

THEORETICAL FEEDRATES FOR FEEDING SCREWS IN LITRES PER HOUR AT REQUIRED RPM

FEEDER MODEL	SCREW DIAMETER	Speed of screw in RPM								
		10	20	40	60	80	100***	120	140	160
30*	10/5 + CR	0,080	0,160	0,320	0,480	0,640	0,800	0,960		
30*	10/5	0,100	0,200	0,400	0,600	0,800	1,000	1,200		
30*	10/10 + CR	0,240	0,480	0,960	1,440	1,920	2,400	2,880		
30*	10/10	0,300	0,600	1,200	1,800	2,400	3,000	3,600		
30* / 40	13mm + CR	0,77	1,54	3,08	4,62	6,16	7,70	9,24	10,78	12,32
30* / 40	13	1,10	2,20	4,40	6,60	8,80	11,00	13,20	15,40	17,60
30* / 40	18	2,40	4,80	9,70	14,50	19,40	24,20	29,10	33,90	38,80
30** / 40	21	4,30	8,60	17,20	25,80	34,40	43,00	51,60	60,20	68,80
40	27	9,30	18,70	37,50	56,20	75,00	93,70	112,50	131,20	150,00
40** / 50 / 60	31	14	28	56	84	112	140	168	196	224
50 / 60	40	30	60	120	180	240	300	360	420	480
60	50	58	116	232	348	464	580	696	812	928
60	58	82	164	328	492	656	820	984	1.148	1.312
60** / 70 / 80	61	107	214	428	642	856	1.070	1.248	1.498	1.712
70 / 80	75 + CR	159	318	636	954	1.272	1.590	1.908	2.226	2.544
80	100 + CR	415	830	1.660	2.490	3.320	4.150	4.980	5.810	6.640
80	125 + CR	860	1.720	3.440	5.160	6.880	8.600	10.320	12.040	13.760
80	155 + CR	1.663	3.326	6.652	9.978	13.304	16.630	19.956	23.282	26.608
80**	165 + CR	2.055	4.110	8.220	12.330	16.440	20.550	24.660	28.770	32.880

* Feeder model 30 runs at minimum speed of 3 RPM and maximum 125 rpm: for real minimum rate divide the feed rate at 10 rpm by 3.3

** Feeder models 30, 40, 60 or 80 : Largest screw possible but WITHOUT nozzle only!

*** Standard RPM of screw for Feeder 40 - 80. Higher speeds than 120 RPM not recommended.

CR = Screw with Center Rod

Feeder model 50, 60 and 70 can handle screw size range till 13 mm if necessary

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