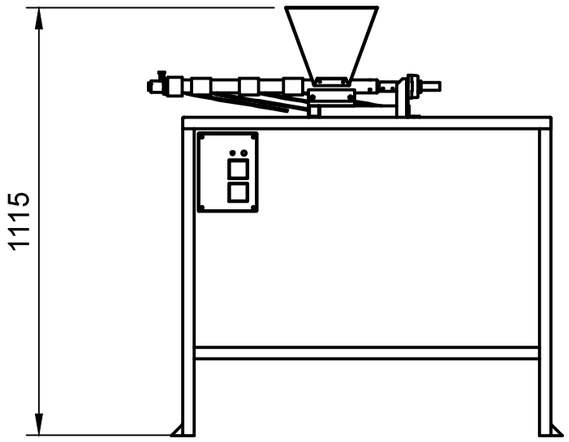
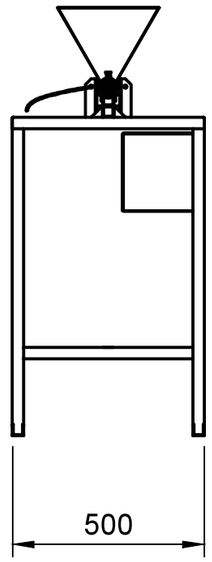
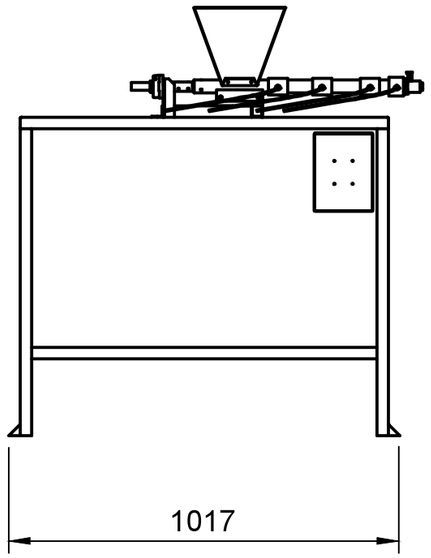
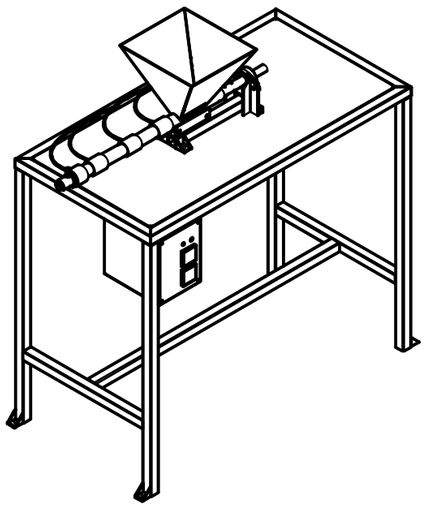
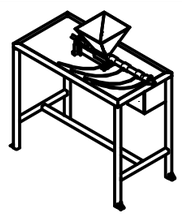
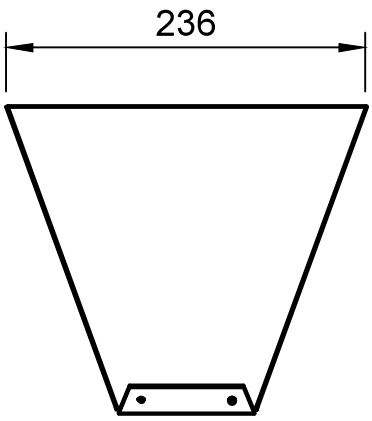


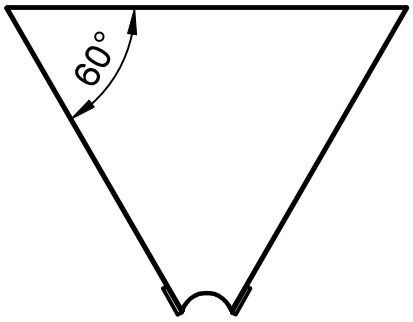


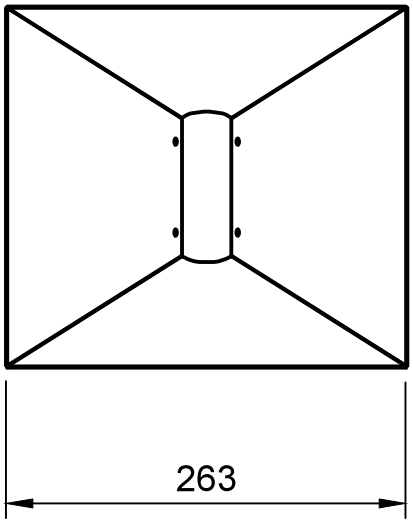




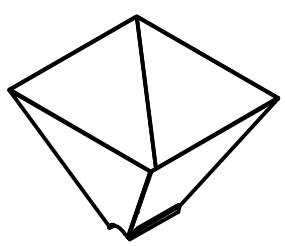
Dept.	Technical reference	Created by	Approved by
Extrusion	website	Precious Plastic	Dave Hakkens
		Document type: sizes in MM	Document status: scale 1:16
		Title: Overview	DWG No.: V2.0
			Rev.: A3 / Date of issue: 16-01-2016 / Sheet: 0/12





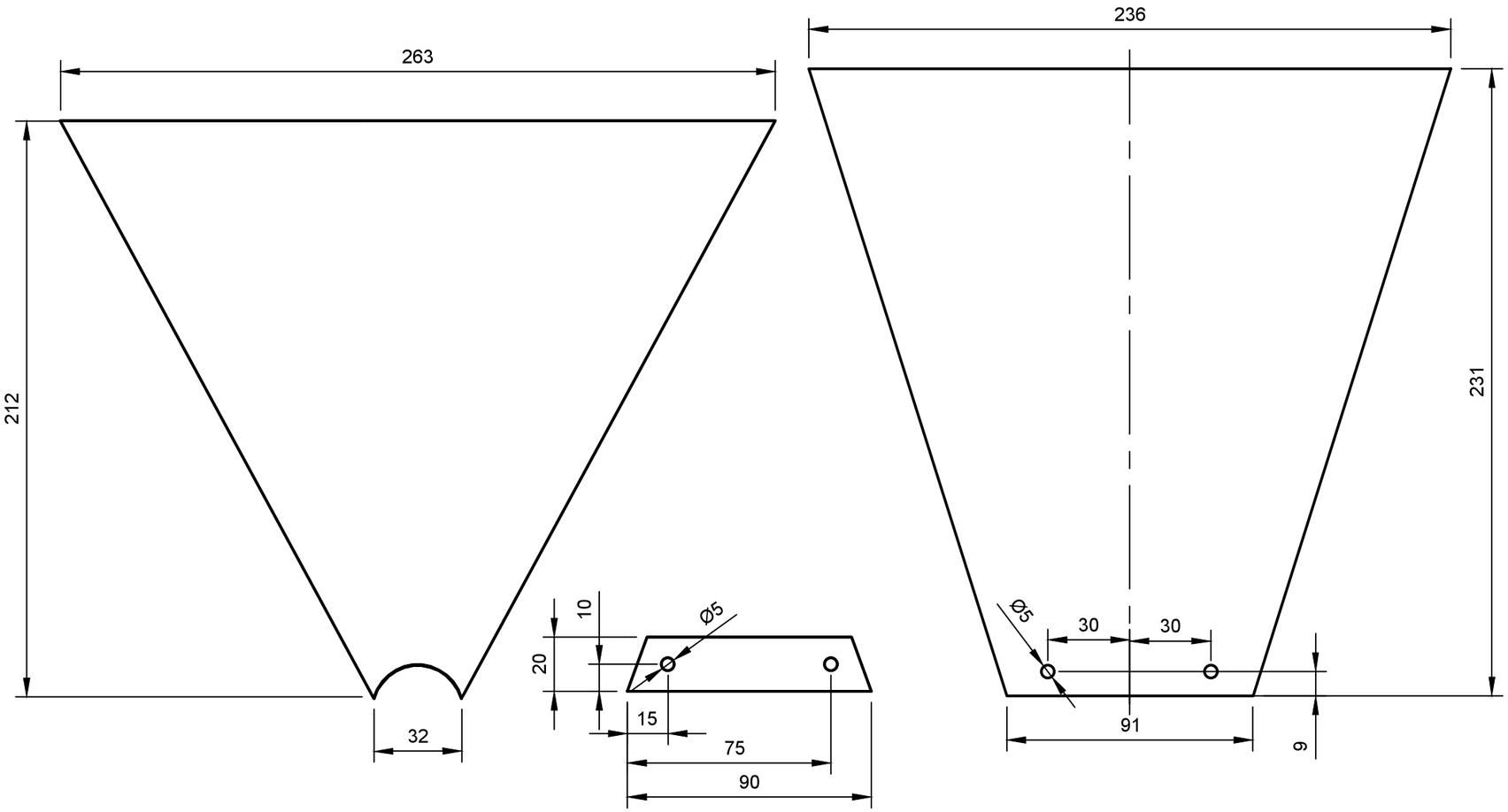


Dept.	Technical reference	Created by	Approved by
Extrusion	website	Precious Plastic	Dave Hakkens



Document type: sizes in MM	Document status: scale 1:5
Title: Hopper	DWG No.: V2.0

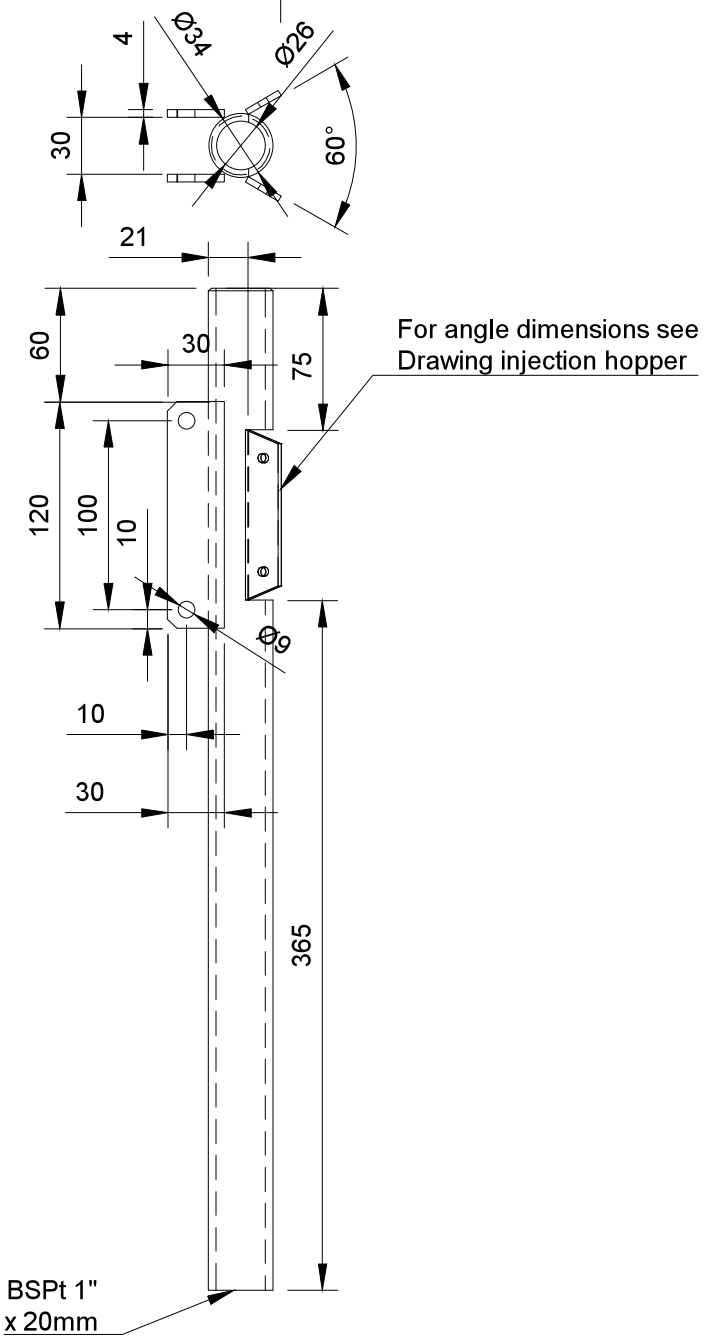
Rev.	Date of issue	Sheet
A4	16-01-2016	1/12



Item	Qty	Part Number	Description	Material
3	2	Side (1) (1)	Sheet 1mm	Steel
2	2	Flat 20x3	L=90	Steel
1	2	Front	Sheet 1mm	Steel

Parts List

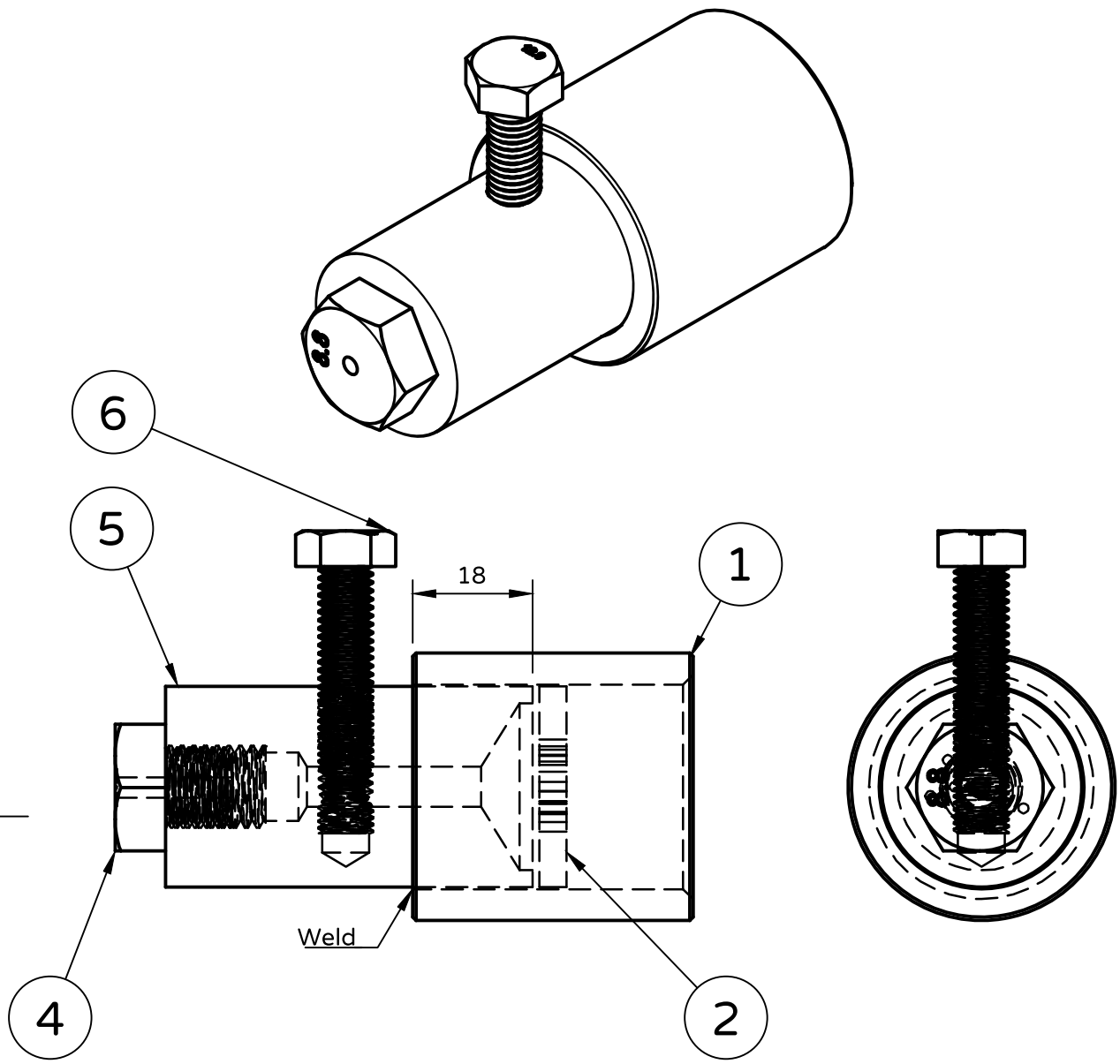
Dept.: Extrusion	Technical reference: website	Created by: Precious Plastic	Approved by: Dave Hakkens
		Document type: sizes in MM	Document status: scale 1:2
		Title: Hopper sheets	DWG No.: V2.0
			Rev.: A3 / Date of issue: 16-01-2016 / Sheet: 2/12



Item	Qty	Part Number	Description	Material
4	2	Flat 30x4	L. 120	Steel
1	1	Tube 34x26	L=530	Steel

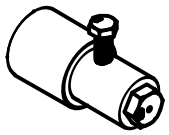
Parts List

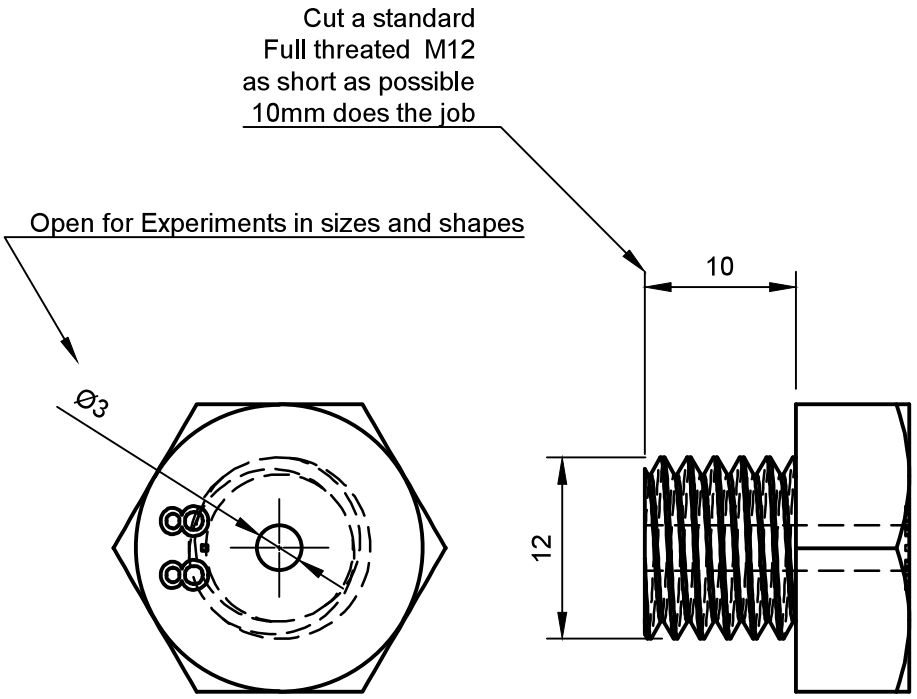
Dept. Extrusion	Technical reference Website	Created by Precious Plastic	Approved by Dave Hakkens
		Document type Sizes in MM	Document status Scale 1:4
		Title Barrel	DWG No. V2.0
			Rev. A4 / Date of issue 16-01-2016 / Sheet 3/12

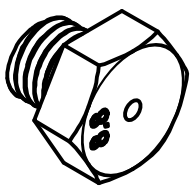


Item	Qty	Part Number	Description	Material
6	1	M8x30		Steel
5	1	Round 30	L=55	Steel
4	1	M12x10		Steel
2	1	Filter Alu R.30	L=4	Aluminum
1	1	1" BSP fitting Female		Steel

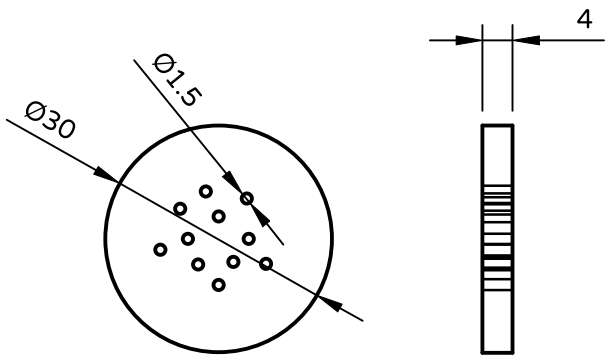
Parts List

Dept. Extrusion	Technical reference website	Created by Precious Plastic	Approved by Dave Hakkens
		Document type sizes in MM	Document status scale 2:1
		Title Nozzle assembled	DWG No. V2.0
			Rev. A4 / Date of issue 16-01-2016 / Sheet 4/12



Dept.	Technical reference	Created by	Approved by
Extrusion	website	Precious Plastic	Dave Hakkens
		Document type: sizes in MM	Document status: scale 2:1
		Title: Nozzle Screw	DWG No.: V2.0

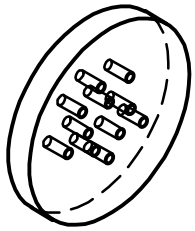
Rev.	Date of issue	Sheet
A4	16-01-2016	6/12

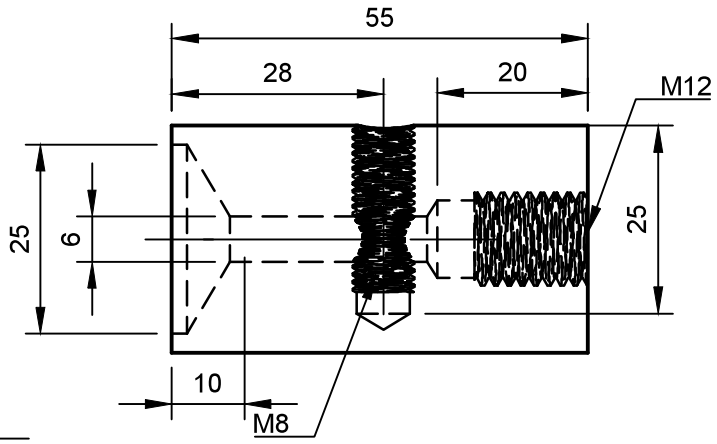


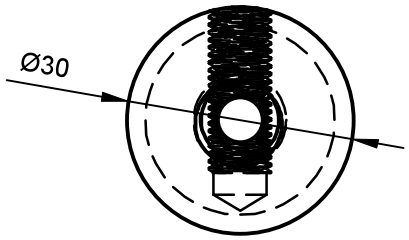
This filter is optionally.
Its to make sure everything that comes out of the extrusion is smooth and molten.
Use this as the output contains chuncks of plastic.

There is a 6mm Hole in in the Nozzle (equals 28 mm2)
A 1.5 mm drilled filtering gap is 1.7mm2.

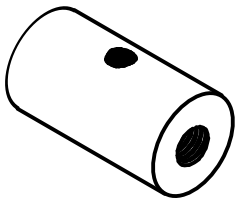
This means you need at least 16 holes to not slow down your output

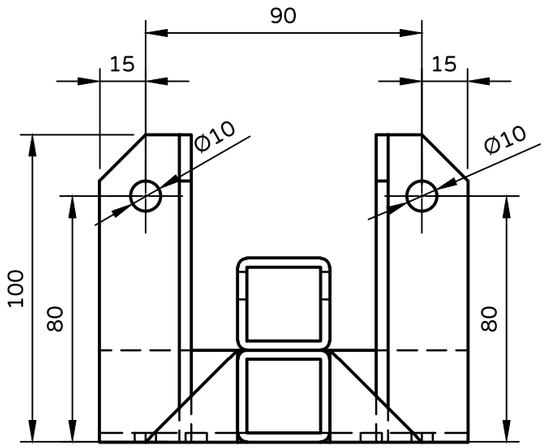
Dept.	Technical reference	Created by	Approved by
Extrusion	website	Precious Plastic	Dave Hakkens
		Document type: sizes in MM	Document status: scale 1:1
		Title: Nozzle Filter	DWG No.: V2.0
			Rev.: A4 / Date of issue: 16-01-2016 / Sheet: 6/12

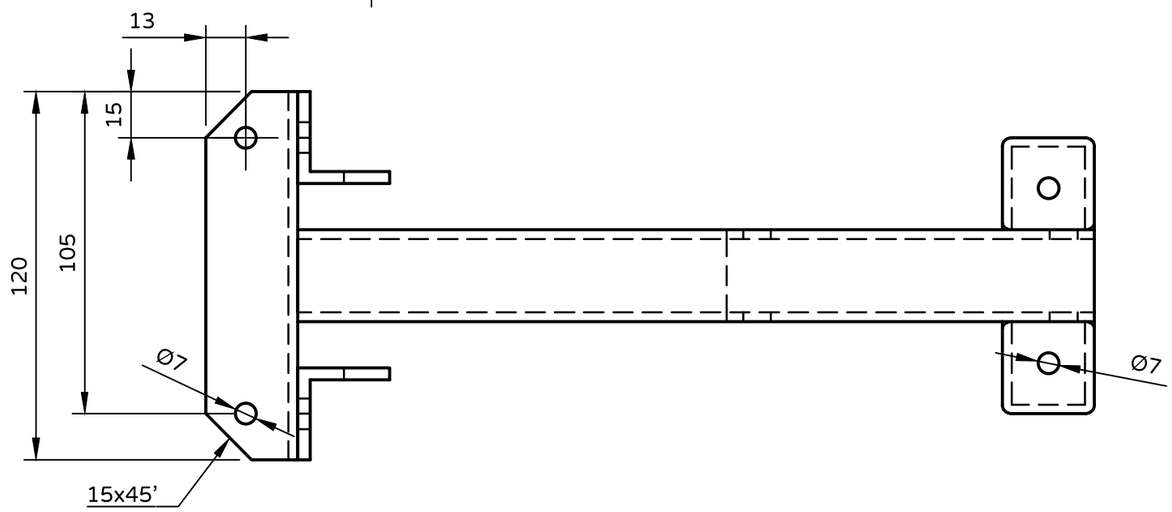


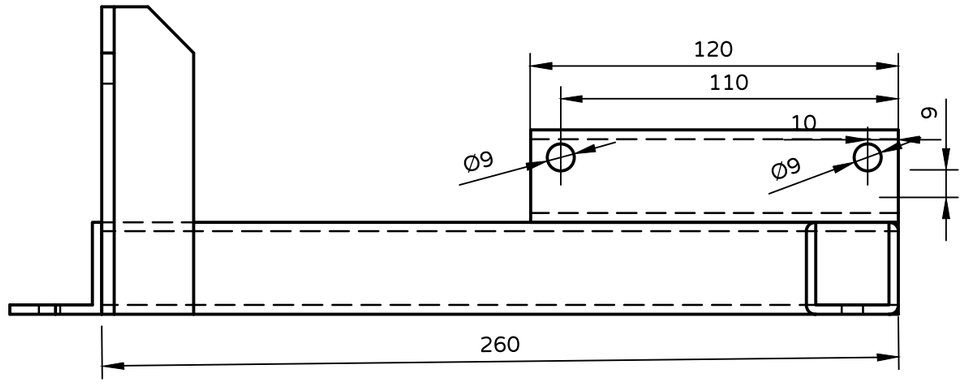


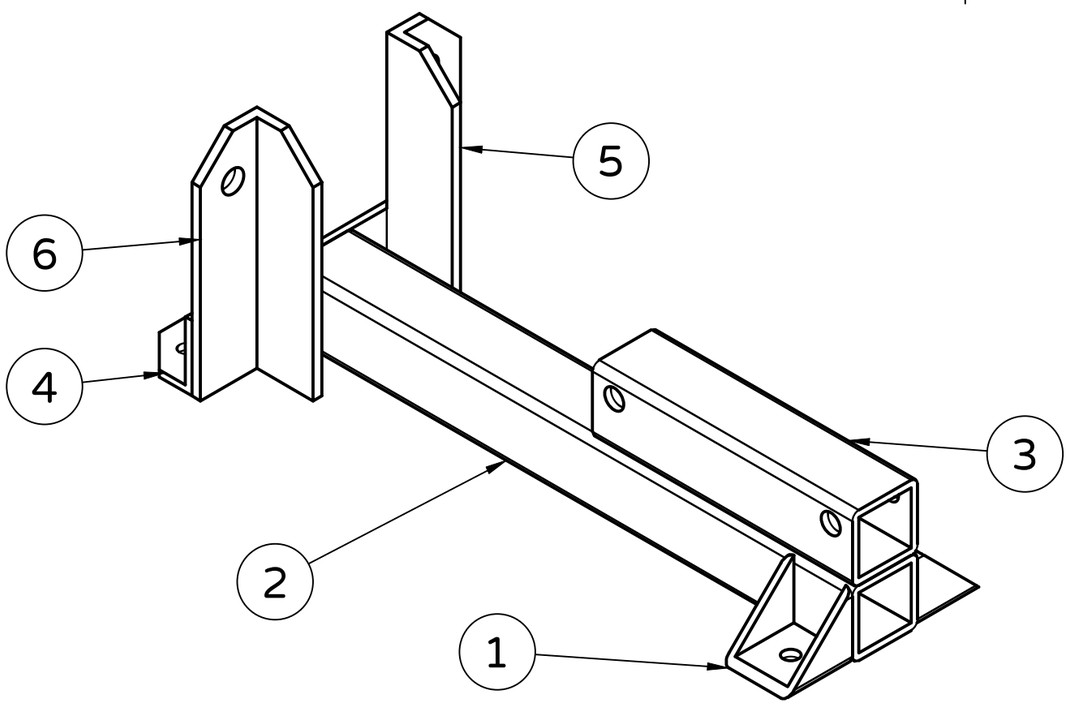
Dept.	Technical reference	Created by	Approved by
Extrusion	website	Precious Plastic	Dave Hakkens
		Document type: sizes in MM	Document status: scale 1:1
		Title: Nozzle Flow Adjuster	DWG No.: V2.0
			Rev.: A4 / Date of issue: 16-01-2016 / Sheet: 7/12







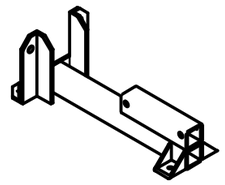


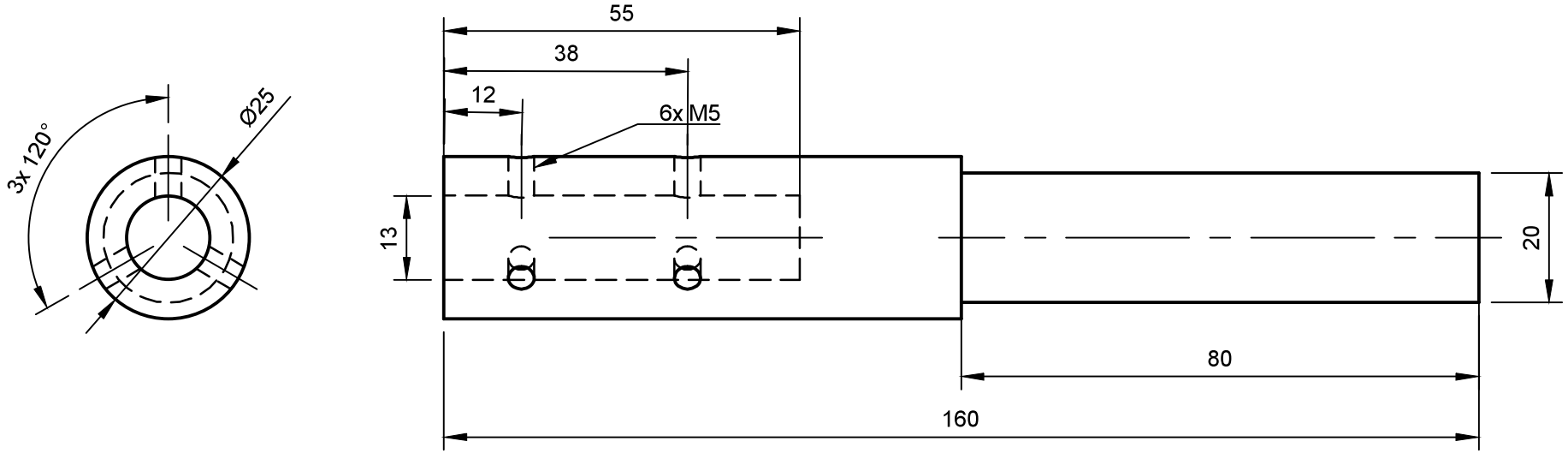


Item	Qty	Part Number	Description	Material
6	1	Angle 30x3 (2)	L=100	Steel
5	1	Angle 30x3 (1)	L=100	Steel
4	1	Angle 30x3	L=120	Steel
3	1	Tube 30x30x3	L=120	Steel
2	1	Tube 30x30x3 (1)	L=260	Steel
1	2	Tube 30x30x3 (2)		Steel

Parts List

Dept.: Extrusion	Technical reference: website	Created by: Precious Plastic	Approved by: Dave Hakkens
		Document type: sizes in MM	Document status: scale 1:2
		Title: Barrel Holder	DWG No.: V2.0
			Rev.: A3 / Date of issue: 16-01-2016 / Sheet: 8/12

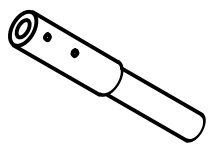




1	1	Round 25	L=160	Steel
Item	Qty	Part Number	Description	Material

Parts List

Dept.	Technical reference	Created by	Approved by
Extrusion	website	Precious Plastic	Dave Hakkens



Document type	Document status
sizes in MM	scale: 1:1

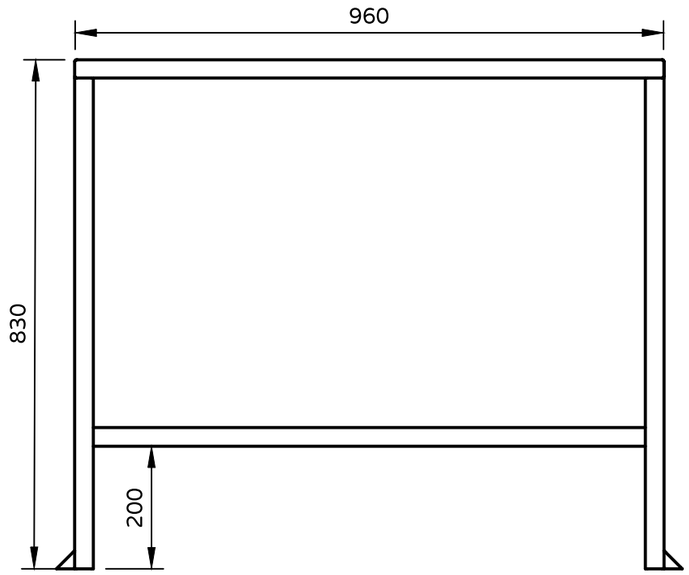
Title

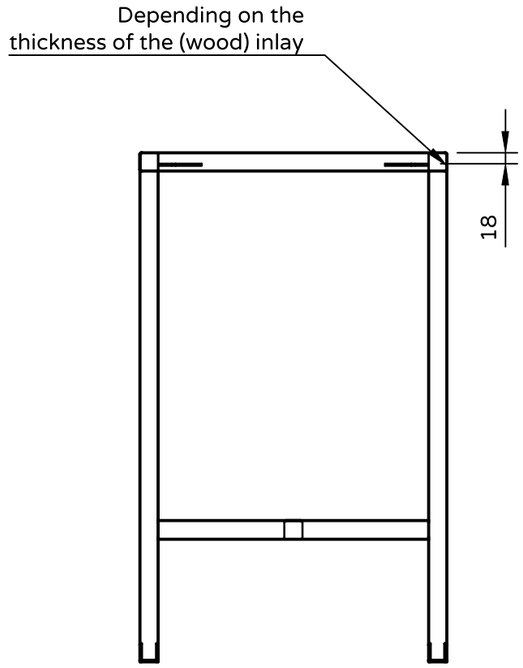
Barrel holder bearing shaft

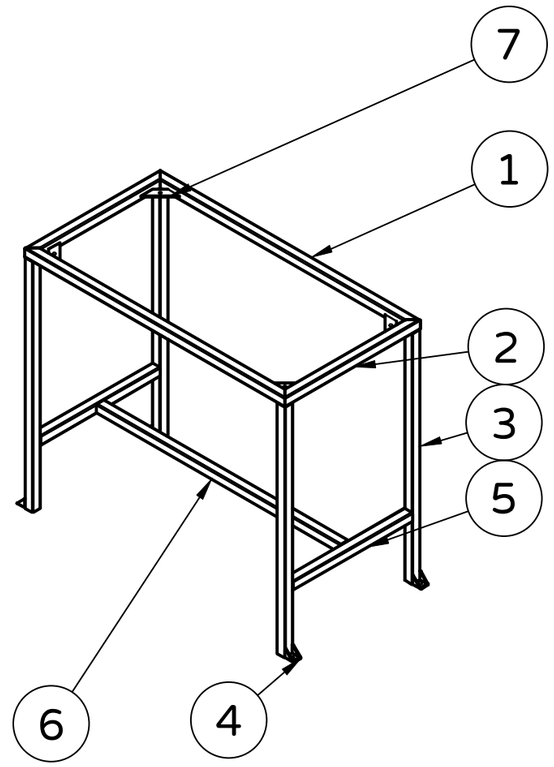
DWG No.

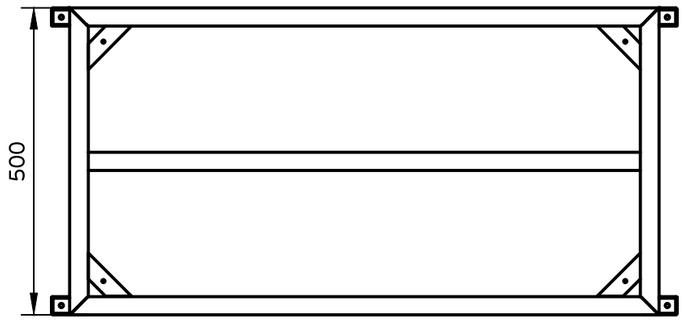
V2.0

Rev.	Date of issue	Sheet
A4	20-01-2016	9/12



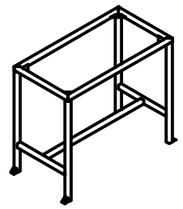


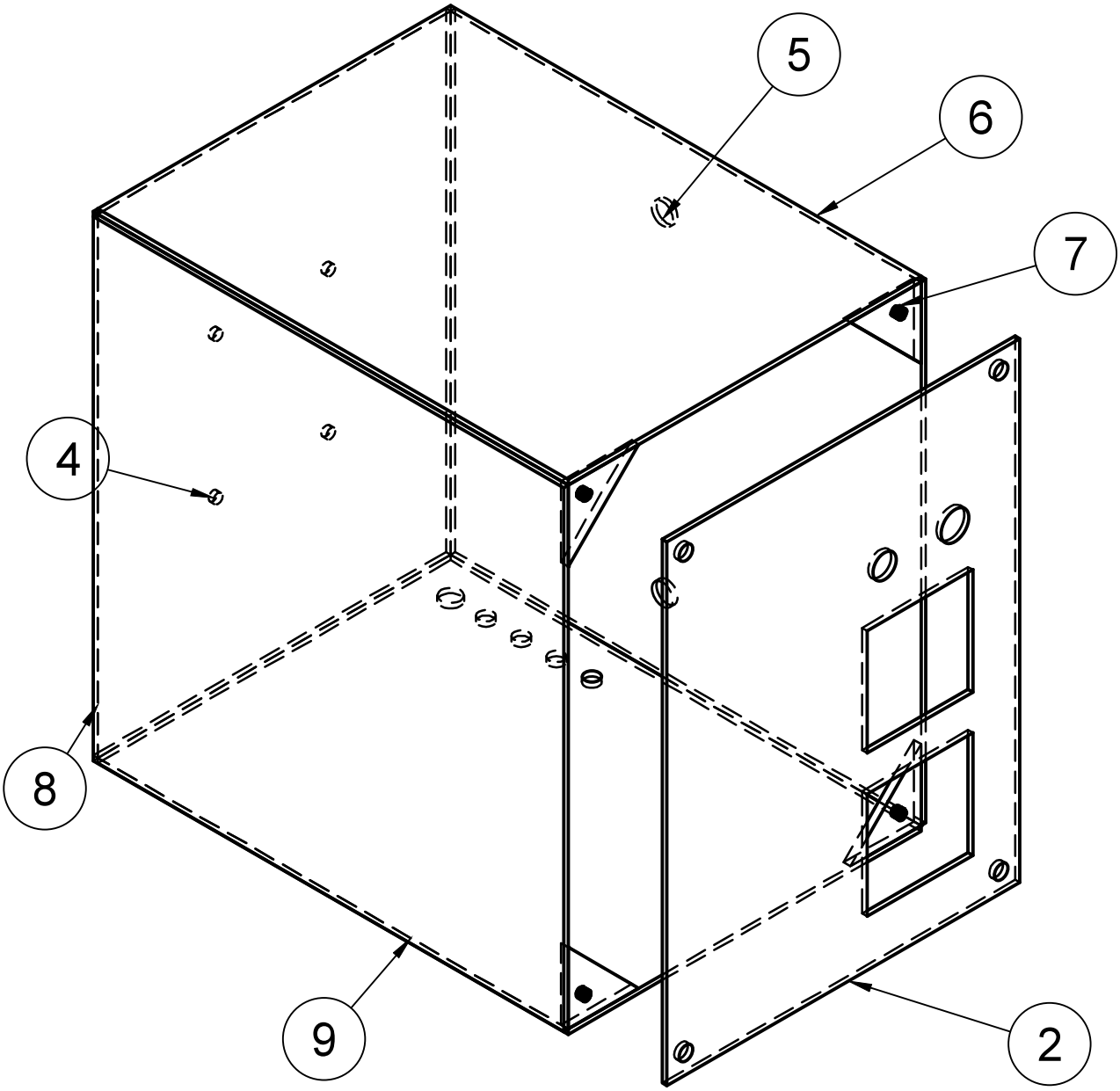




Item	Qty	Part Number	Description	Material
7	4	Flat 30x3	L=100	Steel
6	1	Tube 30x30x3 (6)	L=900	Steel
5	2	Tube 30x30x3 (5)	L=440	Steel
4	4	Tube 30x30x3 (2) (1)	L=35	Steel
3	4	Tube 30x30x3 (4)	L=800	Steel
2	2	Tube 30x30x3 (3)	L=500	Steel
1	2	Tube 30x30x3	L=960	Steel

Parts List

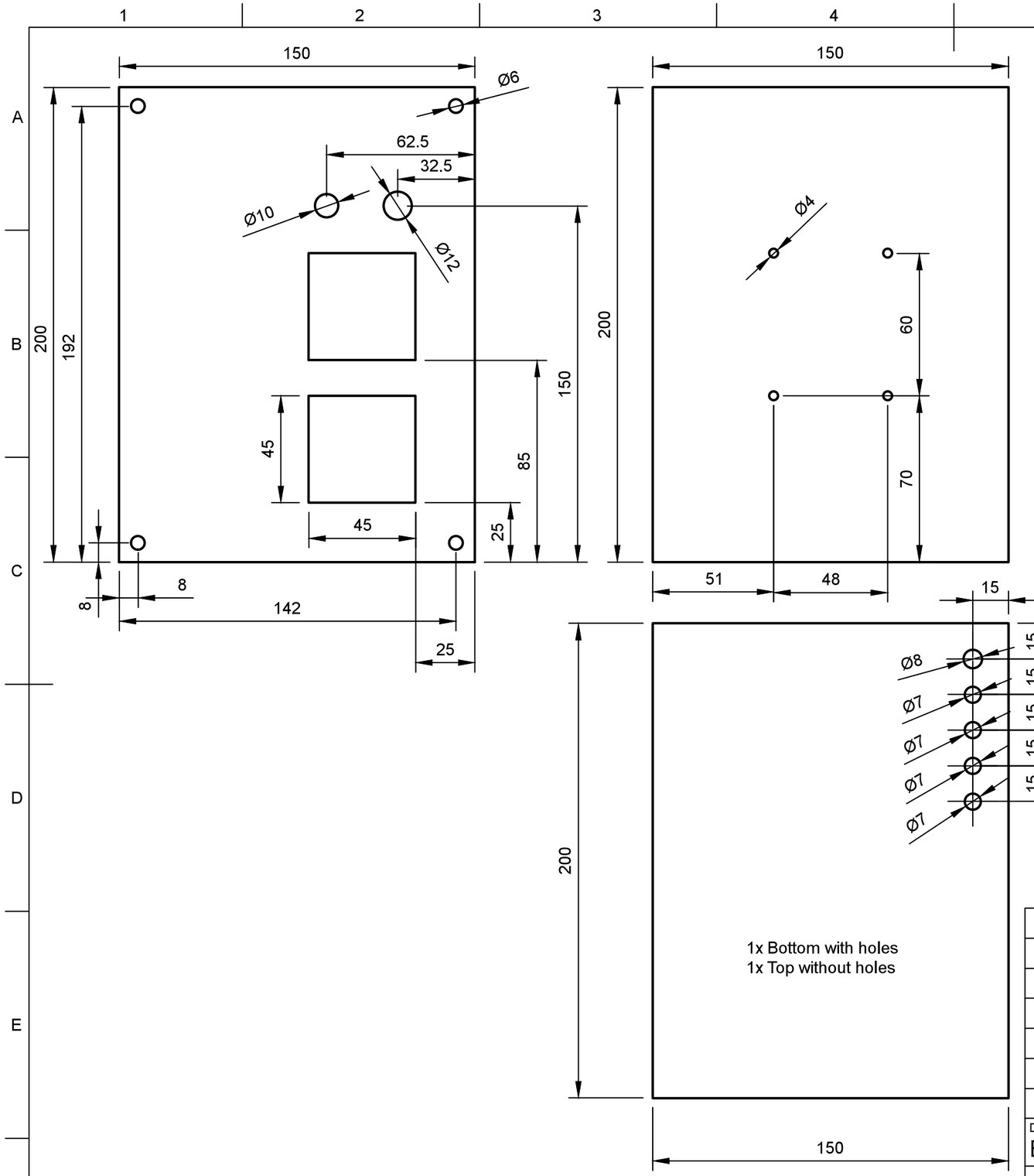
Dept.: Extrusion	Technical reference: website	Created by: Precious Plastic	Approved by: Dave Hakkens
		Document type: sizes in MM	Document status: scale: 1:10
		Title: Framework	DWG No.: V2.0
			Rev.: A3 / Date of issue: 16-01-2016 / Sheet: 10/12



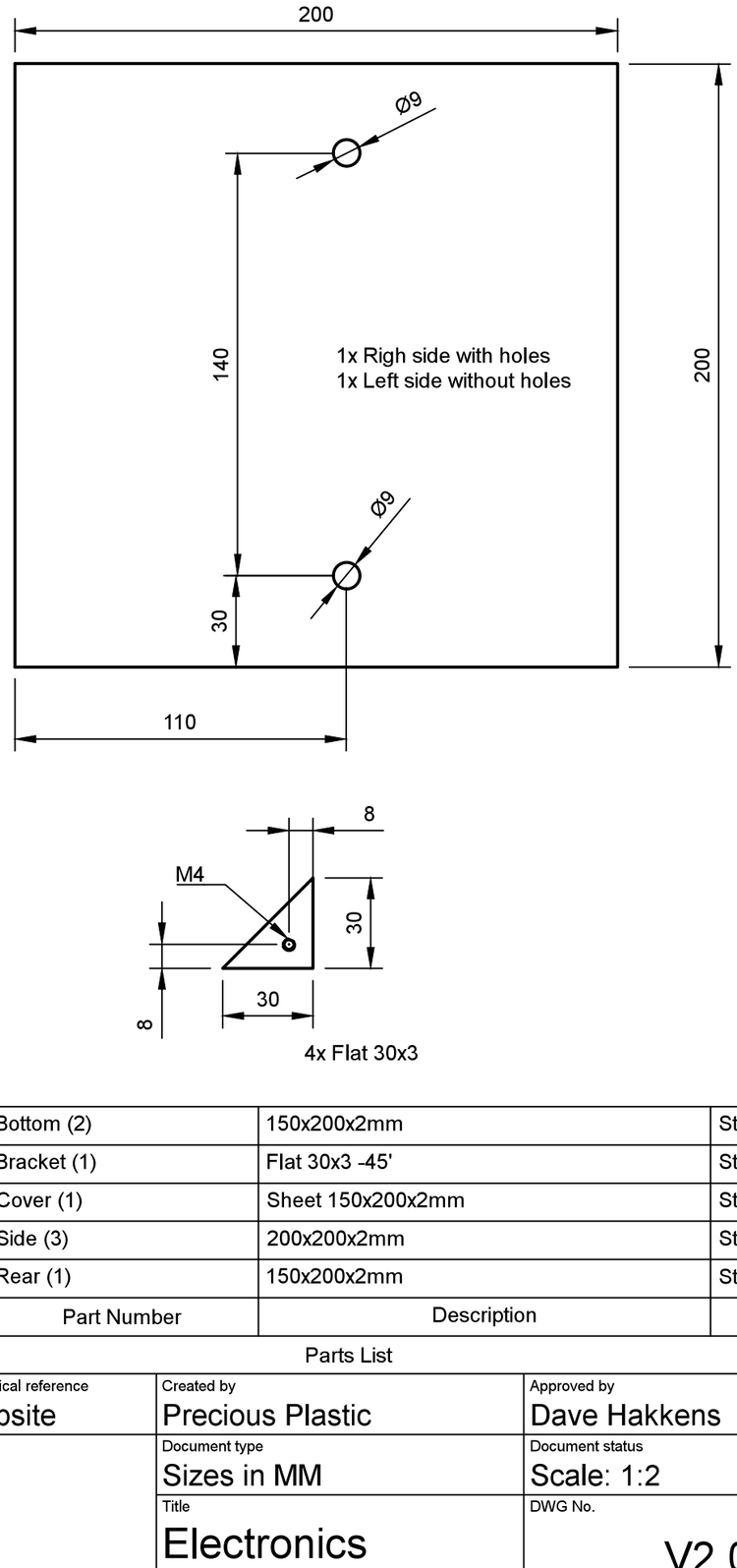
Item	Qty	Part Number	Description	Material
9	1	Bottom	150x200x2mm	Steel
8	1	Side (2)	200x200x2mm	Steel
7	4	Bracket	Flat 30x3 -45'	Steel
6	1	Top	150x200x2mm	Steel
5	1	Side	200x200x2mm	Steel
4	1	Rear	150x200x2mm	Steel
2	1	Cover	Sheet 150x200x2mm	Steel

Parts List

Dept.: Extrusion	Technical reference: website	Created by: Precious Plastic	Approved by: Dave Hakkens
		Document type: sizes in MM	Document status: scale 1:2
		Title: Elextronics metal box	DWG No.: V2.0
			Rev.: A4 / Date of issue: 16-01-2016 / Sheet: 11/12



1x Bottom with holes
1x Top without holes

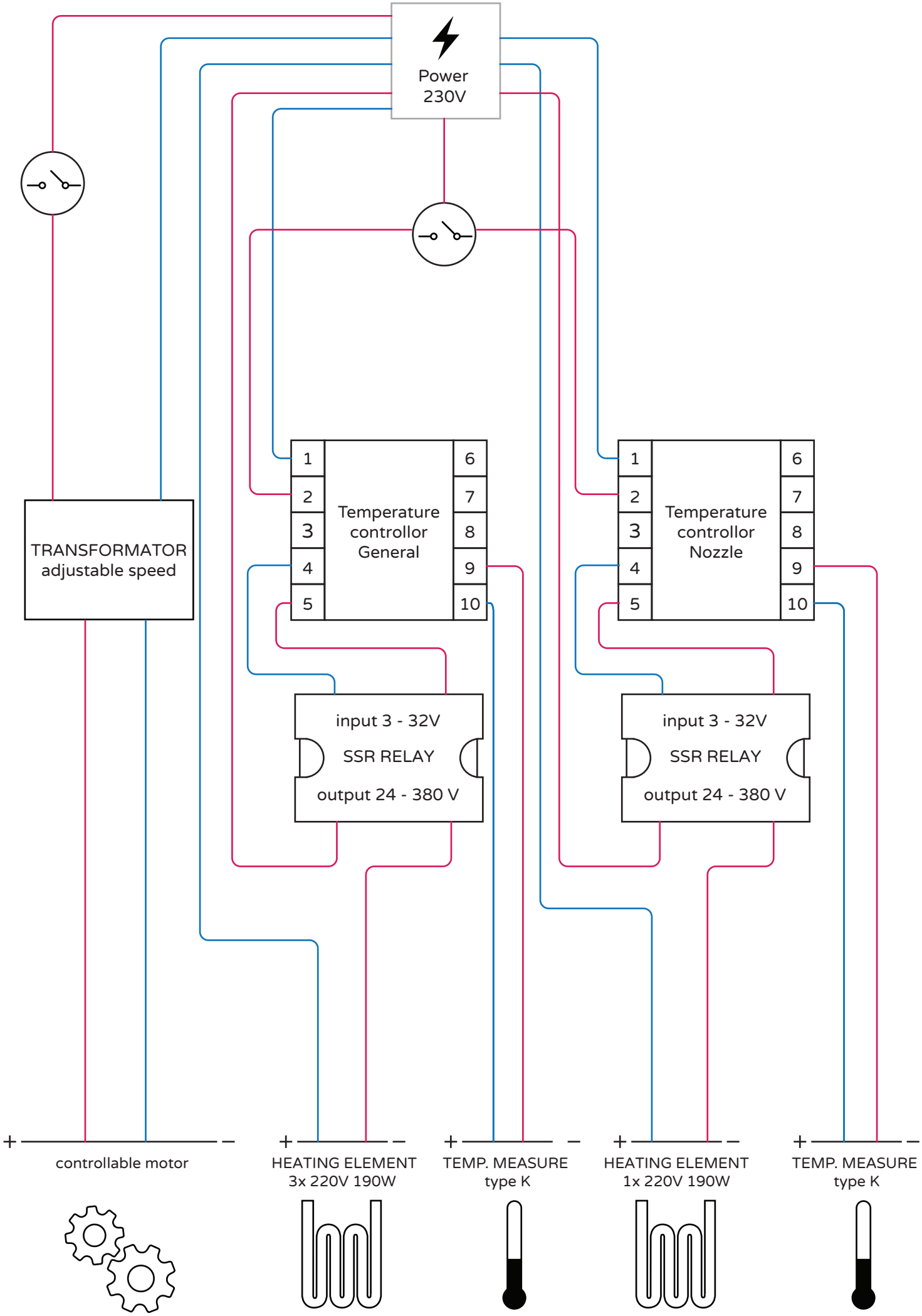


4x Flat 30x3

Item	Qty	Part Number	Description	Material
5	1	Bottom (2)	150x200x2mm	Steel
4	1	Bracket (1)	Flat 30x3 -45'	Steel
3	1	Cover (1)	Sheet 150x200x2mm	Steel
2	1	Side (3)	200x200x2mm	Steel
1	1	Rear (1)	150x200x2mm	Steel

Parts List

Dept.: Extrusion	Technical reference: website	Created by: Precious Plastic	Approved by: Dave Hakkens
		Document type: Sizes in MM	Document status: Scale: 1:2
		Title: Electronics Sheets	DWG No.: V2.0
			Rev.: a3 / Date of issue: 16-01-2016 / Sheet: 12/12


Power
230V
TRANSFORMATOR
adjustable speed
1
2
3
4
5
Temperature
controllor
General
6
7
8
9
10
input 3 - 32V
SSR RELAY
output 24 - 380 V
1
2
3
4
5
Temperature
controllor
Nozzle
6
7
8
9
10
input 3 - 32V
SSR RELAY
output 24 - 380 V
+
–
controllable motor
+
–
HEATING ELEMENT
3x 220V 190W
+
–
TEMP. MEASURE
type K
+
–
HEATING ELEMENT
1x 220V 190W
+
–
TEMP. MEASURE
type K

BILL OF MATERIALS / EXTRUSION

DESCRIPTION	MATERIAL	DETAILS	QUANTITY	WHERE TO GET IT	REMARKS	PRICE
Machine parts						
– Strip	Steel	30x3MM	10cm	Scrapyard	-	1
• Roundbar	Steel	30MM	5.5cm	Scrapyard	accurate and smooth from the inside	2
• Roundbar	Steel	25MM	22cm	Scrapyard	-	3
□ Squaretube	Steel	30x30x3MM	800 cm	Scrapyard	-	35
o Tube	Steel	34x26x4MM	53 cm	Scrapyard/ Metal shop	-	1
L Angle profile	Steel	30x30x3mm	32cm	Scrapyard	-	2
Sheetmetal	Steel	1mm	-	Scrapyard	-	15
Motor	-	-	1	Scrapyard	Around 70 RPM	30
Bearing	-	-	1	Scrapyard/hardware store	UCFL 204	5
Motor	-	26 x 600 MM	1	Scrapyard/hardware store	Make sure if fits the tube	30
Electronics						
PID Controller	-	0-400 Degree	2x	Ebay	-	20
SSR	-	2-24 V	2x	Ebay	-	8
Thermocouple	-	Type K	2x	Ebay	-	15
Bandheater	metal	35x45MM	3x	Ebay	-	18
Bandheater	metal	40x45MM			-	
Power switch	-	220V	1x	Scrapyard/Hardware store	-	3
Led indicator	-	220V	1x	Hardware store	-	3
Powercord	-	-	5M	Scrapyard/Hardware store	-	2

TOTAL 192.00€

Price varies depending on where you live