The InnoPET Blomax Series IV has an output rate of up to 81,000 PET bph. The InnoPET Blomax Series IV is available in a modular design of 4 to 36 blowing stations, each with an output rate of up to 2,500 PET bph. The standard mould hanger can cover bottle volumes from 0.1 to 3.0 liters. Special sizes can also be produced.

During the development of all technical innovations within the InnoPET Blomax Series IV, special emphasis was placed on key requirements like minimum energy consumption, process stability as well as fast changeover times respectively easy operation and maintenance. The focus and goal of the development was to minimize the total cost of ownership per produced bottle. All technical innovations integrated into the Series IV support this goal.

**The NIR Reflexx-oven**
- Exclusive use of short-wave, energy-dense NIR (Near Infra Red) radiation
- Heating-up time of preforms reduced by 50%
- Reduction of surface heat
- Re-heat and cooling energy consumption reduced by approx. 30% vs. traditional heating technology

**The Clever-Loc blow molding stations**
- Minimum footprint design, more stations on the same blowing wheel diameter
- Only one half opens, the other half remains rigid
- Clever-Loc device, clamping through toggle lever
- Longer process time
- Higher specific output of up to 2,500 bottles/h/station
- Compatible with Series III molds

**Preform transport via active mandrel and TouchGrip system**
- Improvement of the established mandrel system: Active mandrel transports preforms gently and securely through the oven
- Very small pitch: 37.7 mm
- TouchGrip gripper systems take over preforms/bottles

**Servo-driven StretchFlexx stretching system**
- Stretching speed independent of machine speed
- Servomotors control the stretching rod
- Rapid mould change-over, no mechanical adjustments
- Stretching movement and -speed can be adjusted on the screen
- High process stability
- Less scrap

**Compressed air savings with Eco-Space valves**
- Approx. 15% decrease of top industrial values in compressed air consumption through redesign of valve block
- Approx. 25-30% savings of blowing air through reduced dead air volume
- Airback™ air recycling system for up to 40% internal highpressure recovery

**Low maintenance**
- Reduction of wear parts
- Central axis of blowing station with permanent lubrication
- Automatic central lubrication system
- No adjustment of guidings and transfers
- Large doors, easy accessibility

**Availability**
- Up to 25% savings in change-over time of blowing stations
- Start-up time minimized to just 15 sec for many applications

**More efficiency in blocked systems**
- Trouble-free blocking with an InnoPET BloFill or InnoPET TriBlock
- Short start-up time
- 50% less preform scrap after an emergency stop
- Improved capacity adjustment of the entire system by an independent stretching motion
- Enhanced product quality

**Important:** Reference of all values is made in comparison to Series III.
### 2_KHS INNOPET® BLOMAX SERIES IV
**STRETCH BLOW MOLDING MACHINES**

| InnoPET Blomax Series IV Machine type/number of blowing stations | Maximum nominal output *) | Standard bottle 0.5-l-bottle/h up to bottle volume | Maximum diameter | Maximum height | Machine footprint (A x B) | Machine height | Weight of basic machine | Electrical load | Blowing air consumption, blowing pressure 25 bar, 0.5 l, 8.5 g (taking Airback Plus into account) | Volume Preformsilo | Bottles after preform input stop | Number of transport mandrels | Number of standard installed heater boxes | Max. diameter, support ring |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | bph* | l | mm | m | m | kg | kVA | kWh | Nm/h | kW | m³ | pcs | pcs | pcs | mm **|
| 6 | 15000 | 0.1-3.0 | 115/125 | 365 | 6.1 x 4.7 | 3.65 | 4.5 | 13250 | 111.4 | 28.3 | 225 | 4.2 | 2.8 | 114 | 136 | 6 | 35/47 |
| 8 | 20000 | 0.1-3.0 | 115/125 | 365 | 6.1 x 4.7 | 3.65 | 4.5 | 14000 | 131.4 | 37.7 | 276 | 5.6 | 2.8 | 114 | 139 | 6 | 35/47 |
| 10 | 25000 | 0.1-3.0 | 115/125 | 365 | 6.5 x 4.7 | 3.55 | 4.5 | 15100 | 174.2 | 47.1 | 326 | 7.0 | 2.8 | 132 | 159 | 8 | 35/47 |
| 12 | 30000 | 0.1-3.0 | 115/125 | 365 | 7.2 x 4.9 | 3.55 | 4.5 | 19250 | 208.3 | 54.5 | 377 | 8.3 | 2.8 | 151 | 180 | 10 | 35/47 |
| 14 | 35000 | 0.1-3.0 | 115/125 | 365 | 7.6 x 4.9 | 3.55 | 4.5 | 20250 | 229.9 | 66.0 | 427 | 9.7 | 2.8 | 170 | 203 | 12 | 35/47 |
| 16 | 40000 | 0.1-3.0 | 115/125 | 365 | 7.6 x 4.9 | 3.55 | 5.1 | 21000 | 249.9 | 75.4 | 478 | 11.1 | 2.8 | 170 | 209 | 12 | 35/47 |
| 18 | 45000 | 0.1-3.0 | 115/125 | 365 | 8.4 x 5.1 | 3.55 | 5.1 | 24950 | 294.3 | 84.8 | 528 | 12.5 | 2.8 | 207 | 246 | 16 | 35/47 |
| 20 | 50000 | 0.1-3.0 | 115/125 | 365 | 8.4 x 5.1 | 3.55 | 5.1 | 25700 | 314.3 | 94.2 | 583 | 13.9 | 2.8 | 207 | 250 | 16 | 35/47 |
| 24 | 60000 | 0.1-3.0 | 115/125 | 365 | 9.4 x 6.1 | 3.55 | 5.1 | 28150 | 366 | 113.1 | 684 | 16.7 | 4.5 | 226 | 279 | 18 | 35/47 |
| 28 | 70000 | 0.1-3.0 | 115/125 | 365 | 10.4 x 6.1 | 3.55 | 4.1 | 30500 | 445.8 | 131.9 | 786 | 19.5 | 4.5 | 282 | 332 | 24 | 35/47 |
| 32 | 72000 | 0.1-3.0 | 115/125 | 365 | 11.1 x 7.1 | 3.55 | 4.1 | 33700 | 465.8 | 135.7 | 806 | 20.0 | 4.5 | 282 | 356 | 24 | 35/47 |
| 36 | 81000 | 0.1-3.0 | 115/125 | 365 | 11.1 x 7.1 | 3.55 | 4.1 | 35200 | 505.8 | 152.7 | 897 | 22.5 | 4.5 | 282 | 346 | 24 | 35/47 |

*) dependent on preform and bottle design

**) larger diameters on request