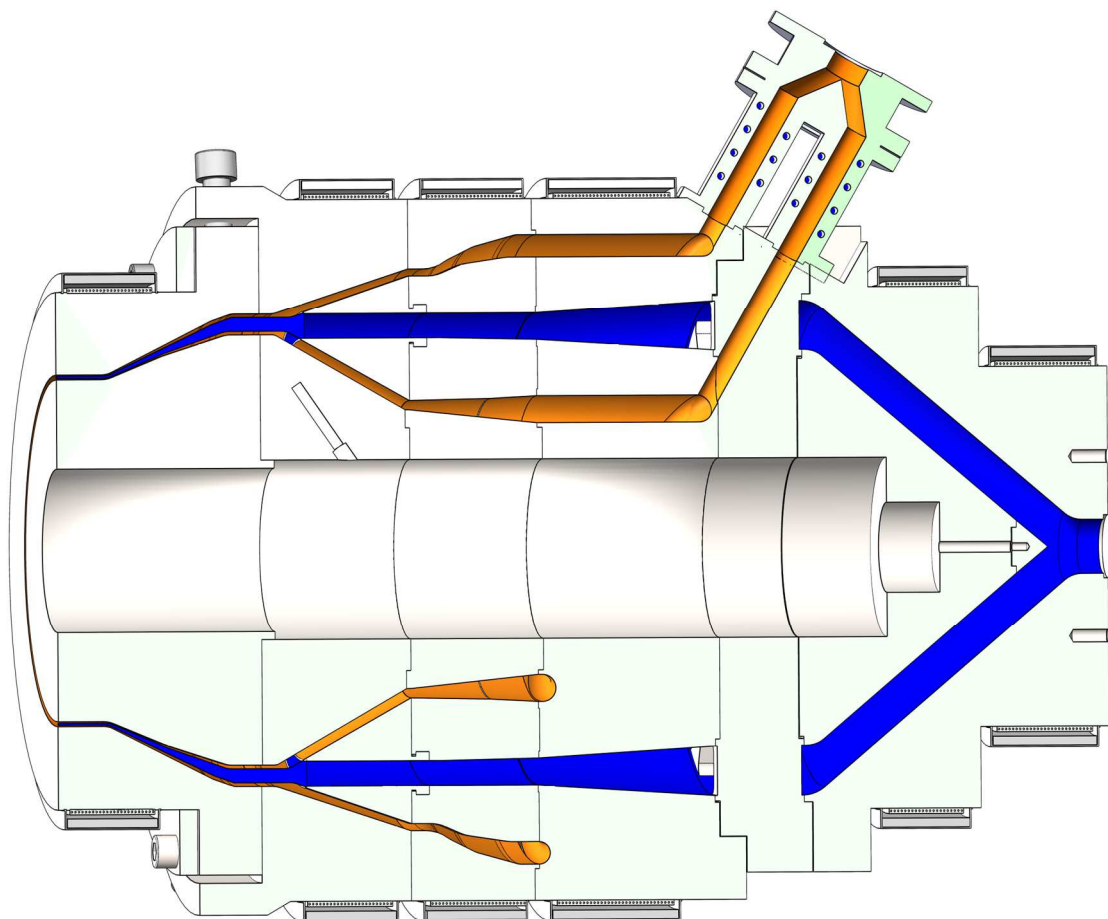


GTS



GERMANTWINSCREWS

Spider Pipe Heads



Extrusion Technology is GTS - Technology

GermanTwinscrews GmbH

Since 1995 we do continuous optimization in screw technology, especially for counter-rotating twin screws. We take care of process energy optimization and take responsibility for our environment.

Highest quality standards and reliability towards our long-term and new customers are the main topics in our company philosophy. Our customers are located in more than 100 countries. We manufacture spider pipe heads for mono and co-extrusion up to 400mm diameter.

- GTS creates international standards for highest melt quality and output maximizing
- GTS manufactures pipe heads with exceptional pipe quality



High-quality Pipe Heads

The well-approved GTS spider pipe die heads are suitable for the production of pipes for all pressure classes according to EN 1452 (DIN 8062).

Most PVC types with formulations based on Pb, Ca-Zn, Sn, organic and/or other stabilizers with foaming agents or highest filler percentages can be used. Furthermore, these pipe heads can be used for a wide range of different thermoplastics such as PO.

Assembly and disassembly are very easy and all spider parts for RG 1 to RG 3 are made of stainless steel. The economical GTS die heads offer pipe manufacturers very cost-effective solutions.

Flow Channel Optimization

The GTS Flow Channel Optimization allows a large melt volume for stress relief in the melt and creates enough time for optimal welding of the flow lines. On the other hand, the flow channels are designed for maximum pressure in the parallel zone at the exit of the nozzle to obtain the best pipe surface on the inside and outside.

Pipes out of GTS pipe heads show very small thickness variations in the wall thickness and length direction. Thermal die centering is available for each pipe head. For C-PVC pipes, GTS has modified the flow channels of the pipe heads and coated them with 60µ hard chrome. Manufacturing is done on 5 axis fully controlled PLC machines.

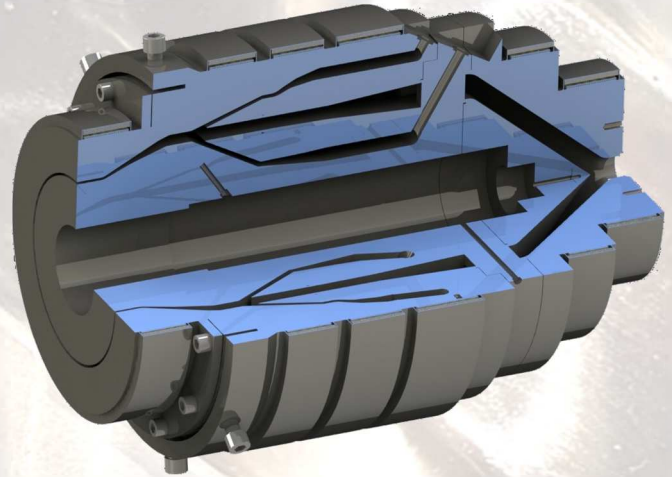


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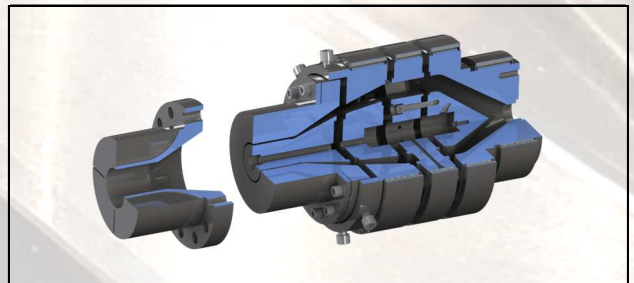
Multi-layer Pipe Heads

For multilayer pipes, the GTS RCO series (from 90 x 1,8 mm to 400 x 3,2 mm) is the best solution for foam core pipes or other multilayer pipes. Customers get an excellent quality of sewage pipes with more than 100 pph of filler in the middle layer. The maintenance and the cleaning are very simple.

The GTS RCO series can be used with two or three extruders, which means with two or three different formulations. Often this is the most economical solution for pipe producers. On special request, GTS supplies pipe heads for up to 60% higher output or for special co-extrusion pipe projects.

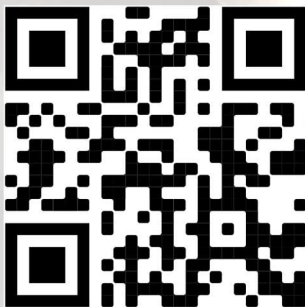


RCO Pipe Heads		RCO 10	RCO 20
Min. Diameter	mm	90 x 1,8	200 x 1,8
Max. Diameter	mm	200 x 1,8	400 x 3,2
Heating Zones		4	4
Heating Capacity	KW	12,0	42,0
Max. Output (foam)	kg/h	1400	1500



PVC Pipe DIN 8062 RG-Pipe Heads

Pressure class	1		2		3		4		5		6														
Max. pressure	1,6 bar		4 bar		6 bar		10 bar		16 bar		> 16 bar														
Density	1,50 kg/dm³		1,42 kg/dm³		1,42 kg/dm³		1,42 kg/dm³		1,42 kg/dm³		1,42 kg/dm³														
o.diam. mm	socket length mm	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m	weight: kg/m													
16									1,2	0,08	1,8	0,11													
20									1,5	0,12	2,3	0,18													
25			Possibility with 2-strand pipe head Ax distance of 380 or 500mm					1,5	0,16	1,9	0,20	2,8	0,28												
32							1,8	0,24	2,4	0,32	3,6	0,46													
40					1,8	1,8	0,31	1,9	1,9	0,32	3,0	3,0	0,50	4,5	4,5	0,71									
50	75				1,8	1,8	0,39	2,4	2,4	0,51	3,7	3,7	0,76	5,6	5,6	1,11									
63	100				1,9	1,9	0,52	3,0	3,0	0,80	4,7	4,7	1,22	7,0	7,0	1,75									
75	110			1,8	1,8	0,59	2,2	2,2	0,71	3,6	3,6	1,15	5,6	5,6	1,73	8,4	8,4	2,50							
90	110			1,8	1,8	0,71	2,7	2,7	1,05	4,3	4,3	1,64	6,7	6,7	2,49	10,0	10,0	3,57							
110	115	1,8	1,8	1,8	0,92	2,2	2,2	2,2	1,06	3,2	3,2	3,2	1,52	5,3	5,3	5,3	2,48	8,2	8,2	8,2	3,72	12,3	12,3	12,3	5,36
125	120	1,8	1,8	0,00	2,5	2,5	0,00	3,7	3,7	0,00	6,0	6,0	0,00	9,3	9,3	0,00	13,9	13,9	0,00	13,9	13,9	0,00			
140	125	1,8	1,8	1,17	2,8	2,8	1,71	4,1	4,1	4,1	2,49	6,7	6,7	6,7	3,98	10,4	10,4	10,4	6,01	15,6	15,6	15,6	8,66		
160	132	1,8	1,8	1,34	3,2	3,2	2,24	4,7	4,7	4,7	3,26	7,7	7,7	7,7	5,23	11,9	11,9	7,86	17,8	17,8	11,29				
180	154	1,8	1,8	1,51	3,6	3,6	0,00	5,3	5,3	0,00	8,6	8,6	0,00	13,4	13,4	0,00	20,0	20,0	0,00						
200	145	1,8	1,8	1,68	4,0	4,0	3,50	5,9	5,9	5,11	9,6	9,6	8,15	14,9	14,9	12,30	22,3	22,3	17,68						
225	152	1,8	1,8	1,89	4,5	4,5	4,43	6,6	6,6	6,43	10,8	10,8	10,32	16,7	16,7	15,52	25,0	25,0	22,31						
250	160	2,0	2,0	2,34	4,9	4,9	5,36	7,3	7,3	7,90	11,9	12,64	18,6	19,20	27,8	27,56									
280	170	2,3	3,01	5,5	6,74	8,2	9,94	13,4	15,94	20,8	24,05														
315	180	2,5	3,68	6,2	8,54	9,2	12,55	15,0	20,07	23,4	30,44														
355	180	2,9	4,81	7,0	10,87	10,4	15,99	16,9	25,49	26,3	38,57														
400	200	3,2	5,98	7,9	13,82	11,7	20,27	19,1	32,46	29,7	49,06														
RG Pipe heads			RG1		RG 2		RG 3		RG 4		RG 5														
Min. Diameter	mm	16x1,2		40x1,8		63x1,9		90x4,3		140x4,1															
Max. Diameter	mm	63x3,0		110x8,2		160x7,7		250x7,3		400x11,7															
Heating zones		4		5		5		6		9															
heating capacity	KW	6,0		12,0		18,0		34,0		44,0															
max output	kg/h	540		940		1080		1200		1350															
Option			380		450		480		8		8														
Dual ax distance	mm	380		450		480		8		8															
Thermal centering	no. zones	4		6		6		8		8															



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