

***THE CUTTING EDGE OF
PELLETIZING***



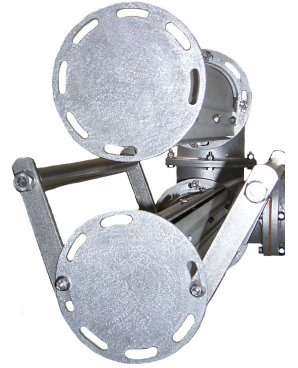


AK SERIES AIR KNIFES

Available in 6, 12 & 18"

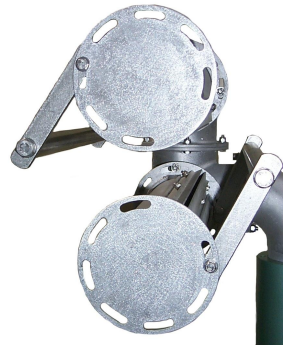


Bay Plastics Machinery Air Knives are designed to meet the demanding needs of your extrusion process. Made from rust free components, the dual air nozzle design is available in three different sizes. The open ended design allows easy start up and maintains proper strand control.

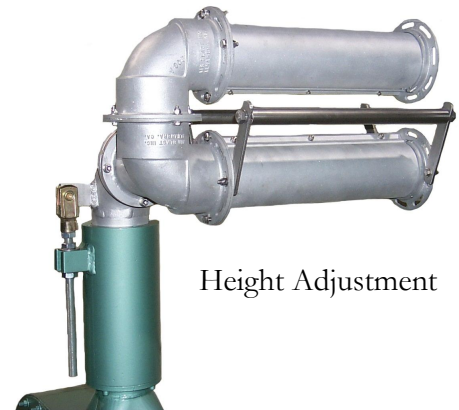
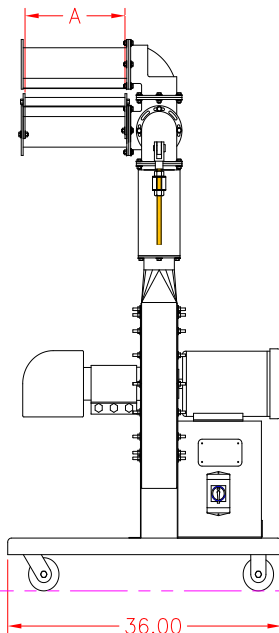
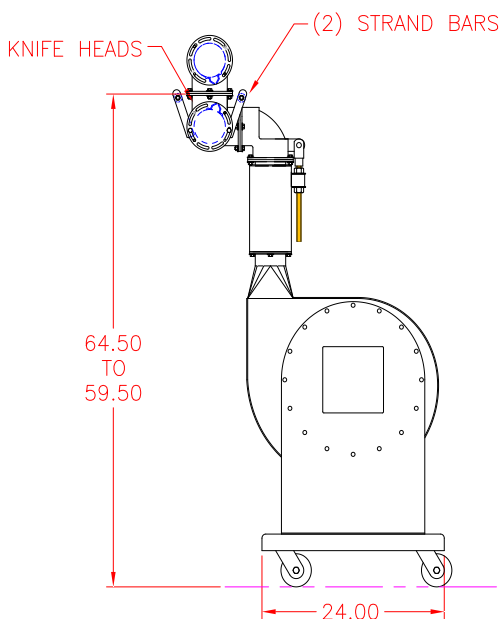


Flexibility is built into this unit, the wear resistant strand guides can be adjusted and moved as needed to best control the strands as they pass through the air knife. The height of the unit is easily adjustable to meet the needs of your specific feed heights. This unit can change from left to right direction to right to left direction by simply repositioning the nozzles.

Strand guides can be repositioned as needed



The blower pulls air into the self contained blower and pushes the air flow into the nozzles. The angle of the nozzles can be adjusted to offer the customer the best possible control of the water removal on the specific product.



Model	A. Dim	HP	CFM
AK-06	6ö(150)	2	335
AK-12	12ö(305)	3	495
AK-18	18ö(450)	3	495

VAK SERIES VACUUM AIR KNIFE

Available in 12", 16", 24", & 32"



The **VAK** dries the strands by a combination of positive and negative air pressure. Experience has shown that a combination of vacuum table and dual positive pressure nozzles offer the best drying results.

The air supply for both pressure and vacuum is provided by one blower. The vacuum air together with the removed water passes a demister before entering the fan. The demister separates the water and the air, the water drops to the bottom of the suction box and is then drained by a self regulating valve.

The pressure air stream is divided into two streams by a manually operated flow control valve. One stream passes through the blowing nozzle and the remaining air passes through a silencer.

The Distance between the blowing nozzle and the strand is approximately 1" to 1 1/2". To ease start up, the positive pressure nozzles are lifted up to allow the strands to be strung up.

For the best results the strands need to be separated and contact the vacuum table. The vacuum table is slightly bowed and hardened grooved rolls position the strands on the table.

Positive Pressure Air Knives

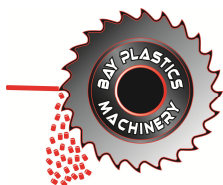


Negative Pressure Vacuum Table



Optional: Tank Pivot

Model	Working Width	HP	CFM	SP H ₂ O
VAK 12	12" (305)	7.5	2,224	8"
VAK 16	16" (406)	7.5	2,224	8"
VAK 24	24" (610)	25	3,531	16"
VAK 32	32" (813)	25	3,531	16"



BAY PLASTICS MACHINERY

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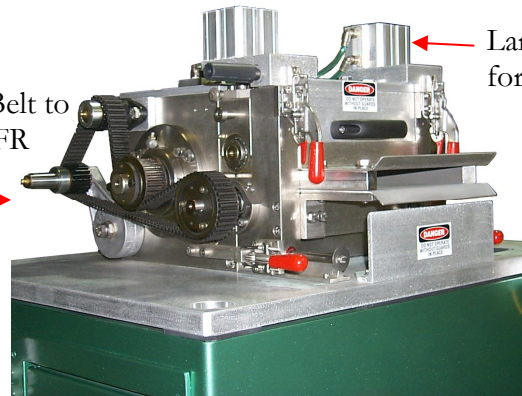
AXP PELLETIZERS

Available in 4", 6", 8", 12" & 16"

Rates from 500-6,500 lb/hr

The **AXP** pelletizer.

A cost engineered product which did not cut performance. Small footprint, simple operation, and easy to maintain are just a few examples of this feature packed machine. No tools required to open the exterior noise cover, cutting chamber or removal of the upper feedroll. The entire range of thermoplastics can be pelletized, from soft rubber-like to brittle, fragile, high-density and glass filled reinforced thermoplastics. The machines are designed for extreme working conditions 24/7 and have the appropriate robust construction.



Serpentine Belt to Drive the LFR

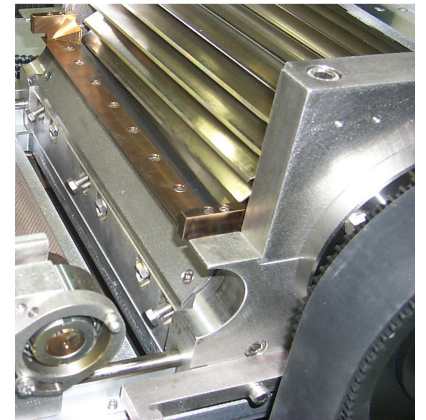
Large Pneumatic Cylinders for UFR Pressure

The **AXP** pelletizers offer our customers a proven design with a number of advantages over the competition. The **AXP** series

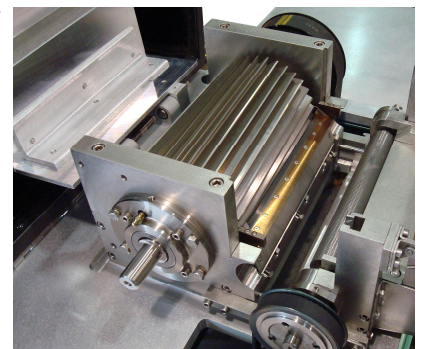
- Uses **50% less floor space** than a gear box driven machine.

- Eliminated the gear box and u-joints, simplifying the lower feed roll drive, **eliminating costly failures.**

- Un-driven upper feed roll—**extends the life** of the **Hypalon covered rolls.** The upper feed roll is driven from contact to the lower feed roll, ensuring that both rolls are always running at the exact same speed.
- Push/pull bed knife for cutting gap control—using the push/pull design to control the cutting gap is **more accurate** than eccentric systems.
- Use of traditional ball bearings for the rotor bearings, allows for much **higher RPM** than spherical roller bearings.
- Large Pneumatic cylinders mounted on top of cutting chamber—2 1/2" bore cylinders offer **greater pulling force** than the competition and the location opens up the front of the cutting chamber for easier cleanout and maintenance.
- Easy clean out—tool less entry to the cutting chamber, **slide out discharge chute**, eliminated hang up points, etc.



Push-Pull Bolts - Rotor Gap Adj.



Slide Open Front End for Easy Clean Out, and Maintenance of Cutting Chamber



Removable Discharge Chute



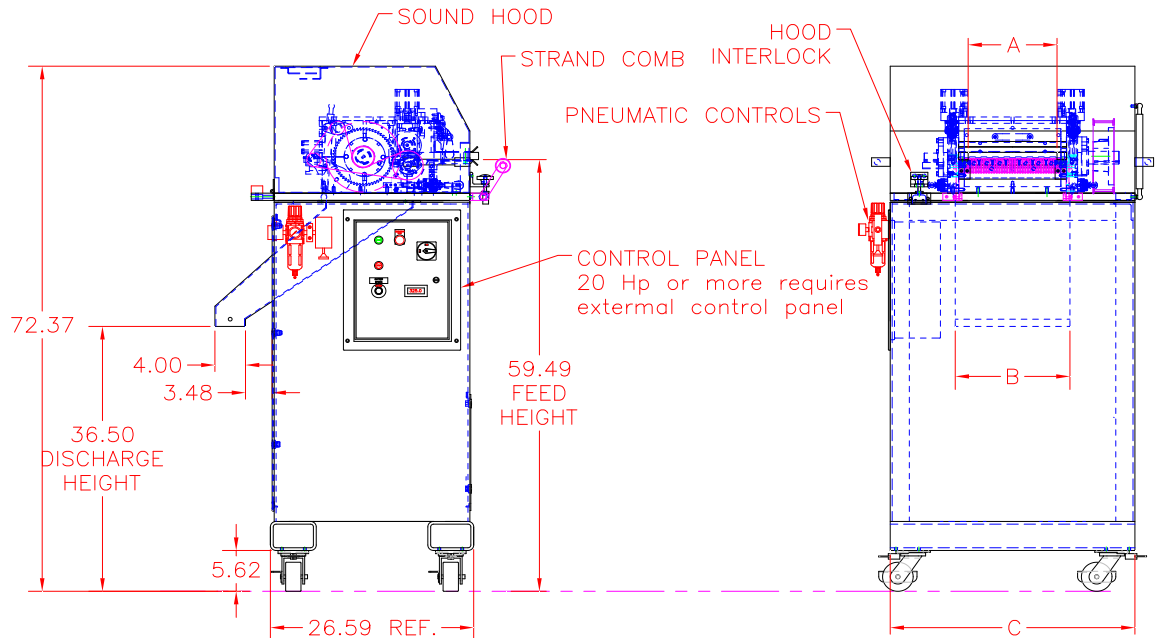
Technical Data:

Available Options

- 32 Blade Wedge Lock Rotor
- Up to 16 Blade Bolt On Type Rotor
- Wear Package
- 24, 48, or 60 Tooth Stellite Tipped Rotor
- Tool Steel Rotors
- Special Bed Knife Materials
- Dual Drive with Independent Control of Feedroll Speed and Rotor Speed
- Extra Horse Power
- Special Coverings on Upper Feedroll
- Special Surfaces and Coatings on Lower Feedroll
- Custom Heights
- Custom Discharge Chute Configurations
- Work Platforms
- Water Baths
- Vacuum Strand Dryers
- Pressure Air Knives
- Flash Off Conveyor
- Many Others

Other Features:

- **Safety:** A safety interlock system. There are no pinch points which can be reached with the sound hood in place.
- **Cleanability:** Our robust design is extremely rugged with its slide rail system. The use of clamps makes it easy to release the pressure without having to deal with loose hand knobs which can be damaged or lost.
- **Repairable Stellite Rotors:** If the rotor tooth is damaged, bent or completely broken out, we can repair a single tooth or all of them. This is possible due to the proprietary welding process developed by Bay Plastics Machinery.
- **Other Standards:** Eccentric mounted bearings for lower feedroll gap settings } four edge solid tungsten carbide bed knife } 32 tooth Stellite tipped rotor } special diamond knurled lower feedroll } Hypalon covered upper feedroll } AC variable frequency drive



Pelletizer Type		AXP04	AXP06	AXP08	AXP12	AXP16
Strand Rating	1/8 in.	20	30	40	60	80
Std. Strand Speed	FPM	85-250	85-250	85-250	85-250	85-250
Motor Size	HP	3	5	10	15	20
Type of Drive		AC Variable Frequency Inverter				
Typical Throughput	Per Strand	80 LB (Based on 1/8" x 1/8" pellets @ 250 FPM)				
Dimensions						
A (Nominal Feed Width)	inches	4	6	8	12	16
B (Discharge Width)	inches	7	9	11	15	19
C (Base Width)	inches	32	32	32	36	36
Weight (estimated)	Lbs	1,450	1,775	1,850	2,200	2,400
Power Requirement (Based on single drive and standard motor HP)	FLA	8.5 (5Hp)	8.5 (5Hp)	15 (10Hp)	22 (15Hp)	32 (20Hp)

**MADE
IN THE USA**



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BT 25 STRAND PELLETIZER

The BPM Series Pelletizer was developed and engineered for the laboratory and small production runs. Based on the proven design of our larger production machines, this lab pelletizer has many of the features found only in production units. From glass filled engineered resins to soft rubber like polymers, these work horses are tough enough to get the job done.

These compact units offer the same benefits found in our larger pelletizers such as:

- Complete access for visual inspection and cleanliness
- Optimum strand control due to a larger offset upper feedroll
- Tool-less entry to the cutting chamber
- Easily removable rotor and upper feedroll
- Maintenance free bearings
- Positive strand feed to the cutter
- Safety interlock

The BPM Bench Top model BT 25 can manage four, 1/8" diameter strands of olefins and two 1/8" diameter strands of engineered resins. Standard line speeds of 20 to 78 feet per minute can be achieved. For more demanding applications we offer a High Speed option to achieve a line speed of 40 to 156 FPM. For those application requiring lower line speed, a low speed version from 4 to 40 FPM is available.

Equipped with independent drives for the feedroll and rotor, this machine can change pellet sizes on demand. With so many features packed in a compact pelletizer, this unit will compliment any lab or small production facility.

Other options include:

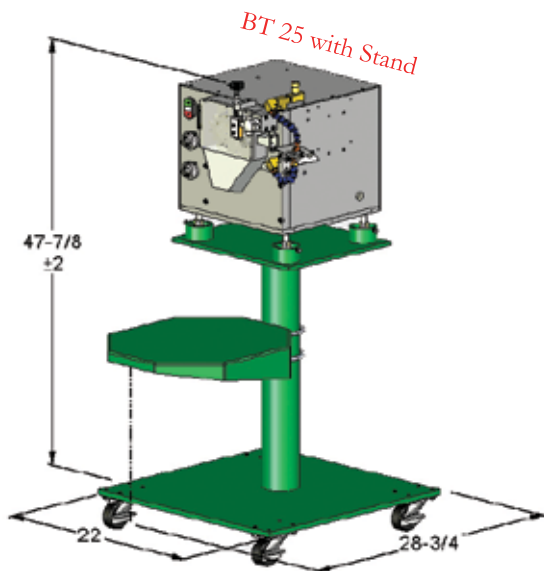
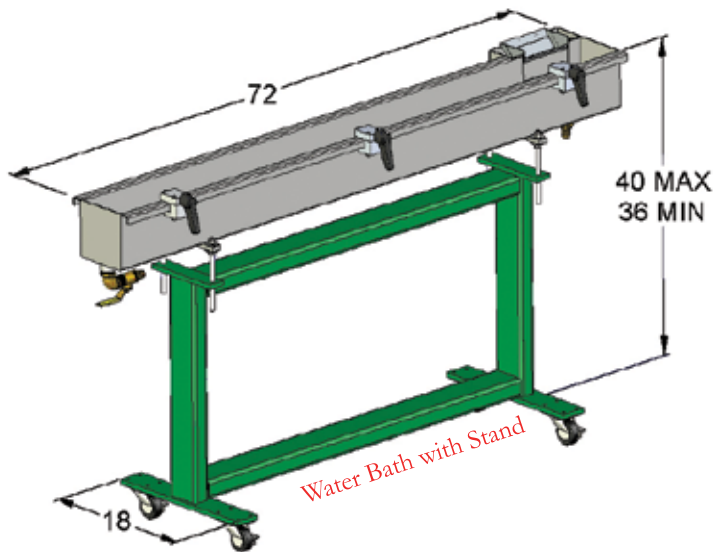
- Carbide Tipped Rotor
- Water Bath
- Support Stand
- Air Knife
- Water Recirculation System

A Uni-Base option is a complete pelletizing system perfectly suited for small runs. With the Uni-Base system design, the pelletizer is mounted on a base consisting of a 6 foot long water bath and air knife. The air knife comes equipped with flow control, guard and drip tray.



Made in USA

Technical Data:



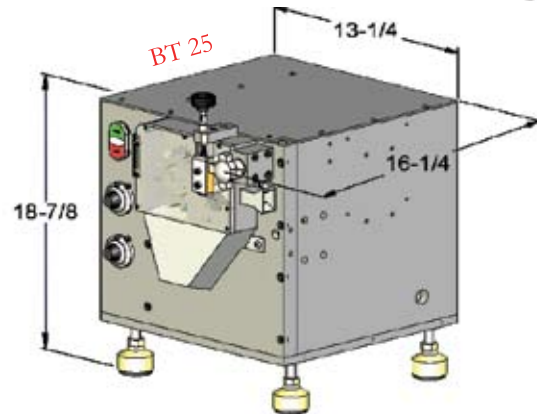
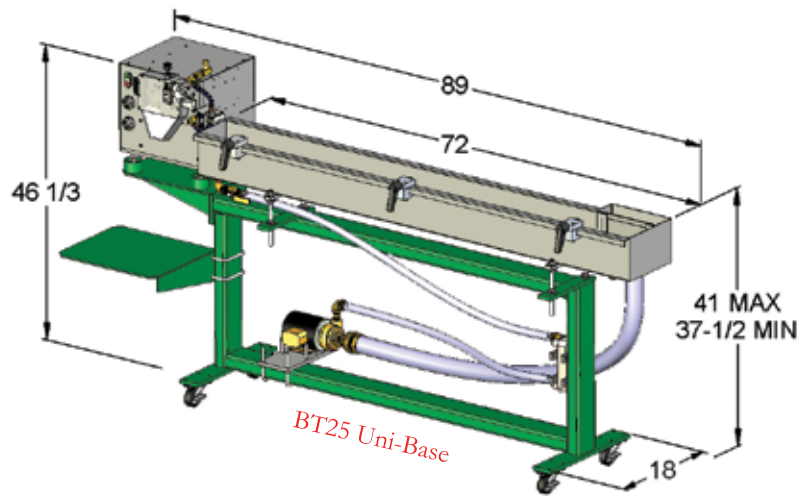
Available Options

- 12 Tooth Carbide Rotor
- AC Variable Frequency Drive
- 230 or 460 Volt AC Drives
- High Speed Version of 156 FPM
- Pharmaceutical version
- Explosion Proof Packages



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Specifications and design subject to
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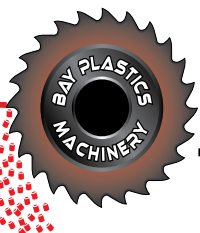


Pelletizer Model BT 25

Working Width	1.0 inch	25mm
Strand Rating (1)	2-4	2-4
Std. Strand Velocity	20-78 FPM	6-24 m/min
Std. Rate per Strand (2)	25 Lb/hr	11 Kg/hr
Optional Strand Velocity	40-155 FPM	12-48 m/min
Opt. Rate per Strand (2)	50 Lb/hr	22 Kg/hr
Motor Size (Rotor)	3/4 HP	0.55 kW
Motor Size (Feedroll)	1/17 HP	0.04 kW
Max. Rotor Speed	800 RPM	
Voltage	110 volts Single Phase	
Type of Drives	DC	
Amp Draw (FLA)	12.9 Amp	
Std. No. of cutting edges Rotor	12	
No. of cutting edges Bed Knife	8	
Opt. No. of cutting edges Rotor	2, 4, 6, 24, or 36	

(1) Up to four strands of Olefins, Up to two strands of engineered resins

(2) Based on 1/8" strand diameter, 1/8" long pellets, and material with specific gravity of 1.0



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SB 100 & SB 50 STRAND PELLETIZER

The SB series of strand pelletizers is a cost effective, easy to clean, robust pelletizing system, designed to process the entire range of thermoplastics. From the soft rubber-like Elastomers to a highly filled & reinforced Nylon. The machine is designed as a production unit able to run 24 hr a day, 7 days a week, but is also a good fit for the laboratory environment.



Clean & Simple design



Easily removable infeed chute for thorough cleaning



Removable Discharge Chute & Push-Pull Bed Knife Gap Adjustment



SB 100 Shown

Standard Features:

Easy Access: No tools required to open the exterior cutting chamber cover.

Safety: A unique designed interlock system prevents ones ability to bypass the switch with a simple bolt or pen.

Cleanability: Our robust design is rugged and easy to clean.

Feed Table: This machine is supplied with removable feed table assembly.

Upper Feed roll: With a simple design, the upper roll remains parallel to the lower feed roll when multiple strands are being processed, resulting in a uniform pulling force on all strands

Pulling Force: Large pneumatic cylinder and upper roll design this unit out performs all others in its class.

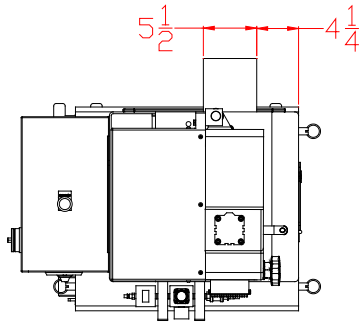
Pneumatic Cylinder: This cylinder is a large 2 1/2" bore and located on the cover for optimal pulling force and conveniently swings away for cleaning

Other Standards: Push-Pull bed knife adjustment • Eccentric mounted bearings for lower feed roll gap settings • four edge solid tungsten carbide bed knife • Stellite tipped rotor • special diamond knurled lower feed roll • Hypalon covered upper feed roll • AC variable frequency drive • stainless steel cutting chamber • aluminum cover assembly and aluminum top plate



Made in USA

Technical Data:



Product	Specific Gravity (gr/cm ³)	Throughput lb/hr/strand Based on 1/8" x 1/8" pellets		
Rotor cutting edges		14 Tooth	20 Tooth	36 Tooth
Std. Strand Velocity (FPM)		35 to 105	50 to 150	90 to 270
PP, PE	0.90	30	43	78
PA 11, PA 12	1.00	33	48	86
PA 6/6	1.15	38	55	99
PMMA, GPPS, ABS	1.05	35	50	90
ASA, HIPS, SAN	1.05	35	50	90
PUR	1.10	37	52	95
PET, PBT, PC	1.20	40	57	104
PET, PBT, PC, PA +15% to 50% Glass fill	1.30	43	62	N/A

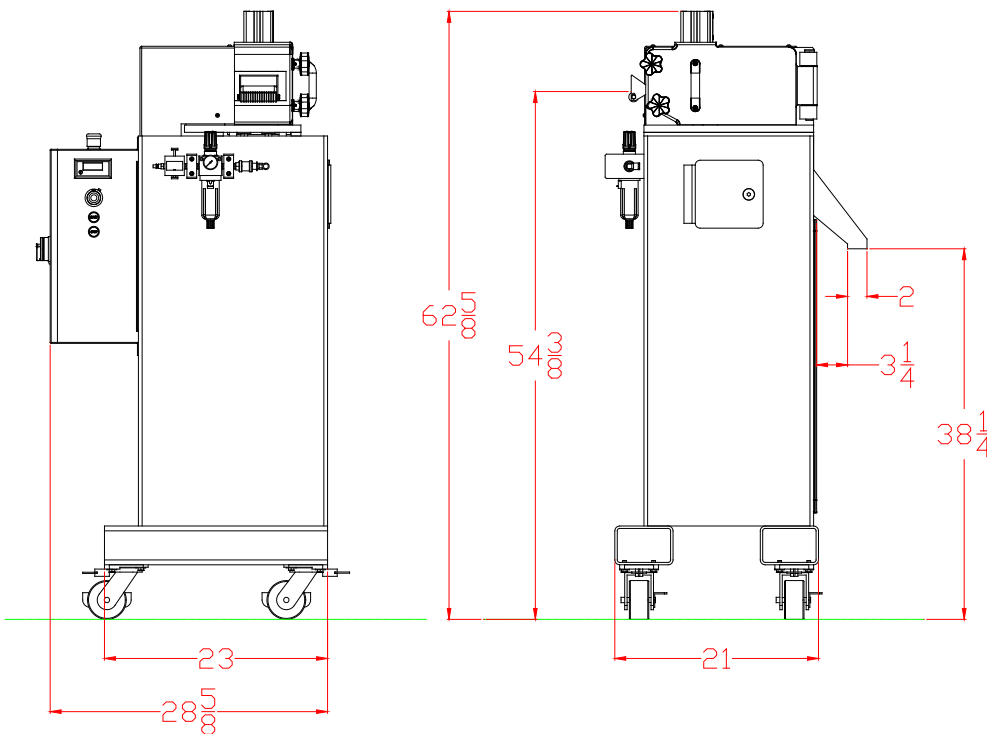
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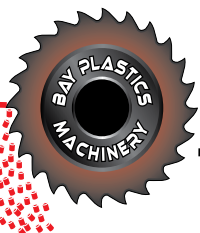
Visit us on the Web at
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Available Options

- 14 Blade Bolt On Type Rotor
- 20 Tooth Cemented Carbide Rotor
- Wear Package
- 36 Tooth Stellite Tipped Rotor
- Tool Steel Rotors
- Special Bed Knife Materials
- Dual Drive with Independent Control of Feedroll Speed and Rotor Speed
- Extra Horse Power
- Special Coverings on Upper Feedroll
- Special Surfaces and Coatings on Lower Feedroll
- Custom Heights
- Custom Discharge Chute Configurations
- Work Platforms
- Water Baths



	SB 100	SB 050
Rotor Diameter - Inch (mm)	6 (150)	6 (150)
Feed Opening - Inch (mm)	3-3/4 (95)	1-3/4 (45)
Motor Size - HP (kW)	2 (1-1/2)	2 (1-1/2)
Strand Capacity *	15	8
Drive	AC Variable Frequency	
* Based on 1/8 (3mm) diameter		



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XVAK SERIES VACUUM AIR KNIVES AVAILABLE IN 12" & 18" (300MM & 450MM)

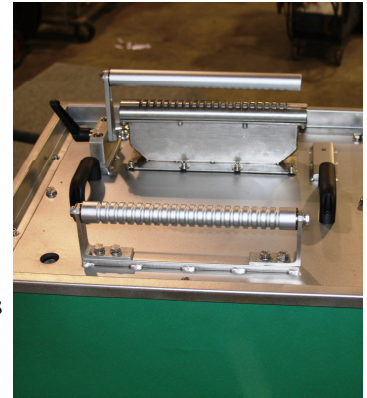


To get the best pellets, you need the driest strands. To get the driest strands, you need the XVAK Series Vacuum Air Knife.

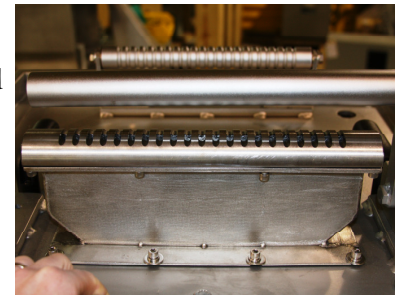
XVAK Series Vacuum Air Knife.

Unlike conventional air knives, which dry strands using pressurized air that could damage delicate strands, the XVAK strand dryer uses negative air pressure to eliminate residual water evenly and effectively. A vacuum comb on the dryer envelopes each strand in a vortex of air, drying all sides of the strand before the strand is pelletized. The water removed by the XVAK is contained within the unit's vacuum tank and discharged to a drain using a maintenance free check valve. Eliminating the safety hazards and the required house cleaning created by water spills, thus providing the safest work environment.

The XVAK uses a filter-free system to separate the vacuumed water from the air. This saves money on replacing and cleaning bothersome filters. The stainless steel construction of the XVAK strand dryer prevents water corrosion.



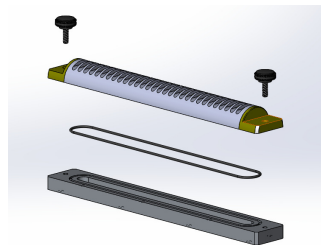
Strand guides &
Vacuum Comb



Available Options:



Sound Enclosure

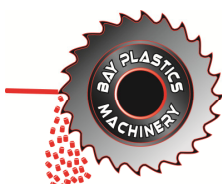


Quick Change Vacuum Head



Remote Mounted Vacuum Head

Model	A. Dim	Base H-D-W	No. strands	HP	CFM	VACUUM
XVAK-12	12"(300)	58"-26"-30"	30	5	262	35" H2O
XVAK-18	18"(450)	58"-32"-36"	50	6.2	365	35"H2O



Bay plastics machinery

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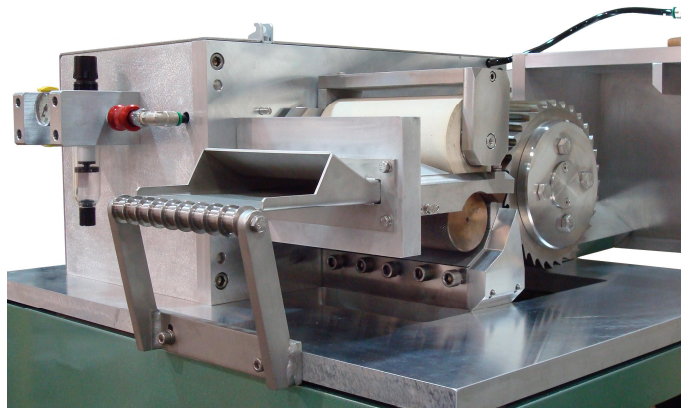
Z SERIES PELLETIZERS

Available in 4 & 8 inch

Rates from 500-2,500 lb/hr

The Z Series Pelletizers.

Are designed to be the most robust cantilever machines in the industry. BPM has made several key improvements to the old outdated designs, to improve reliability and cleanability of the new machines. Of these the most important is that we now support the bed knife holder on the reinforced Isolation Plate. This support under the bed knife holder makes the system more robust, and will eliminate the concerns that came with the old design. With the old design, after years of operation the support bolts stretched out and made it impossible to hold tight cutting gaps. This resulted in poor cuts and possible catastrophic damage to the cutting knives.

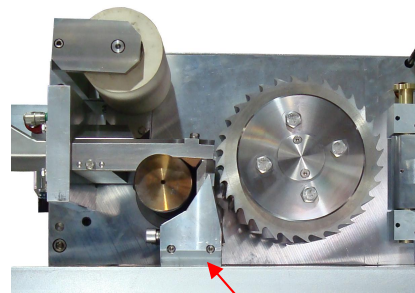


Key Benefits and Changes

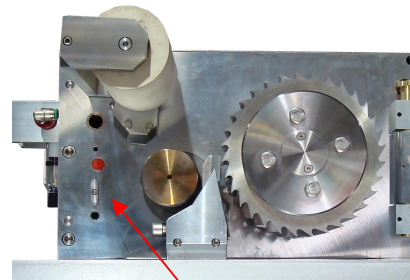
- **Supporting the Bed Knife Holder** on the Isolation Plate—This allows us to hold a tighter cutting gap. With the old hanging bed knife design, the gap would change as more load was applied to the system.
- **Truly Rust Free Cutting Chamber**—The competition uses tool steel components in certain material contact areas of the cutting chamber, causing contamination to the finished product.
- **Improved the Removable Feed Table Design**—The feed table is now suspended on a large diameter pin and a keyway has been added so that the Doctor blade gap can be set and held. The cutting Chamber cover applies pressure to the feed table to secure it in place.
- The diameter of the rotor Shaft has been increased to eliminate costly failures.
- The **spur change gears** have been eliminated and replaced with a quieter and maintenance free **serpentine belt** system.
- The lower feed roll is now an eccentric design so that the gap between the Doctor blade and the bed knife can be adjusted, eliminating a common contamination point.
- The Rotor Shaft (at the cutter) is now **chrome plated**, to eliminate galling. With the old design as the rotor shaft was damaged it would cause costly repair or replacement.
- **Removable Discharge Chute**—The discharge chute is now supported on tracks to aid in the removal of the chute. The operator must remove one bolt to completely clean the chute.



Removable Chute



Supported Bed Knife Holder



Removable Feed Table Design

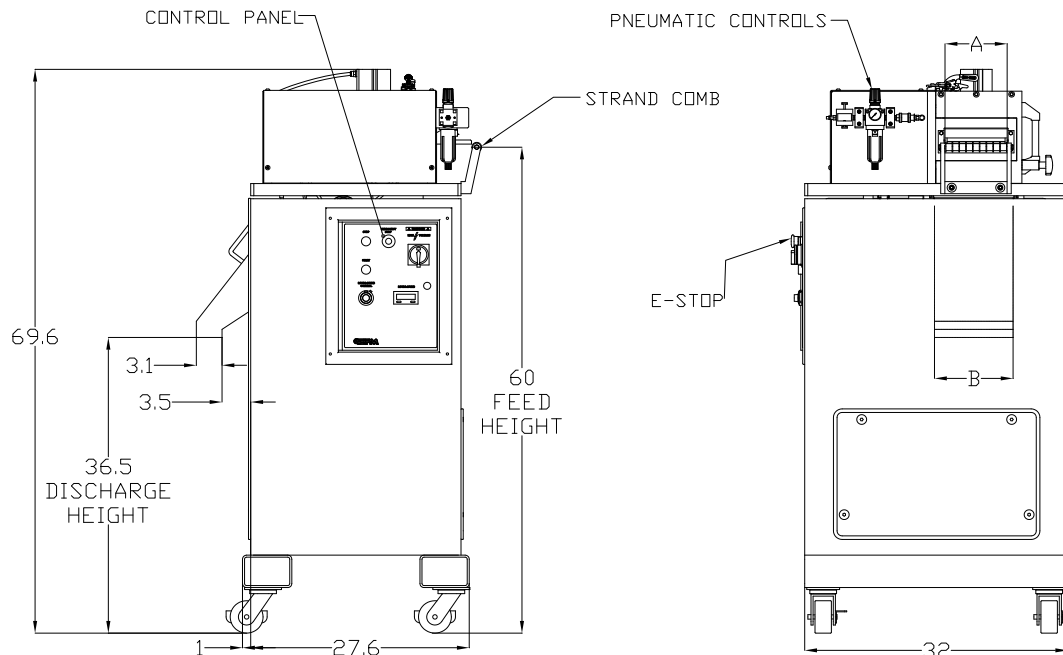
Technical Data:

Available Options

- 32 Blade Wedge Lock Rotor
- Up to 16 Blade Bolt On Type Rotor
- Wear Package
- Available in Various Tooth Stellite Tipped Rotor
- Tool Steel Rotors
- Special Bed Knife Materials
- Dual Drive with Independent Control of Feedroll Speed and Rotor Speed
- Additional Horse Power Motors
- Special Coverings on Upper Feedroll
- Special Surfaces and Coatings on Lower Feedroll
- Custom Heights
- Custom Discharge Chute Configurations
- Work Platforms
- Water Baths
- Vacuum Strand Dryers
- Pressure Air Knives
- Flash Off Conveyor

Other Features:

- **Safety:** The cover closures prevent the cover from being opened until all components are stopped. The safety interlock system is OSHA approved. There are no pinch points which can be reached with the cover in place.
- **Cleanability:** Our robust design is extremely rugged, and with the removable feed table, it offers our customers ease of cleaning and quick material change over's.
- **Repairable Stellite Rotors:** If the rotor tooth is damaged, bent or completely broken out, we can repair a single tooth or all of them. This is possible due to the proprietary welding process developed by Bay Plastics Machinery.
- **Other Standards:** Eccentric mounted bearings for lower feedroll gap settings, four edge solid tungsten carbide bed knife, 32 tooth Stellite tipped rotor, special diamond knurled lower feedroll, Hypalon covered upper feedroll, AC variable frequency drive



The Z Series Pelletizer		Z04	Z08
Strand Rating	1/8 in.	20	40
Std. Strand Speed	FPM	85-250	85-250
Motor Size (other sizes available upon request)	HP	5	10
Type of Drive	AC Variable Frequency Inverter		
Typical Throughput	80 LB/Strand (Based on 1/8” x 1/8” pellets @ 250 FPM)		
Dimensions			
A (Nominal Feed Width)	inches	4	8
B (Discharge Width)	inches	5	9
Base Width	inches	32	32
Weight (estimated)	Lbs	1,450	1,775
Power Requirement (Based on single drive and standard motor HP)	FLA	8.5 (5Hp)	15 (10Hp)



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WBX WATER BATHS

Available in various sizes

The WBX water cooling tanks are designed to meet the demanding requirements of your strand pelletizing line.

Constructed of stainless steel, these tanks are available in many different sizes to accommodate most extrusion applications.

Our rugged painted steel support frames are equipped with large diameter jack screws at each leg to adjust the height of the tank as needed. Having independent height control of each leg allows adjustments to be made for perfect level control.

These tanks include a side weir box with an easy cleanable screen. The standard weir box also allows the operator to control the water level in the tank via a sealed water gate design.

The hold down bars can be positioned along the entire length of the tank, and locked in place. The hold down bars are designed with a quick release system to ease start up. Simply loosen the locking lever and lift the entire bar assembly out of the lock down clamps. The rolls are grooved and designed to rotate (non-rotating design also available). The roll is a large 2" diameter and made from UHMWPE to eliminate corrosion and have low rotational resistance.

Our optional water recirculation systems are available to meet your specific requirements. These systems include a pump, heat exchangers, filter and starting electrics. To compensate for evaporation and spillage these units utilize an automatic water make up circuit to keep the tank full. There are several options available when it comes to heat exchangers, the standard is a sealed plate unit, however we can add a plate and frame or shell and tube unit upon request.



Hold down bar position lock



Quick Release hold down bars

Adjustable support legs

Water Make up valve





Small lab units
available



Available as long as necessary for customers application



Available with vari-
ous sizes of optional
water recirculation
systems



Optional—Liner Adjustment
moves full tank under die to ease
start up

WBX SIZES AVAILABLE

CUSTOM SIZES AVAILABLE UPON REQUEST

Model	W" x D" x L'	Hold Down Bars	Model	W" x D" x L'	Hold Down Bars
WBX 0606-6	6" x 6" x 6'	3	WBX 2012-10	20" x 12" x 10'	3
WBX 0606-15	6" x 6" x 15'	4	WBX 2012-15	20" x 12" x 15'	4
WBX 1008-10	10" x 8" x 10'	3	WBX 2012-20	20" x 12" x 20'	4
WBX 1008-15	10" x 8" x 15'	4	WBX 2012-25	20" x 12" x 25'	5
WBX 1008-20	10" x 8" x 20'	4	WBX 2012-30	20" x 12" x 30'	5
WBX 1008-25	10" x 8" x 25'	5	WBX 2412-10	24" x 12" x 10'	3
WBX 1210-10	12" x 10" x 10'	3	WBX 2412-15	24" x 12" x 15'	4
WBX 1210-15	12" x 10" x 15'	4	WBX 2412-20	24" x 12" x 20'	4
WBX 1210-20	12" x 10" x 20'	4	WBX 2412-25	24" x 12" x 25'	5
WBX 1210-25	12" x 10" x 25'	5	WBX 2412-30	24" x 12" x 30'	5
WBX 1512-10	15" x 12" x 10'	3	WBX 3012-10	30" x 12" x 10'	3
WBX 1512-15	15" x 12" x 15'	4	WBX 3012-15	30" x 12" x 15'	4
WBX 1512-20	15" x 12" x 20'	4	WBX 3012-20	30" x 12" x 20'	4
WBX 1512-25	15" x 12" x 25'	5	WBX 3012-25	30" x 12" x 25'	5
WBX 1512-30	15" x 12" x 30'	5	WBX 3012-30	30" x 12" x 30'	5



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