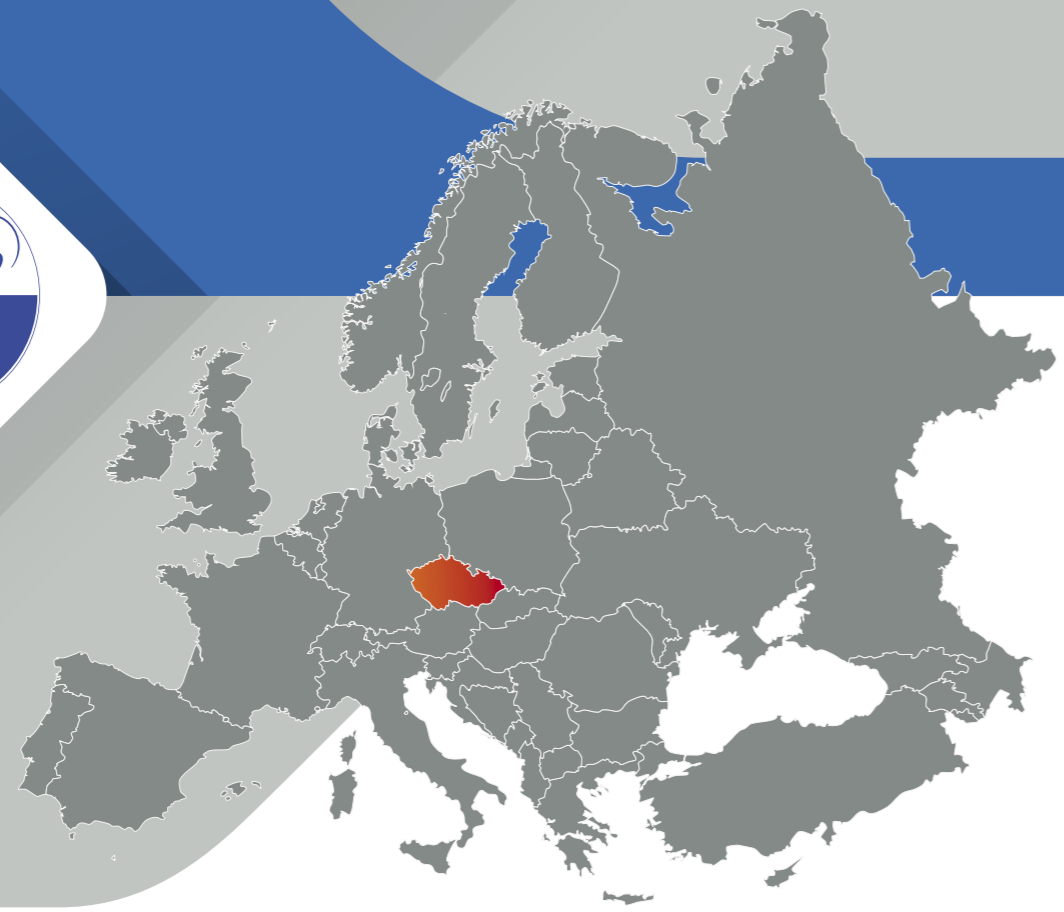


precision machines with a hot heart

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# CONTAINER GLASS FORMING MACHINES ISS

founded 1950



Sklostroj Turnov CZ, s.r.o.  
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## ISS SUPPORTED SOLUTIONS:

**Sections:** 6, 8, 10 & 12

**Production modes:** SG, DG, TG & QG

**DG:** 6 1/4" (eventually 5", 5 1/2")

**TG:** 5" (eventually 4 1/4")

**QG:** 95 mm

**Technology:**  
BB/PB/NNPB/LPBB®

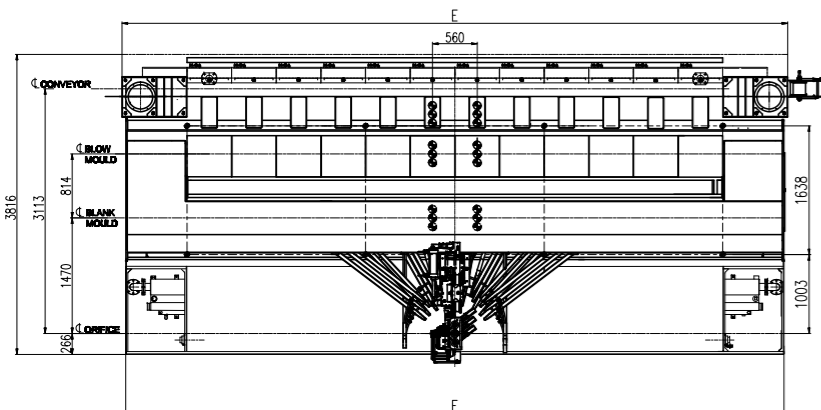
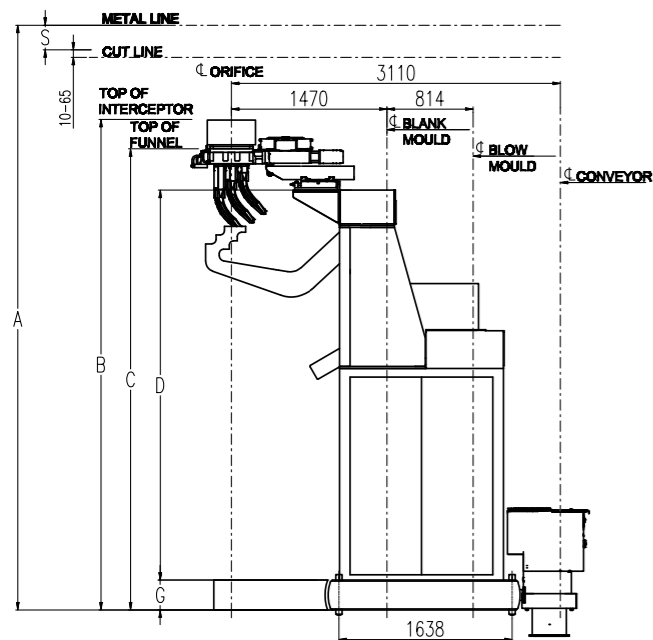
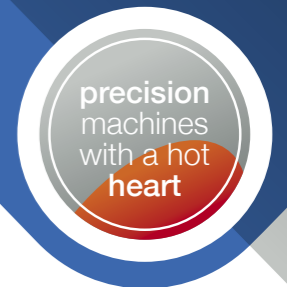
**ISS**  
**CONNECTS**  
**YOUR COMPANY**  
**WITH THE**  
**TECHNOLOGY**  
**YOU NEED**

## BENEFITS

- ❏ Servo-electric mechanisms provide precise and repeatable motion
- ❏ CD 5" TG production mode at the same speed as DG
- ❏ CD 95 mm QG production mode at the same speed as TG
- ❏ Full access to all motors and cables from underneath the machine
- ❏ Reduced energy consumption by 40%
- ❏ New safety devices and features
- ❏ Ergonomic and operator friendly design
- ❏ Precise and user friendly control & drive system "SDT-10" based on 100% standard components - Siemens
- ❏ Increased access to blank and blow moulds
- ❏ Wide range of ware sizes production
- ❏ Vertiflow and InVertiflow on blank and blow mould sides
- ❏ Cooling of each mould half can be controlled individually

## FEATURES

- ❏ SERVO feeder DS-P5-1
- ❏ SERVO feeder plunger, each drive independent 1-4 gob
- ❏ SERVO micro lifting of tube
- ❏ SERVO parallel shear
- ❏ SERVO gob distributor
- ❏ Gob delivery system with "V" shape
- ❏ SERVO parallel MOC for blank and blow side
- ❏ SERVO plunger mechanism or pneumatic plunger - optional
- ❏ SERVO pantograph baffle mechanism
- ❏ SERVO pantograph blow head mechanism
- ❏ SERVO invert mechanism
- ❏ SERVO take-out mechanism
- ❏ E-pusher mechanism
- ❏ Quick change accessories
- ❏ 360° axial cooling in blank and blow mould and additional Vertiflow in blow mould
- ❏ Proportional technology for plunger up, plunger cooling/counter blow and final blow
- ❏ SERVO conveyor with silent chain 150 mm with safety ladder and motorized leveling
- ❏ Electric control of dead plate cooling
- ❏ Automatic central lubrication system Lincoln



## PRODUCT DIMENSIONS

\*/ valid for standard model

Center Distance	6 1/4" DOUBLE GOB			5" TRIPLE GOB			95 mm QUAD GOB		
	B&B	P&B	NNPB	B&B	P&B	NNPB	B&B	P&B	NNPB
Technology									
Ware Range Reference	dimensions in [mm]			dimensions in [mm]			dimensions in [mm]		
Min.Height Under Finish*	66	66	66	50	50	50	54	35	31
Max.Height Under Finish	347	342	347	347	342	347	250*	250*	250*
Max.Body Diameter	121	121	121	90	90	90	65	65	65
Max.Finish Diameter	48	90	48	48	83	48	35	55	38

## Dimensional specifications – ISS Machines

Number of sections and dimensions in [mm]	6	8	10	12
A – Metal Line	5700	5700	6000	6300
B	4370	4370	4650	4870
C	4110	4110	4390	4610
D	3074	3074	3354	3920
E	4988	6108	7228	8348
F	4890	6010	7130	8250
G	285	285	285	325
Machine weight including moulds, variables, conveyor and platforms in [t]	31	38	45	52

## ENERGY AND UTILITIES CONSUMPTION (ISS MACHINE - TG, speed 17 cuts/min./section)

COMPRESSED AIR	Pressure	Quantity/one section
Working air (pneumatic plungers)	3.5 bar	0.5 Nm <sup>3</sup> /min
Working air (servo plungers)	3.5 bar	0.15 Nm <sup>3</sup> /min
Technology air BB	4 bar	2.7 Nm <sup>3</sup> /min
Technology air PB*	4 bar	6 Nm <sup>3</sup> /min
* Plunger cooling consumption reference 360° at 4 bar		
VACUUM**	150 mbar	0.5 Nm <sup>3</sup> /min
** Vacuum consumption depends on mould design, wear and timing		
COOLING AIR	Pressure	Quantity
Blank and blow mould, neck ring	0.16 bar	33.9 Nm <sup>3</sup> /min
Conveyor wind	0.09 bar	20 Nm <sup>3</sup> /min
Deadplates wind	0.09 bar	14 Nm <sup>3</sup> /min
COOLING WATER	Pressure	QTY(entire machine)
Scoops, drives, control cabinet, etc.	1 - 2.1 bar	65 l/min
ELECTRIC POWER	Network type	Input
Machine connection (installed UPS)	3+N+PE 400/230V 50Hz	36 kW
Machine consumption (10 sections)	3+N+PE 400/230V 50Hz	20 kW