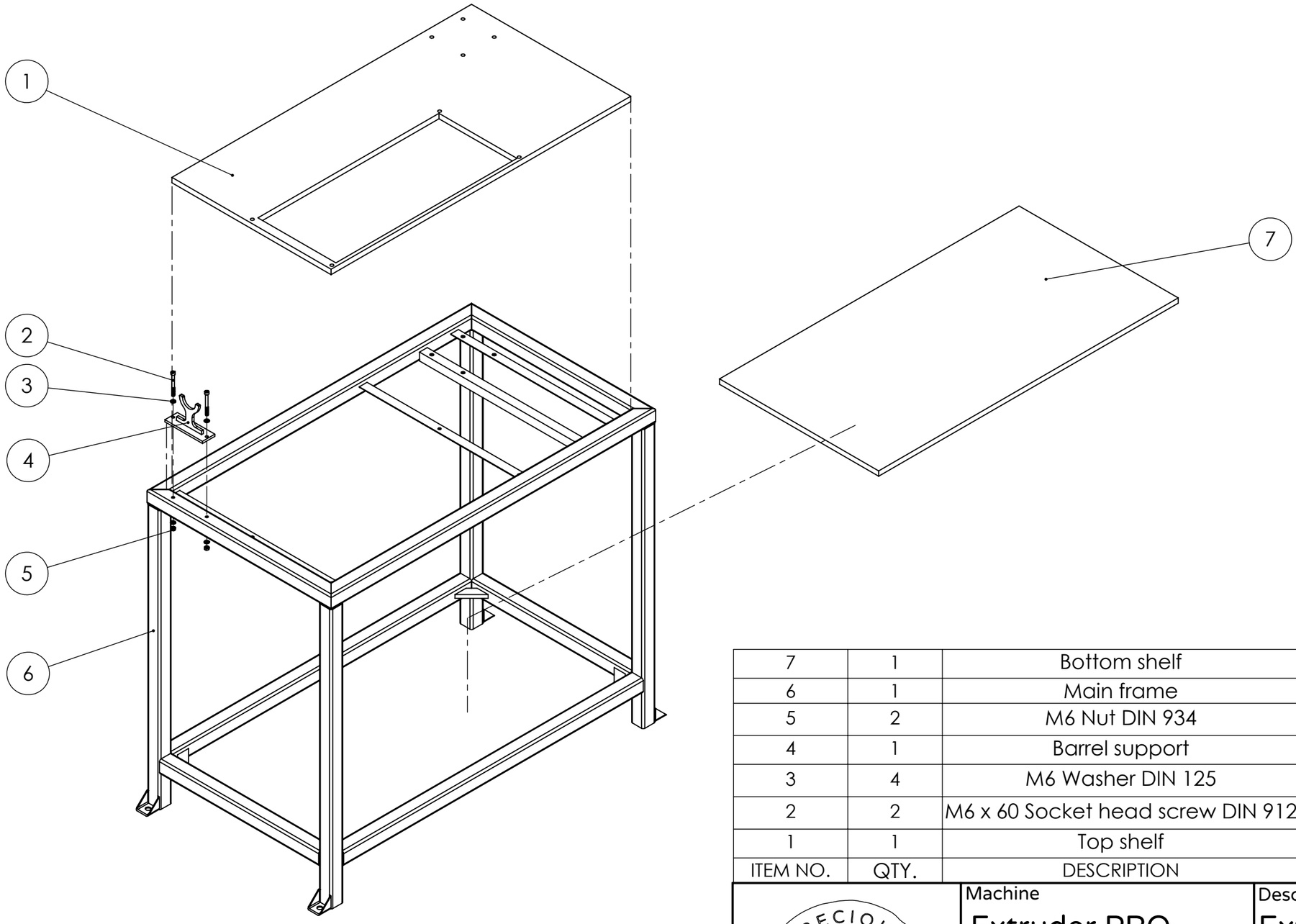


ITEM NO.	QTY.	Numéro de pièce	PART NO.	MATERIAL
8	4	M6 x 10 mm Socket Head Screw DIN 7984	EXTPRO-V1 15	Steel
7	6	M5 Hex. Nut DIN 934	EXTPRO-V1 14	Steel
6	4	Cover attachment Thick. 1 mm	EXTPRO-V1 2100.06	Mild Steel
5	2	Side 3 Thick. 1 mm	EXTPRO-V1 2100.05	Mild Steel
4	1	Side 1 Thick. 1 mm	EXTPRO-V1 2100.04	Mild Steel
3	1	Side 2 Thick. 1 mm	EXTPRO-V1 2100.03	Mild Steel
2	1	Front Thick. 1 mm	EXTPRO-V1 2100.02	Mild Steel
1	1	Cover Thick. 1 mm	EXTPRO-V1 2100.01	Mild Steel

-Items 1 through 6 are laser cut. Find corresponding .DXF files in the download kit.
-Point weld together items 2 through 6
-Align the M5 nuts (EXTPRO-V1 14) on the holes with bolts and point weld the nuts in place

PRECIOUS PLASTIC

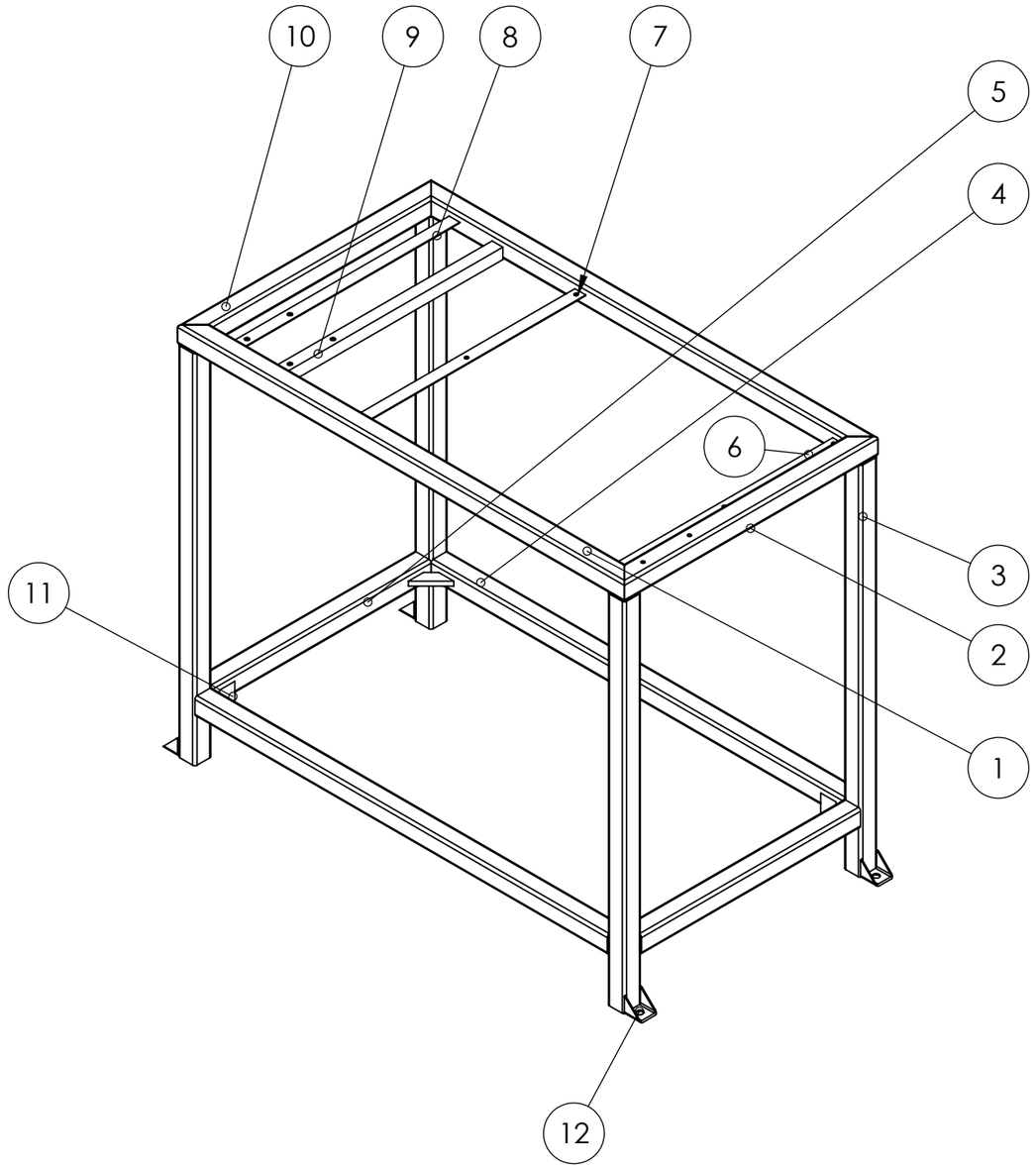
Machine: Extruder PRO			Description: Extruder Assembly			
Projection method: First angle			Release date: 07/01/20	Drawing no.: EXTPRO-V1 2100.00		Rev.: A
General tolerances: ISO 2768-m			Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 1 / 1



ITEM NO.	QTY.	DESCRIPTION	PART NUMBER	MATERIAL
7	1	Bottom shelf	EXTPRO-V1 3000.03	Plywood
6	1	Main frame	EXTPRO-V1 3000.01	Mild steel
5	2	M6 Nut DIN 934	EXTPRO-V1 28	Zinc plated steel
4	1	Barrel support	EXTPRO-V1 3000.04	Mild steel
3	4	M6 Washer DIN 125	EXTPRO-V1 26	Zinc plated steel
2	2	M6 x 60 Socket head screw DIN 912	EXTPRO-V1 27	Zinc plated steel
1	1	Top shelf	EXTPRO-V1 3000.02	Plywood

PRECIOUS PLASTIC

Machine: Extruder PRO			Description: Extruder Assembly		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 3000.00			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1



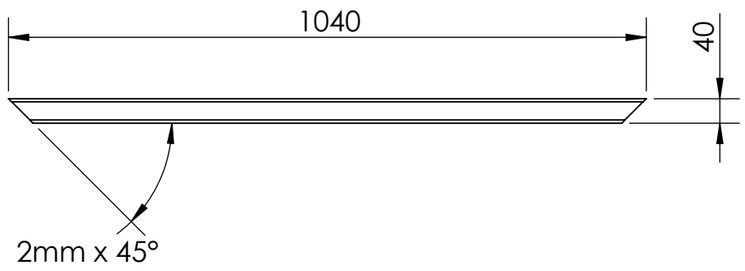
Notes:

1. Grind all surfaces to be welded about 25 mm away from weld
2. Point weld the whole assembly
3. Verify that everything is square and all the measurements are good
4. Fully weld the whole frame

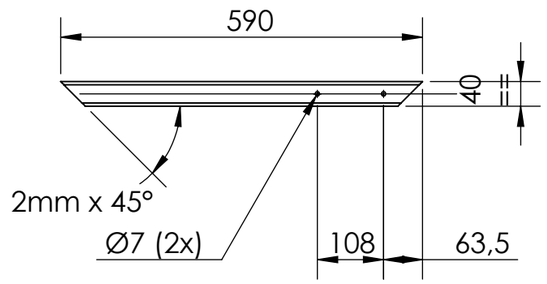
ITEM NO.	QTY.	DESCRIPTION	LENGTH	ANGLE1	ANGLE2	MATERIAL
12	4	Square tube 40 x 40 x 2.6 mm	37	45°	0°	Mild steel
11	4	Flat bar 25 x 5 mm	75	45°	45°	Mild steel
10	1	Square tube 40 x 40 x 2.6 mm	590	45°	45°	Mild steel
9	1	L angle 25 x 25 x 3 mm	510	0°	0°	Mild steel
8	1	L angle 25 x 25 x 3 mm	510	0°	0°	Mild steel
7	1	L angle 25 x 25 x 3 mm	510	0°	0°	Mild steel
6	1	L angle 25 x 25 x 3 mm	510	0°	0°	Mild steel
5	2	Square tube 40 x 40 x 2.6 mm	510	0°	0°	Mild steel
4	2	Square tube 40 x 40 x 2.6 mm	960	0°	0°	Mild steel
3	4	Square tube 40 x 40 x 2.6 mm	830	0°	0°	Mild steel
2	1	Square tube 40 x 40 x 2.6 mm	590	45°	45°	Mild steel
1	2	Square tube 40 x 40 x 2.6 mm	1040	45°	45°	Mild steel

PRECIOUS PLASTIC

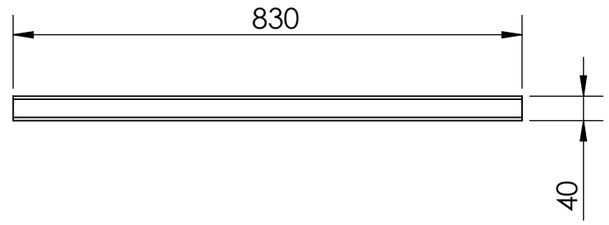
Weight: 30 kg			Material: Mild Steel		
Machine: Extruder PRO			Description: Main frame		
Projection method: First angle	Release date: 07/11/20	Drawing no.: EXTPRO-V1 3001.01	Rev.: A		
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 3



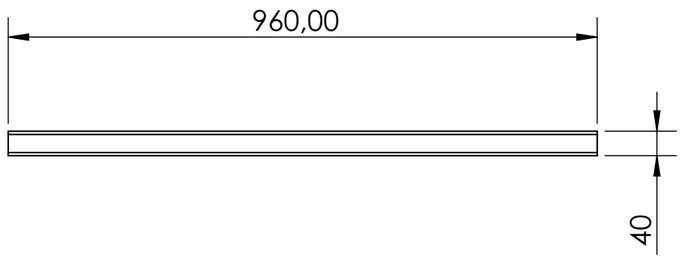
ITEM 1 :SQUARE TUBE 40X40X2.6



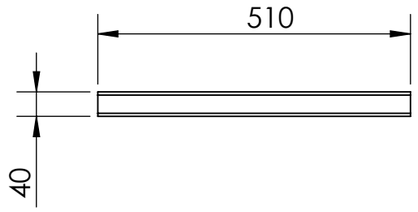
ITEM 2:SQUARE TUBE 40X40X2.6



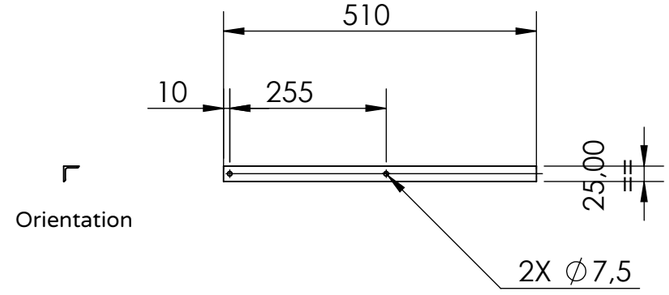
ITEM 3 : SQUARE TUBE 40X40X2.6



ITEM 4 :SQUARE TUBE 40X40X2.6

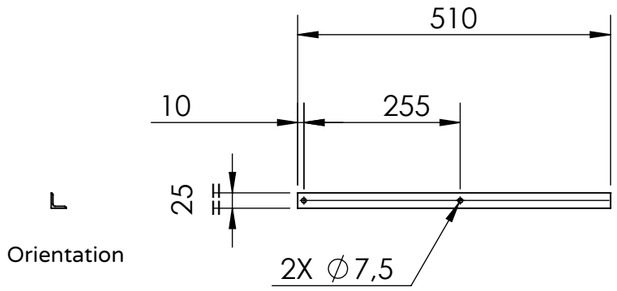


ITEM 5: SQUARE TUBE 40X40X2.6

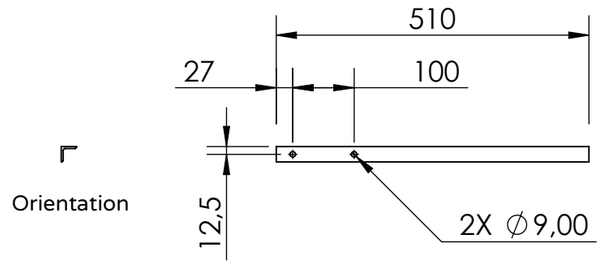


ITEM 6 : L ANGLE 25X25X3

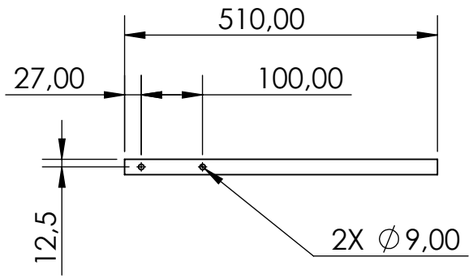
Weight: 30 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Main frame			
Projection method: First angle	Release date: 07/11/20	Drawing no.: EXTPRO-V1 3000.01			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 2 / 3



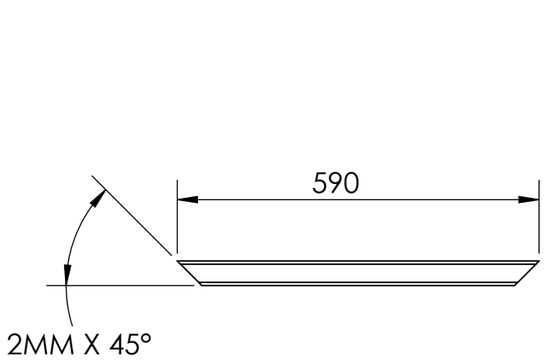
ITEM 7: L ANGLE 25X25X3MM



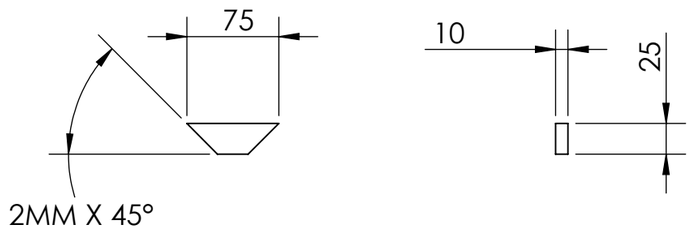
ITEM 8: L ANGLE 25X25X3MM



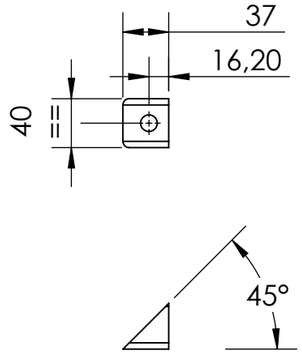
ITEM 9 : L ANGLE 25X25X3MM



ITEM 10 :SQUARE TUBE 40X40X2.6

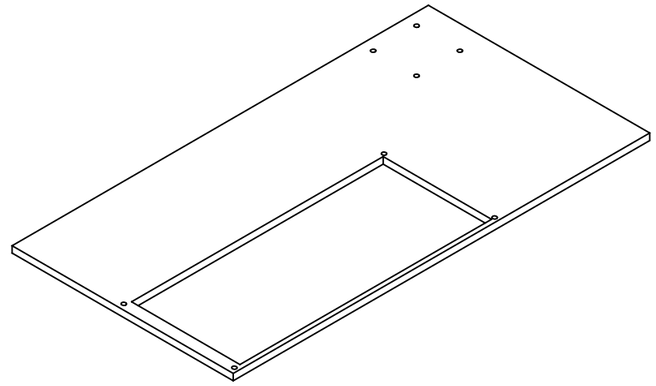


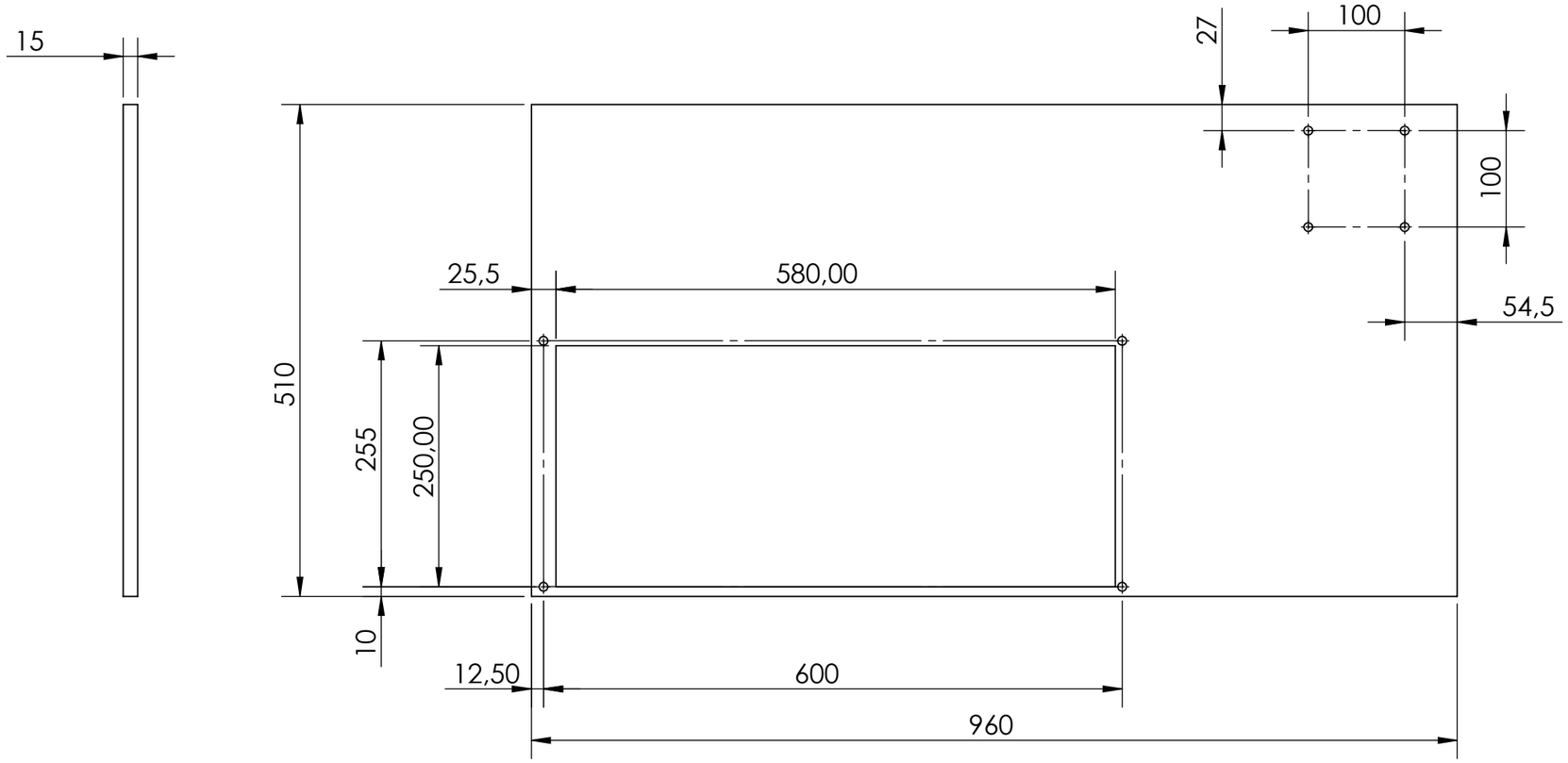
ITEM 11; FLAT BAR 25x5 MM
Scale 1:5



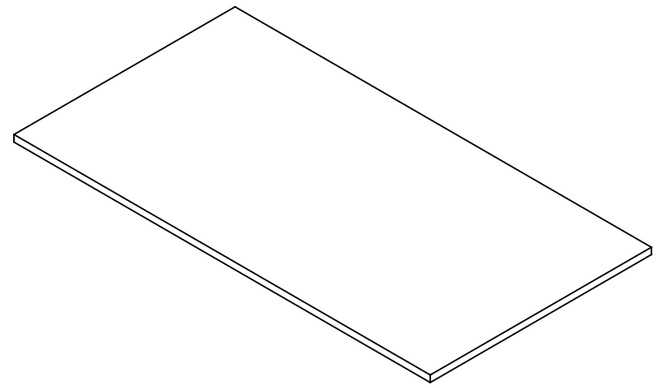
ITEM 12 :SQUARE TUBE 40X40X2.6
Scale 1:5

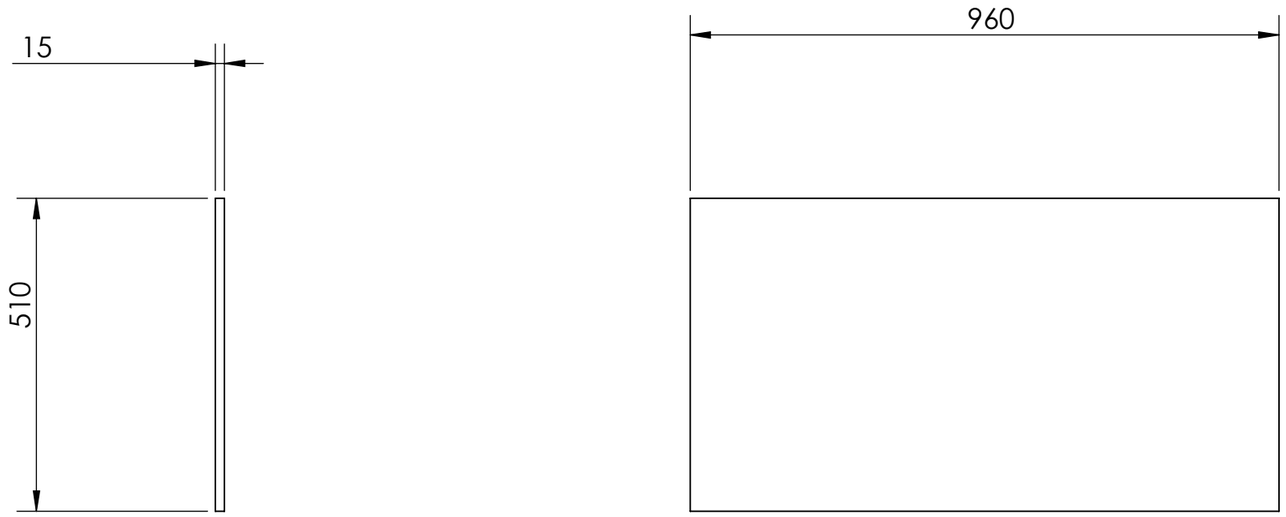
Weight: 30 kg		Material: Mild Steel			
Machine: Extruder PRO		Description: Main frame			
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1-3000		Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 3 / 3





Weight: 1 kg			Material: Plywood		
Machine: Extruder PRO			Description: Top shelf		
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1-3000.02		Rev.: A
General tolerances	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:6	Sheet: 1 / 1





Weight: 1 kg		Material: Plywood				
Machine: Extruder PRO		Description: Bottom shelf				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 3000.03			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:10	Sheet: 1 / 1

M
3~

50.00 Hz

L1 L2 L3 ⏚ U V W

NOZZLE

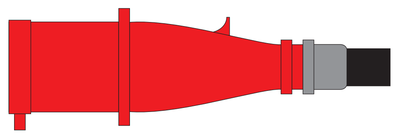
BARREL

FEEDING

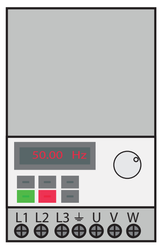
NOZZLE

BARREL

FEEDING

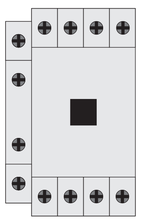


16A MALE PLUG

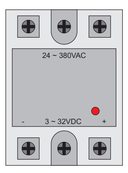


VARIABLE FREQUENCY DRIVER
(VFD)

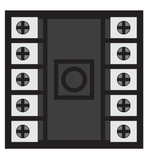
THREE-PHASE MOTOR 3KW



32A CIRCUIT
BREAKER RELAY



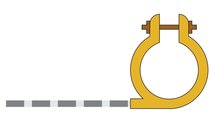
SSR 40A



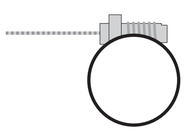
PID CONTROLLER

ROTARTY SWITCH

EMERGENCY STOP



HEATING COLLAR



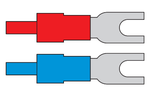
THERMOCOUPLE COLLAR

M25 CABLE GLAND

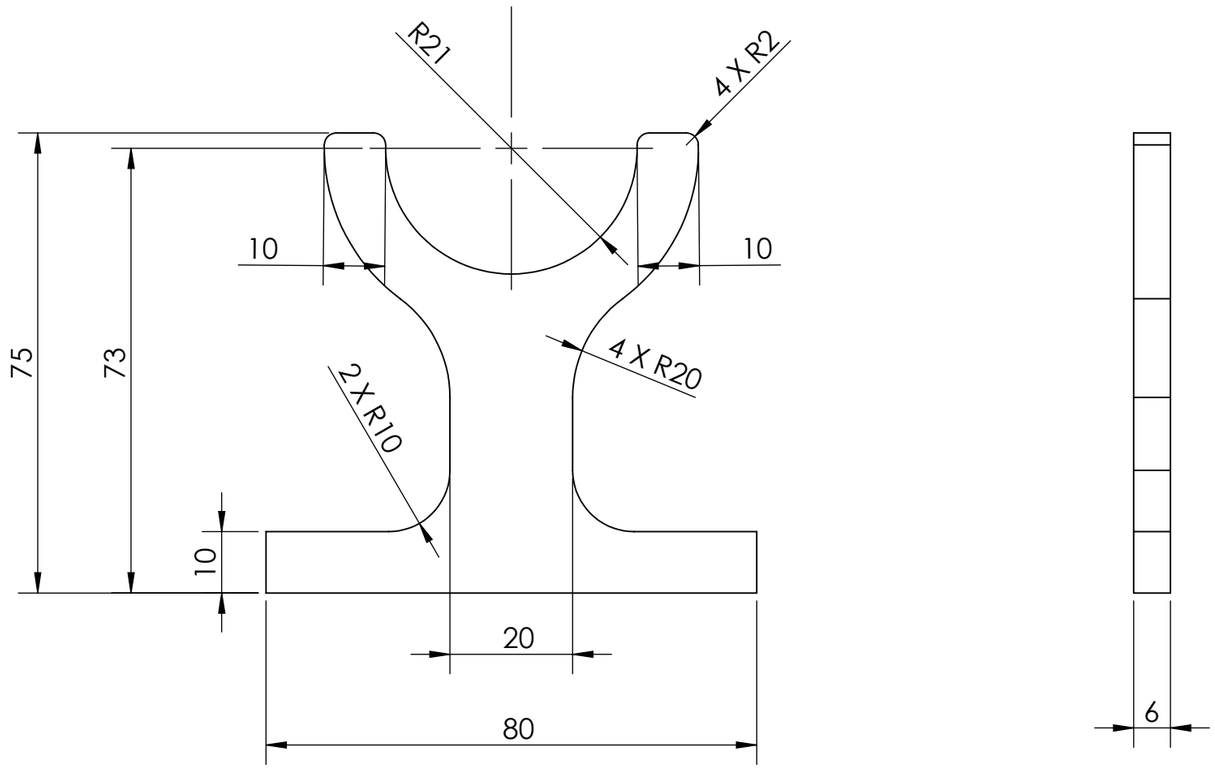
M16 CABLE GLAND

RING TERMINAL

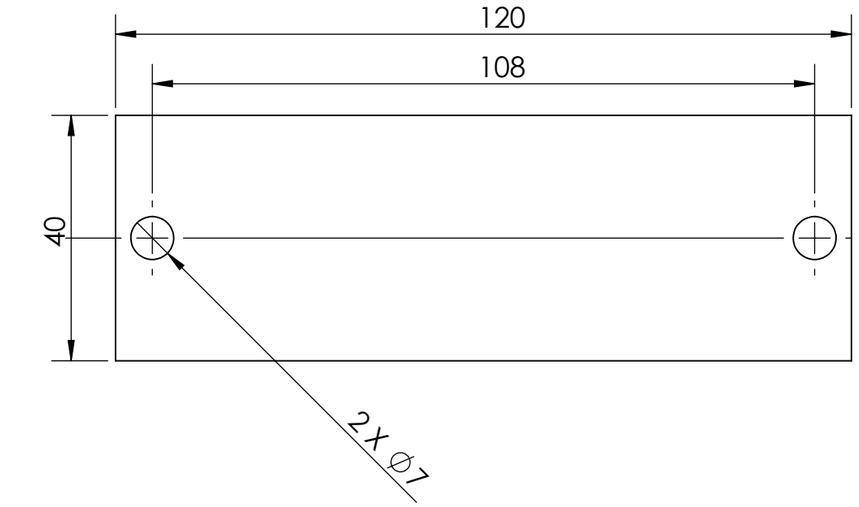
6MM 5 MULTI-CORE CABLE

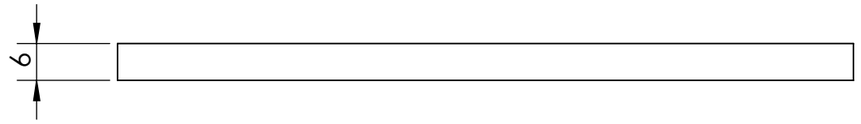


FORK TERMINAL

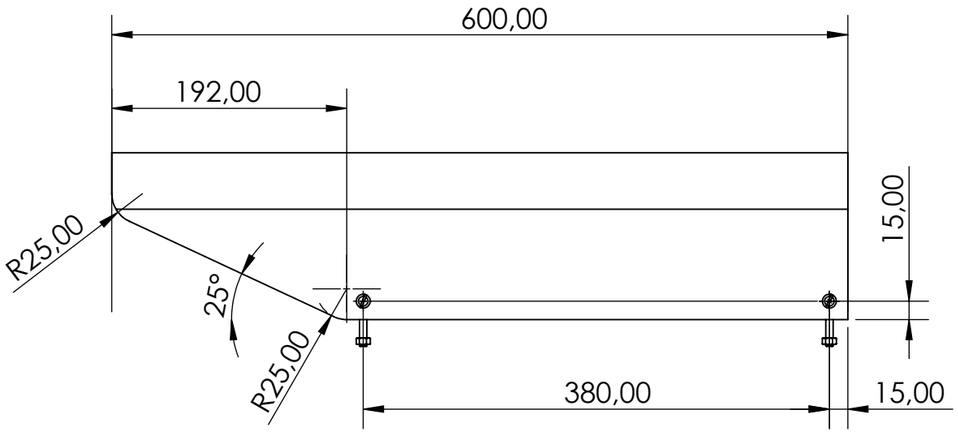


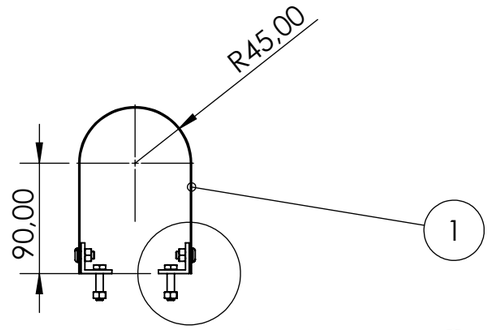
Weight: 0.6 kg		Material: MILD STEEL				
Machine: Extruder PRO		Description: BARREL SUPPORT 1				
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 3000.04			Rev.: A
General tolerances: ISO 2768-m		Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:1	Sheet: 1 / 1

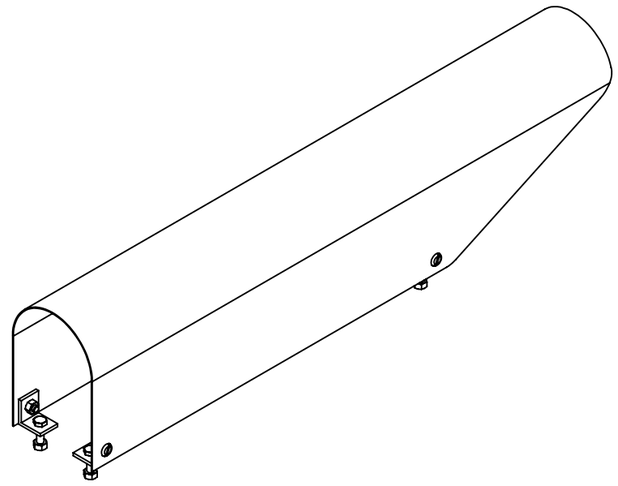




Weight: 0.6 kg			Material: MILD STEEL		
Machine: Extruder PRO			Description: BARREL SUPPORT 2		
Projection method: First angle	Release date: 07/01/20	Drawing no.: EXTPRO-V1 3000.05			Rev.: A
General tolerances: ISO 2768-m	Doc. type: Part	Units unless specified: mm	Sheet size: A3	Scale: 1:1	Sheet: 1 / 1

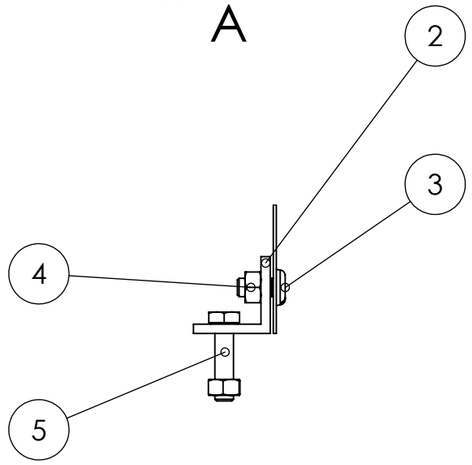


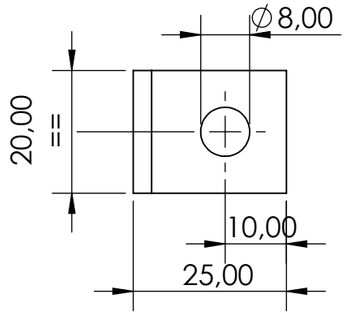


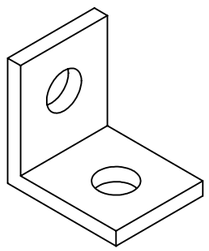


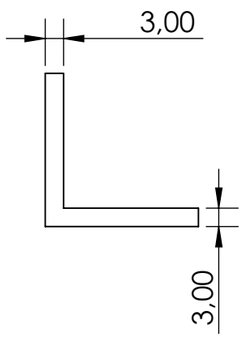
DÉTAIL A

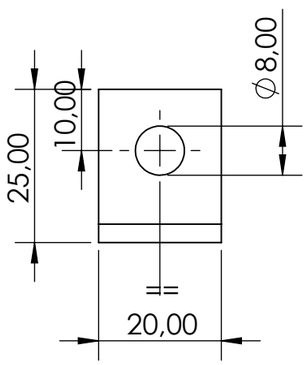
ECHELLE 1 : 2











ITEM NO.	QTY.	DESCRIPTION	PART NO.	MATERIAL
5	4	SCREW M6X25	EXTPRO-V1 3000.06	Mild Steel
4	8	NUT HM6	EXTPRO-V1 3000.06	Mild Steel
3	4	SCREW M6X12	EXTPRO-V1 3000.06	Mild Steel
2	4	L ANGLE 25 X 25 X 3MM	EXTPRO-V1 3000.06	Mild Steel
1	1	0.5 MM METAL SHEET	EXTPRO-V1 3000.06	Mild Steel

PRECIOUS PLASTIC

Machine: Extruder PRO			Description: Heat protection		
Projection method: First angle		Release date: 07/01/20	Drawing no.: EXTPRO-V1 3000.06		Rev.: A
General tolerances: ISO 2768-m		Doc. type: Assembly	Units unless specified: mm	Sheet size: A3	Scale: 1:5	Sheet: 1 / 1