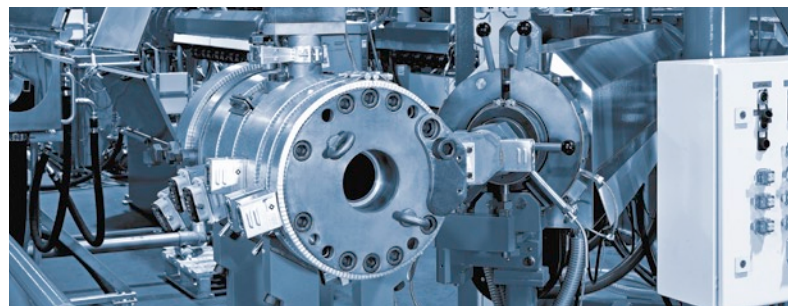


Single and Double Cross Heads Qu and DQu



TROESTER

EXCELLENCE IN EXTRUSION.

Single and Double Cross Heads

Qu and DQu

The TROESTER Single Cross Heads Qu and Double Cross Heads DQu apply the insulation of single-core cables in voltage classes up to 1 kV, the sheathing of cables, as well as the sheathing of flat cables.

The Cross Heads are employed in Insulation lines, sheathing lines, Silane lines, Silicone lines, as well as in Rubber-CV lines. Depending on the area of application, it can be designed for plastic and/or rubber compounds. The conical construction of the material distribution flow channels of the Cross Heads resulting in an absolute precision fit, together with excellent sealing and easy installation/disassembly.

The temperature control of the QU and DQu is electrically or via pressurized water or oil depending on the area of application. The separate temperature control zones guarantee ideal flow characteristics for the compound, in addition to rapid heating up to operating temperature and an exact separation of the temperatures for the melt streams from the ambience and among each other at the DQu. Optionally the Double Cross Heads can be designed to be able to change the melt streams and strip or skin distributors can be installed. In addition, the Head can be insulated against the heat emanating from the CV tube.

The Cross Heads are equipped with computer-optimized material flow channels. This enables the same average flow rates and layer thicknesses to be achieved at the die outlet. The flow channels are optimally matched in shape and depth to the viscosities of the required materials.

The very low wall thickness tolerances for the layers results in material savings. Especially for flat cables and sector conductors, special guiding units are placed in front of and/or in the head, which ensure that excellent layer thickness tolerances will be achieved. The dies can be positioned at the front of the head, which enables short tool changeover times in a maximum convenient way.

For the small cross heads no additional support is required. They can be connected and carried by the Extruder.

TROESTER Cross Heads and their design of cross head tooling and flow channels guarantee a perfect material flow and will not allow the melt to cross-link within the head. This contributes to uninterrupted, maximum possible production times. The use of dial gauges allows for an outstanding reproducibility of centering, thus further minimizing operating costs.



Single Cross Head Qu 80 E
on maintenance trolley

The cross heads are supplied with hardened material flow channels to prevent any damage during head cleaning. As an option, hydraulic die centering and automatic centering, is also available to further simplify cross head handling.

For Double Cross Heads the layout of the extruders can be from one or both sides, depending on the requirements and the space available i.e. machine connections can be modified to suit the prevailing on-site space conditions. With additional blind pieces all Double Cross Heads can be used for 1-layer production as well.

Main Advantages of TROESTER Single and Double Cross Heads Qu and DQu

- > Long life and low maintenance design
- > Big product range with one cross head only
- > Perfect sealing and positional accuracy due to conical design
- > Optimized distribution flow channels minimize layer thickness tolerances, thereby saving material
- > Short changeover times of extrusion tools
- > Hardened material flow channel parts for easy cleaning
- > Minimal re-centering using dial gauges
- > Rapid heating-up to operating temperature
- > Exact temperature setting of the melt stream(s)

Technical Data (Single Cross Head Qu)

Cross Head Size	Diameter before Cross Head mm	Diameter after Cross Head (max.) mm
10	1,0 - 7,0	8,0
up to	up to	up to
240	80,0 - 225,0	230,0

Technical Data (Double Cross Head DQu)

Cross Head Size	Diameter before Cross Head mm	Diameter after Cross Head (max.) mm
20	2,0 - 16,0	17,0
up to	up to	up to
240	15,0 - 170,0	180,0

Bigger cross head sizes upon request.