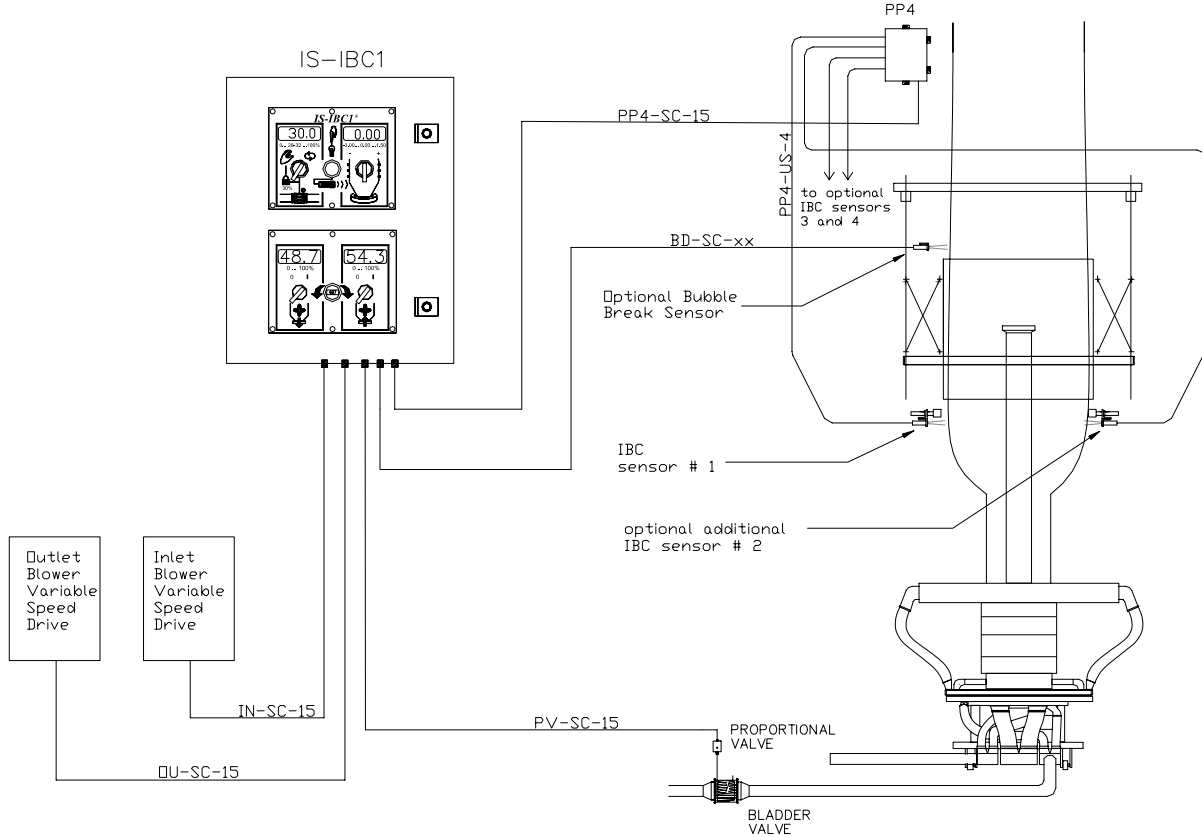


Specification Sheet

DRJ Part Number IBC1XSAB

Drawing Set: IS-03-19



Application

This cost effective configuration is best suited for blown film applications that make a low number of size changes over the period of a week or have low manpower availability to operate the line. This system provides a significant improvement over mechanical arm and other ultrasonic control systems. The automatic blower balance (ABB) feature greatly simplifies the startup process and adjustments to cooling levels by always keeping the blowers balanced. Size changes do require the operator to set the size of the cage to achieve the correct bubble size. All DRJ IBC systems come with both a comprehensive manual and a color operator's manual.

Select This Configuration When:

The customer is looking for an upgrade from an existing DRJ or competitive system and a stand-alone panel for the operator interface is desirable. Also, this configuration works well if the new IBC system will be part of a die upgrade package because it keeps installations costs down. The main system components and operator controls are installed in NEMA panel that is easily mounted to existing support structure. All original wiring is supplied with quick connect military style connectors. Main panel dimensions: Height-19.75" (500mm), Width-15.75 (400mm), and Depth-8.25" (210mm)

Assumptions

Variable speed drives may either be purchased with the system, supplied by another vendor, or be previously installed units from an existing IBC system. If drives are supplied by DRJ, the drives will be pre-programmed with all settings for proper IBC operation. If the drives are to be supplied by another vendor, check first with DRJ to ensure compatibility of the drive with the IBC system. DRJ will supply a wiring and programming guides for compatible drives. If previously used drives and blowers are to be integrated with this system, DRJ must check the variable speed drives for proper power ratings and the blowers for proper airflow to ensure optimum performance. Use the DRJ configuration form to identify any used equipment that will be used with this system.

Electrical

System comes standard with Allen Bradley "Euro" style switches. Optional Klockner Moeller switches are also available. Power requirements: 100-250 VAC, 50-60 Hz, 4 amps maximum. Input terminal block is fused with illuminated blown fuse indicator. A power switch is provided on the bottom of the main panel. All sub-systems and control voltages are powered by 24 volts DC and are individually fused.

General Installation Requirements

Main controller and power supply should be mounted in close proximity of the die. The IBC sensors must move linearly with the change in diameter of the cage. The IBC sensors must also move vertically as the cage moves. The flow control valve must be mounted within ten feet of the die for optimum performance.

Standard Features

Item	Description
High Performance IBC Control	Patented IBC technology provides the best possible control of the bubble at the highest air exchange rate. State of the art ultrasonic sensor technology provides optimum performance even in high bubble flutter conditions. Patented "bladder valve" technology allows very good control of airflow over a wide range of operating conditions. Layflat control capability is +/- 1/8 inch (+/- 3mm). Actual performance depends on alignment of equipment, stability of melt pressure, tension control and melt strength.
Digital Bubble Contact Control	Allows the operator to precisely position the bubble relative to the sizing cage. This provides flexibility to run very soft materials that would otherwise be marked by the sizing cage.
Internal Diagnostic Modem Interface	Allows DRJ to log into any IBC system and monitor and tune the operation of the system. Simply connect a standard analog telephone line to the system. No other devices required.
One-touch Air Exchange Adjustments	The automatic blower balance feature completely eliminates the need for the operator to adjust both blowers to achieve the proper balance between the inlet and outlet blowers. By adjusting a single control, the operator can quickly set the air exchange rate a new setting. The system also automatically reviews the blower balance and readjusts without disturbing the process.

Optional Features

Item	Description
Multiple Sensors	Provides 2, 3 or 4 IBC sensors to monitor bubble diameter. Useful in rotating die applications or when very large bubble diameter precludes the ability to maintain a round bubble. For example, if the bubble were too large to support it with a cage, then four IBC sensors would be the optimum configuration. Note: Gammatec CCN cages support a maximum of two IBC sensors.

Bubble Break Detector	Provides a relay output (4 contacts – normally open and normally closed) when bubble break is detected. The unit uses the layflat sensors to detect a bubble break. Both sensors must confirm the bubble break before the detector is activated. Timing circuits prevent false detections during startup. This feature arms itself automatically so the operator does not have to remember to arm it.
Klockner Moeller Electrical Switches	Replaces the Allen Bradley switches with the Euro style switches from Klockner Moeller. Change the part number to IBC1XSKB .