

LP TABLE QUANTITY

	L/D																	
	10		20		30		35		40		45		50		55		60	
	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP	Raw Mat. Kg	LP
20	0,1	2 ml	0,1	2 ml	0,2	4 ml	0,2	4 ml	0,3	6 ml	0,3	6 ml	0,3	6 ml	0,3	6 ml	0,4	8 ml
30	0,2	4 ml	0,4	8 ml	0,6	12 ml	0,7	14 ml	0,8	16 ml	1,0	20 ml	1,1	22 ml	1,2	24 ml	1,3	26 ml
40	0,5	10 ml	1,0	20ml	1,5	30 ml	1,8	36 ml	2,0	40 ml	2,3	46 ml	2,5	50 ml	2,8	56 ml	3,0	60 ml
50	1	20 ml	2	40 ml	3	60 ml	3	60 ml	4	80 ml	4	80 ml	5	100 ml	5	100 ml	6	120 ml
60	2	40 ml	3	60 ml	5	100 ml	6	120 ml	7	140 ml	8	160 ml	8	160 ml	9	180 ml	10	200 ml
70	3	60 ml	5	100 ml	8	160 ml	9	180 ml	11	220 ml	12	240 ml	13	260 ml	15	300 ml	16	320 ml
80	4	80 ml	8	160 ml	12	240 ml	14	280 ml	16	320 ml	18	360 ml	20	400 ml	22	440 ml	25	500 ml
90	6	120 ml	10	200 ml	18	360 ml	20	400 ml	23	460 ml	25	500 ml	30	600 ml	32	640 ml	35	700 ml
100	8	160 ml	15	300 ml	25	500 ml	27	540 ml	30	600 ml	35	700 ml	40	800 ml	45	900 ml	60	1,2 l
110	10	200 ml	20	400 ml	35	700 ml	40	800 ml	42	840 ml	47	940 ml	50	1 l	55	1,1 l	65	1,3 l
120	14	280 ml	27	540 ml	40	800 ml	45	900 ml	55	1,1 l	60	1,2 l	70	1,4 l	75	1,5 l	80	1,6 l
140	22	440 ml	45	900 ml	65	1,3 l	75	1,5 l	85	1,7 l	100	2 l	110	2,2 l	120	2,4 l	130	2,6 l
160	32	640 ml	65	1,3 l	100	2 l	115	2,3 l	130	2,6 l	150	3 l	160	3,2 l	180	3,6 l	200	4 l
180	45	900 ml	90	1,8 l	140	2,8 l	160	3,2 l	180	3,6 l	200	4 l	230	4,6 l	250	5 l	275	5,5 l
200	65	1,3 l	125	2,5 l	200	4 l	220	4,4 l	250	5 l	280	5,6 l	300	6 l	350	7 l	375	7,5 l
220	85	1,7 l	170	3,4 l	250	5 l	300	6 l	340	6,8 l	380	7,6 l	420	8,4 l	460	9,2 l	500	10 l
240	110	2,2 l	220	4,4 l	330	6,6 l	380	7,6 l	435	8,7 l	490	9,8 l	550	11 l	600	12 l	650	13 l
260	140	2,8 l	280	5,6 l	400	8 l	500	10 l	550	11 l	600	12 l	700	14 l	750	15 l	850	17 l

For cleaning **Blow molding**, **blow film** and **cast film** machines you have to add the quantity necessary for the head (die) and eventually for the accumulator, which can change according to the type. Generally you have to calculate half of the quantity needed for the screw/barrel.

These are *indicative* values depending on colour, material and machine conditions. The quantities of raw material are indicated in **kilograms**. All quantity values are for a single-screw machine; for a double-screw machine multiply the value by 1,6.

For the very first cleaning operation the indicated quantities must be **doubled** (it will be necessary to make **two** cleaning operations depending on the machine condition).