The CPM Extrusion Group has emerged as a global leader in the supply of twin- and multi-screw processing technologies. Process design-based engineering leads the development of our products from specialized screw geometries to complete compounding plants.

SERVICE & SUPPORT
The combined resources of the CPM Extrusion group result in a global service organization with sales, after-sales, and process labs in the USA, Germany and China.

REPLACEMENT PARTS
The CPM Extrusion group is home to the world’s most comprehensive line of twin screw replacement parts.

TWIN- & MULTI-SCREW PROCESS EQUIPMENT
Ranging from economical to highly engineered, the CPM Extrusion group offers the widest range of twin- and multi-screw extruders available.

PROCESS & APPLICATIONS TEAM
Through the installation of 3,900 compounding lines globally, our world-class process and applications team has unparalleled depth in twin- and multi-screw processing applications.
The CXE (Engineered Series) represents the industry benchmark for quality and reliability. CPM aims to provide the industry’s highest level of technology with the CXE.

The CXE is the most suitable product for you if you require:

- Reliability under extreme operating conditions
- Technical advantage through highly engineered/specialized design and configuration
- A highly customized machine design due to a unique operating environment
- Advanced process control and/or system integration

The CXE has found its place among globally leading producers with the most demanding requirements and is supported by a global network and the highest levels of CPM engineering and service resources.

Standard Geometry
The CXE series design incorporates the industry standard 1.55 D/o/Di ratio, allowing customers to take advantage of the Century Extrusion value proposition without shouldering the high costs of qualifying a new process section geometry.

Long-Term Reliability
Century Extrusion high speed/high torque gearbox was co-developed with one of the world leading suppliers of twin screw gearboxes. In addition to the highest power and safety factors available, the Century Extrusion gearbox offers a main bearing life of up to 50,000 hours.

Advanced Wear Materials From The CPM Extrusion Group
Century Extrusion has decades of experience developing industry-leading wear materials including high torque, cold rolled shafts, PM screw elements materials and tungsten carbide barrels. The CXE line offers these materials as a standard.

CXE Design Flexibility
The CXE series allows for a high level of user definition in the specification of:

- Process section metallurgy and configuration
- Power and torque
- Process control and automation
The APEX Series High Output at a Great Price...

The APEX Series includes both the CX and the RTX and is available in screw diameters ranging from 26 to 140mm. The APEX Series design was based on extensive feedback from key customers around the world and incorporates the following advanced features:

- **Advanced barrel design for high output processing**
  - Proprietary vented gate/cooling system for maximum wear and tear resistance.
  - 67% increase in barrel lengths to reject high output capacity.
  - High-density cast bronze feed barrel design for accurate temperature control and superior heat transfer.

- **Solid feeding technology designed for high output**
  - Designed for high output performance.
  - Screw speed up to 120 RPM.
  - Screw speed up to 120 RPM.

- **Special torque European gearbox and worm gear**
  - High torque gearbox and worm gear.
  - Screw speeds up to 120 RPM.

- **Key components are manufactured on CNC machines**
  - High-quality European gearboxes and worm gears.
  - High-quality European gearboxes and worm gears.

- **Safety standards and regulations comply with all global and local regulations**
  - Compliant with all global and local regulations.

- **Co-designed by Raval and Century screw geometry**
  - Compliant with all global and local regulations.

- **High wear resistance to maintain performance**
  - High wear resistance.

- **Raval Extension (RXL) is available**
  - RXL is available.

- **Raval Extension (RXR) is available**
  - RXR is available.

- **Raval Extension (RXK) is available**
  - RXK is available.

- **Raval Extension (RXB) is available**
  - RXB is available.

- **Raval Extension (RXU) is available**
  - RXU is available.

- **Raval Extension (RXL) is available**
  - RXL is available.

- **Raval Extension (RXR) is available**
  - RXR is available.

- **Raval Extension (RXK) is available**
  - RXK is available.

- **Raval Extension (RXB) is available**
  - RXB is available.

- **Raval Extension (RXU) is available**
  - RXU is available.

- **Raval Extension (RXL) is available**
  - RXL is available.

- **Raval Extension (RXR) is available**
  - RXR is available.

- **Raval Extension (RXK) is available**
  - RXK is available.

- **Raval Extension (RXB) is available**
  - RXB is available.

- **Raval Extension (RXU) is available**
  - RXU is available.

- **Raval Extension (RXL) is available**
  - RXL is available.

- **Raval Extension (RXR) is available**
  - RXR is available.

- **Raval Extension (RXK) is available**
  - RXK is available.

- **Raval Extension (RXB) is available**
  - RXB is available.

- **Raval Extension (RXU) is available**
  - RXU is available.

- **Raval Extension (RXL) is available**
  - RXL is available.
Because of its advanced features and economical price, the TSE series by Ruiya Extrusion is one of the most commonly used machines in China.

Through 20 years of development, the TSE has become an industry standard in China.

The TSE Series:

- Closed loop barrel cooling package
- Modular barrel configuration with individual heaters and control zones
- Vent ports for atmospheric venting
- Splined shafts
- Self-wiping segmented screws
- User-friendly analog or PLC control systems
- Integrated torque limiting system
- Proven and reliable gearbox
- Robust frame design
- Vacuum ports and vacuum systems
- Available with screw speeds of max 600 RPM
- Available sizes 20mm – 135mm

The TSE Plus Series:

The TSE Plus allows processors to obtain advanced performance within the TSE series. The TSE Plus offers higher output, higher torque and higher reliability than the TSE base models. The TSE Plus includes all of the features of the TSE and the following additional:

- European high torque gearbox with the industry’s highest safety factor, low noise and significantly longer working life.
- European high performance gearbox lubrication system
- European safety clutch for advanced mechanical protection
- Frame with increased rigidity and strength
- Barrels and shafts that are interchangeable with the TSE base models

RingExtruder RE®

The RingExtruder RE® technology opens up new innovative possibilities in terms of product quality, economic efficiency and flexibility. The special benefits of the RingExtruder RE® are derived from a reduced energy introduction and thus lower operating costs coupled with improved product quality and, simultaneously, especially good mixing and dispersion capability.

We supply machines and systems for the particularly gentle processing of products that are sensitive to shearing. The extraordinary degassing performance of the RingExtruder RE® has been shown, e.g. in the market success of PET bottle-to-bottle recycling.

The outstanding mixing capacity produces advantages with the continuous processing of rubber and India rubber products.

The company’s well-equipped technology center currently provides three extruders for customer trials. Practical extrusion trials with a throughput of up to 1 t/h and with various additional units can be carried out here.

Operating principle

The material is transported in conveying zones in the shape of a double helix, around the stationary core and around each screw. The process chamber in the transfer zone from screw to screw, often called the “intermeshing section”, is used as an imported part of the processing technology in the RingExtruder RE®.

Within the intermeshing section the dispersive mixing with a high share of elongational flow and in partially filled screws a surface renewal to improve degassing, takes place. Both effects form the basics for the advantages of process technology of the RingExtruder RE®

Degassing

The RingExtruder RE® provides a huge surface-to-volume ratio for the processed material. Increasing surface-to-volume ratio and a frequent passage of the intermeshing section between the screws is enhancing the degassing efficiency of the machine. With the introduction of the Z-technology, the RingExtruder RE® was taken even further to a high performance degassing machine.

The Z-technology allows defined gaps with different gap widths to be used for dispersion and degassing tasks. This combination of screw arrangement and screw design, which is only possible in the RingExtruder RE®, spreads the product in defined layers and then scraps it off and mixes it in again during the next half revolution.

Furthermore special degassing barrels with wide vent port openings or vent port stubbers are available.

- Continuous processing of rubber and rubber compounds
- Production of tire compounds
- Recycling of PET Flakes
- Compounding of highly filled polymers
- Production of masterbatch
- Reactive extrusion
- Processing of shear-sensitive products
- Demanding degassing tasks
- Food and pharmaceutical applications
High Performance Replacement Screw Elements

The CPM Extrusion Group Advanced Technology

- We have developed the most comprehensive line of replacement screw elements available today.
- Offering more than 80 materials, we are able to meet your most specific wear and corrosion requirements.
- We are continually developing new materials to help you decrease cost of ownership and downtime.

HPE Elements

We offer a selection of high performance elements. The right carefully selected HPE element, introduced into the process at the right point, is able to increase throughput and product quality in amasing ways.

- Higher mixing effect with lower energy input in general
- Higher degassing effect by higher surface regeneration
- And further advantages

T-Profile Screw T6

- Based on a non-symmetrically intermeshing profile.
- Only one tip of the profile scrapes the barrel surface.
- Each section is turned by 180 degrees so that a continuous tip is created.
- Positive conveying with improved surface renewal rate.
- T6 clearance.

T-Profile Screw T3

- Same non-symmetrically intermeshing profile as the T6.
- T3 clearance
- Higher degree of filling due to lower conveying efficiency.
- Improved mixing effect.

10V-12 Advantage

- 10V-12 was developed to offer the best cost per wear available today.
- 10V-12 has become the industry benchmark for high wear application.
- 10V-12 contains high levels of vanadium for excellent wear resistance as well as high levels of chromium for excellent corrosion resistance.
- 10V-12 is manufactured from powdered alloys utilizing HIPping technology. HIPped 10V-12 produces a homogeneous carbide distribution superior to conventional steels ensuring consistent wear throughout the part.
- We manufacture 10V-12 in-house in order to maintain tight control of quality, lead time, and cost.
- 10V-12 also utilizes a soft core to protect shaft splines and to ensure maximum transfer of torque.

ElementCapabilities

- Spline, hex, keyed
- Custom profiles
- High performance alloy steels selected to match specific applications
- Elements manufactured for more than 30 brands of twin screw extruders including:
  - Coperion/Werner & Pfleiderer
  - Berstorff
  - Clextral
  - Davis Standard
  - APV
  - And many more...

Materials

- 10V-12
- PM 8V and 10V
- 440C
- Nitrided
- W6Mo5Cr4V2
- 38CrMoAlA
- 000. 005. 112
- 068. 179. 4PH
- V35. V60
- S06. 48P85C

<table>
<thead>
<tr>
<th>Material</th>
<th>Alloy No.</th>
<th>RockwellHardness</th>
<th>Wear</th>
<th>Corrosion</th>
</tr>
</thead>
<tbody>
<tr>
<td>10V-12</td>
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<td>57–62</td>
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<tr>
<td>PM 8V</td>
<td>10</td>
<td>60–62</td>
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<td></td>
</tr>
<tr>
<td>440C</td>
<td>21</td>
<td>58–58</td>
<td></td>
<td></td>
</tr>
<tr>
<td>PM 8V</td>
<td>91</td>
<td>53–56</td>
<td></td>
<td></td>
</tr>
<tr>
<td>D2</td>
<td>21</td>
<td>58–58</td>
<td></td>
<td></td>
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<tr>
<td>Nitraloy</td>
<td>00</td>
<td>64–72</td>
<td></td>
<td></td>
</tr>
<tr>
<td>440C</td>
<td>41</td>
<td>53–56</td>
<td></td>
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</tr>
</tbody>
</table>
High Performance Replacement Screw Shafts

The CPM Extrusion Group Advanced Technology
- We have responded effectively and consistently to the expanding needs for high torque, high speed extrusion products.
- The CPM Extrusion Group is a leader in high torque, rolled shaft technology producing shafts that can withstand significant increases in load, torque, and temperature.
- Working with leading materials suppliers, we have developed materials with the highest torque capacity and hardness properties to manufacture superior extruder shafts.

The Cold-Formed Advantage
- Cold-formed shafts have improved surface finish that increases fatigue life.
- Dimensional stability with respect to required tolerances is greatly enhanced with the cold-forming process. A single tool setting is used during manufacturing which diminishes spline variation ensuring a perfect shaft element fit.
- The cold-forming process generates compressive stress within the spline form. Materials in compression will not crack, whereas materials in tension will elongate and eventually fail.

Coatings for extreme environments
- Surface treatments to aid in corrosion resistance
- Surface treatments to assist in the easy assembly of elements

Shaft Capabilities
- Spline, hex, keyed
- High Performance alloy steels selected to match specific applications
- Configurations for most major twin screw manufacturers including:
  - Coperon/Werner and Pfleiderer
  - Berstorff
  - Clextral
  - Davis Standard
  - APV
  - And many more...

Materials
- H-11
- H-13
- M300
- 17-4 Ph
- 4340
- 40CrNiMoA
- 125-01
- 143-01
- 143-33
- 454-01

Shafts Testing and Results
- In a controlled environment, we conducted comparative tests of the cold-formed shaft and the competitive shaft on the market.
- Subjecting both shafts to uniform unidirectional torison load cycles, these tests measured the fatigue life of each shaft at elevated temperatures.
- We rolled shafts outperformed the highest-rated shaft on the market by 26%. See these outstanding results in the plot below.

<table>
<thead>
<tr>
<th>Number of Cycles</th>
<th>Rotational Change in Degrees</th>
</tr>
</thead>
<tbody>
<tr>
<td>10,000</td>
<td>0.0</td>
</tr>
<tr>
<td>20,000</td>
<td>0.2</td>
</tr>
<tr>
<td>30,000</td>
<td>0.4</td>
</tr>
<tr>
<td>40,000</td>
<td>Maximum Allowable Twist Line</td>
</tr>
<tr>
<td>50,000</td>
<td>Competitive Shaft @ 43-45 HRC Fails at 32,000 Cycles</td>
</tr>
</tbody>
</table>

Our Shafts @ 42 HRC Exceed 40,000 Cycles

The CPM Extrusion Group Advantage
High Performance Replacement Barrels

Advanced Wear Solutions

We deliver productivity through the best wear solutions available today. In support of our commitment, the CPM Extrusion Group places a very high priority on the development of advanced materials of construction and the continuous improvement of our manufacturing processes.

Tungsten Carbide Barrels

The Tungsten Carbide barrel is the perfect illustration of our commitment to providing the best “cool per wear” solutions available. Our design offers these benefits:

- High carbide content for excellent abrasive wear resistance
- High nickel content for corrosive wear resistance
- Correct OEM apex dimensions
- Excellent bond strength between carbide layer and base materials to ensure adhesion of wear surface and robust apex
- Wear surface free of cracks and pits

Seamless, 4.5mm average thickness, crack-free wear surface, heavily loaded with 65% tungsten carbide in a nickel matrix for maximum wear and corrosion resistance

Geometrically correct apex dimension provides optimal design performance

Twice the bond strength and twice the wear depth as cladded coatings

Four-quadrant cooling

High toughness for excellent impact resistance

The industry’s most highly-loaded, HiPPed, tungsten carbide barrel

Selection and Experience

The CPM Extrusion Group has the widest barrel offering in the industry. To date, we have manufactured replacement parts for 30 different brands of twin screw extruders. No other supplier can match CPM’s experience in part design, wear and process application.

In addition to providing high performance replacement barrels for the CPM Extrusion Group brand of twin screw extruders, we also manufacture barrels ranging from 18mm to 180mm for most major brands of twin screw extruders, including:

- CoperionWerner & Pfleiderer
- Berstoff
- Davis Standard
- Leistritz
- Butler
- Clextral
- APV/Baker Perkins
- B&P Process Equipment
- Entek
- Toshiba

HiPPed Barrels for Extreme Wear and Corrosion Applications

The HiPPed Barrels offer optimum performance for extreme wear and corrosion applications. In addition, the HiPPed Barrels offer these benefits:

- Tailored material chemistry to ensure the best mix of corrosion and wear resistance
- Seamless surface and excellent bond strength eliminate delamination and “chunking” of the wear surface (problems inherent to other wear solutions)

<table>
<thead>
<tr>
<th>Material</th>
<th>Alloy No.</th>
<th>Rockwell Hardness</th>
<th>Wear</th>
<th>Corrosion</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tungsten Carbide/Nickel</td>
<td>77</td>
<td>62-68</td>
<td></td>
<td></td>
</tr>
<tr>
<td>PM 15V</td>
<td>17</td>
<td>59-61</td>
<td></td>
<td></td>
</tr>
<tr>
<td>PM 19V</td>
<td>10</td>
<td>60-62</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RXT101</td>
<td></td>
<td>60-62</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Chrome Cast Iron</td>
<td>90</td>
<td>57-62</td>
<td></td>
<td></td>
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<tr>
<td>D2</td>
<td>21</td>
<td>56-58</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Nitraloy</td>
<td>80</td>
<td>64-72</td>
<td></td>
<td></td>
</tr>
<tr>
<td>440C</td>
<td>41</td>
<td>53-58</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Improve Your Barrel Wear

The CPM Extrusion Group has developed replacement barrels for machines ranging from 18mm to 180mm in diameter. Our offering includes parts for all configurations including:

- Round • Rectangular • Flanged • Non-Flanged • Clamshell • Designs for special applications

Accessories

The CPM Extrusion Group also offers a wide variety of barrel accessories including:

- Barrel fastener kits • Vent ports • Vent plugs • Vent stacks • Barrel spacers • Injection port adapters
A complete line of feeders and pelletizers

Feeder types
- Side feeders
- Volumetric ingredient feeders
- Loss in weight feeders
- Cramming feeders
- Liquid feeders

Pelletizer types
- Strand pelletizers
- Water ring cutters
- Underwater pelletizers
- Die face cutters

Modular Compounding Systems

Modular compounding systems by CPM represent “the next level” of competitive advantage for leading compounders, allowing them to respond quickly to their customer’s changing environments.

Modular systems by CPM incorporate key unit machines and controls into a self-contained, pre-tested unit.

Modular systems offer the following key benefits:
- A significant reduction in total project cost (up to 25%)
- Less risk of budget overruns
- Single supply relationship
- Reduction in performance risk (all systems are pre-tested)
- Construction/installation time reduced by 70%
- The ability to quickly deploy, re-deploy or move compounding assets from one location to another

Systems & Services

Complete Compounding systems
- Significant experience providing complete compounding lines and systems
- With excellent design, project engineering, manufacturing and field service resources in USA, Germany and China, the CPM Extrusion Group is the parallel supplier for you.

Process Consulting
Engineering Services
Screw Design and Process Simulation
Wear Analysis
Monthly Webinar and Software

LOCAL SERVICE GLOBAL REACH
## Product Series Comparison

<table>
<thead>
<tr>
<th>Gearbox</th>
<th>TSE</th>
<th>TSE Plus</th>
<th>APEX RXT</th>
<th>APEX CX</th>
<th>CXE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety Clutch</td>
<td>Rulya</td>
<td>European</td>
<td>European</td>
<td>European</td>
<td>European</td>
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<tr>
<td>Shaft Processing Method</td>
<td>Rulya 40CrNiMoA</td>
<td>Rulya 40CrNiMoA</td>
<td>H11 or H13</td>
<td>CPM High Strength Tool Steel</td>
<td>CPM High Strength Tool Steel</td>
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<tr>
<td>Screw Materials</td>
<td>Rulya</td>
<td>W6Mo5CrV2</td>
<td>W6Mo5CrV2</td>
<td>CPM Proprietary 10V-12 PM</td>
<td>CPM Proprietary 10V-12 PM</td>
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<tr>
<td>Liner Materials</td>
<td>Rulya a101 Liner</td>
<td>Rulya a101 Liner</td>
<td>Hipped RX 101</td>
<td>CPM Proprietary CX77</td>
<td>CPM Proprietary CX77</td>
</tr>
</tbody>
</table>

**TSE Series** - Advanced features at an economical price. The TSE series represents the standard for entry level machines in China. It is our most economical solution. All components are sourced from top Chinese and global suppliers.

**TSE Plus** - Higher performance within the TSE Series. The TSE Plus includes all of the features of the TSE base models with the following additional features:
- Higher output and torque
- European gearbox, lubrication system and safety clutch
- Stronger, more rigid frame

**APEX Series** - The highest level of output and quality at a very competitive price...without sacrifice.

**APEX RXT Features:**
- Geometry based on both Chinese and Western Standards
- A European high torque gearbox, lubrication system and safety clutch
- High performance shafts and screw elements
- An advanced barrel design to ensure proper cooling capacity and to allow for a much thicker/stronger wear liner.
- High performance HiP barrel liners manufactured in China

**APEX CX Includes all of the features of the RXT and:**
- Geometry based on Western standards
- Higher torque gearbox with higher safety factor
- Maximum screw speeds of 1200 RPM
- Tungsten Carbide lined CX 77 barrels manufactured by Century Extrusion in the USA

**CXE Engineered Series** - Designed and built by Century Extrusion in the USA. It represents the top level of quality and performance from the CPM Extrusion group. All components are manufactured in the USA and Europe. It employs the center distance and standards commonly used in Europe and America. The CXE series offers:
- The highest level of quality and reliability
- The highest level of customer definition
- The highest level of components
- The highest level of design specialization screw speeds of 1200 RPM

## Technical Data

<table>
<thead>
<tr>
<th>Model</th>
<th>D (mm)</th>
<th>Central Distance (cm)</th>
<th>Max L/D</th>
<th>RPM (r/min)</th>
<th>Torque (N/m)</th>
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<tbody>
<tr>
<td>CXE CX 30</td>
<td>25</td>
<td>2.11</td>
<td>72</td>
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<tr>
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<td>CXE CX 40</td>
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<td>CXE CX 50</td>
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<td>72</td>
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<td>CXE CX 70</td>
<td>70</td>
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<td>72</td>
<td>1200</td>
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<td>1000</td>
<td>3600</td>
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* This power and torque data is for CXE / CX HO series.

<table>
<thead>
<tr>
<th>Model</th>
<th>D (mm)</th>
<th>Central Distance (cm)</th>
<th>Max L/D</th>
<th>RPM (r/min)</th>
<th>Max Power (kw)</th>
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<tbody>
<tr>
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<td>900</td>
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<td>900</td>
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<td>RXT 125</td>
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<th>RPM (r/min)</th>
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* When operating in excess of 1500 RPM, the maximum torque per screw shaft should be monitored such that the maximum torque density is less than 17N/m/cm3.