Twin-Shaft Batch Mixer

DKX
The benchmark in mixing technology

Efficient . Reliable . High Performance

BHS SONTHOFEN
All depends on the right mixing technique!
The BHS mixing technique has a significant and rapid effect towards producing a high-quality mixture which increases production efficiency and economic value. The BHS twin-shaft mixing technology offers numerous comprehensive advantages.

Always a reliable mixing result
With the well-engineered design and alignment of the mixing tools, our customers achieve a batch-by-batch consistent high level of homogeneous mixture at short mixing cycles.

Robust construction and maintenance-friendly
BHS mixers are robust, durable and designed for longevity. BHS also includes convenient access for machine maintenance.

Comprehensive modular system
BHS has a wide range of mixing sizes and configurations. Our comprehensive modular systems can be custom designed and manufactured for all our Twin-Shaft mixers to include designs to meet your specific requirements.

BHS world-wide service
We offer our customers fast and reliable service world-wide and are pleased to assist your project needs at anytime. We also stock all mixer components and wear parts for quick delivery from our parts department, world-wide.

Over 120 years of experience
The first Twin-Shaft Mixer was designed and manufactured by BHS-Sonthofen, Germany, in 1888 and has been continuously developed ever since. Our customers profit from our years of experience and technical knowledge which is integrated into all BHS products. BHS is the technical market leader in twin-shaft mixing technology.
Approved thousand of times ...worldwide!

www.bhs-sonthofen.com
State-of-the-Art: Three dimensional mixing

**Operating principle**

- A circular three-dimensional pattern is generated for rapid mixture of batch ingredients
- Intensive material exchange in the turbulent overlap area of the two mixing circles
- Energy input is optimized through intensive relative movements of the mixture
- Rapid movement of all materials throughout the mixer during the entire mixing process

**BHS spiral mixing tools**

- Mixing tools are arranged to create an uninterrupted spiral for each mixing shaft
- Mixing shafts rotate in opposite directions in the longitudinal center of the mixer. This creates an overlap area of the mixing tools.
- Counter shovels are located on the ends of both shafts
- Mixing tools operate at a precise and gentle mixing speed

Functional principle: Spiral mixing tools

Functional principle: Mixture movement and center overlap area
Three-Dimensional . Rapid . Homogeneous

Result: Quality and economic efficiency

Consistent high level homogeneous mixture within rapid mix cycles

- Homogeneous mixture levels of 95% are achievable within 30 seconds
- Batch after batch our mixers produce high level uniform and homogeneous mixtures
- BHS Mixing techniques preserve the grain structure of the individual recipe components

High energy efficiency

- High mixture performance is achieved at low speeds
- Reduced energy consumption due to short mixing cycles, effectiveness of mixing tools and efficiency of drive units

Low-wear

- Minimal wear of mixing tools and trough liners achieved from lower mixing speeds and mixer compact design
- Reduced wear to internal mixer surfaces in relation to mixture volume
- All wear parts have been optimized and designed for longevity

Efficient concrete production

- Rapid and optimal bonding of cementitious particles
- Potential of reducing cement content due to uniform and consistent mixture of all particles
- Consistent and rapid distribution of admixtures and additives throughout the entire mixture volume
- Batch to batch consistency for all mix designs
- Minimum batch filling levels of 10% are possible
- Guaranteed to mix special concrete recipes (SCC, RCC, UHPC, etc.)
- Hybrid mixing cycles are possible (slow-fast-slow)

Development of homogenized mixture during the actual mixing process

The graphics below illustrates in a realistic simulation the development of the homogeneous mixture during the rapid mixing process. This is exclusive in a BHS twin-shaft batch mixer.
Experience and expertise

Application-oriented mixer configuration

With over 120 years of experience in mixing technology BHS has the required expertise to provide the optimal solution for all your specific requirements. Depending on the application we also offer in addition to our standard configurations, numerous options to customize your twin-shaft batch mixer.

Drive performance
Our twin-shaft batch mixer can be designed with different drive configurations depending on the maximum torque requirements.

Speed
Our twin-shaft batch mixer can be equipped with optional speed configurations with pole-changing drive or with variable frequency drive units.

Feeding
The location of the material inlet openings and sequence of charging the mixer influence the mixing efficiency and mixing times. BHS has the knowledge and the answers for optimal mixer charging.

BHS mixing test facility

At BHS manufacturing facilities, we operate mixing pilot plant stations. For questions relating to mixing processes we perform flexible and versatile mixing tests for our customers. Machine parameters can be varied to determine optimal settings, and recipe volumes can be precisely measured for accurate mix design testing.

Our numerous DKX products available

Our comprehensive range of high performance twin-shaft batch mixers provides long-term solutions for almost all industry related applications. You will benefit from our expertise and the many mixing applications available:

**DKX:** Suitable for almost all types of applications (building materials and other sectors). Modern concrete recipes with high levels of additives, f.i. SCC, UHPC or RCC, can also be reliably produced.

**DKXS:** Production of ready-mix concrete in all consistencies and with consistent high quality.

**DKXN:** Optimized solution particularly for the production of high-slump ready-mixed concrete.

**DKXD:** Specially designed and configured for dam construction, designed for robust course aggregates.

**DKXA:** Specially designed for maximum performance in asphalt production and high temperatures.

**DKXF:** Production of pourable dry fine particle mixtures, equipped with large discharge doors and special positive seal for residue-drip free discharge.

**DKXG:** Production of granular dry and wet mixtures, equipped with large discharge doors for residue-free discharge.

**DKXC:** Production of continuous mixing processes with controllable mixing cycles.

Let our experienced specialists assist you towards sizing the correct mixer for your specific application.
Extensive experience with demanding concrete recipes

Even with increasing diversity of recipes, our many available twin-shaft batch mixers is a long-term solution for the production of homogeneous concrete mixtures. When producing specialty mixtures (fine grain, SCC, UHPC, RCC, colored concrete, fiber additives, light weight, etc) you can rely on our comprehensive experience.

Quality concrete
Aggregate size: 0-1.3 in (0-32 mm)

Steel fibre concrete
Aggregate size: 0-0.63 in (0-16 mm)

Colored concrete
Aggregate size: 0-1.3 in (0-32 mm)

Self-compacting concrete
Aggregate size: 0-0.63 in (0-16 mm)

Competent partner for mixing plant manufacturers

We are a reliable and competent supplier for various RMC plant manufactures. We have thousands of BHS mixers in use, worldwide; with numerous types of plants. Our mixers are in operation day after day and year after year, they perform to the complete satisfaction of the end user.

Perfect mobility and flexibility with BHS containerized concrete batching plant
Robust and reliable drive technology designed for performance, operational safety, energy efficiency and longevity.

1 Gear box
The worm gears are specially designed for our twin-shaft batch mixer. They offer high efficiency and ensure long service life – even for extreme loads. The gear boxes are placed on the mixing shaft without a fixed connection to the mixing trough.

2 Electric motor
We exclusively use high-quality motors for our twin-shaft batch mixers. They have been specially designed for the mixing load cycles.

3 V-Belt drive unit
The power transmission is equipped with a reliable V-belt drive system. The V-belts are located on the outer side of the drive unit for easy accessibility for maintenance.

4 Torque support
The adjustable torque support is used for the adjustment of the gear boxes. This allows a free suspension of the drive in order to prevent impulsive impacts within the gear system.

5 Synchronous coupling
To achieve synchronization between both mixing shafts a low-maintenance elastic coupling is utilized between the gear box units.

6 Shaft sealing and shaft bearing
The mixer shafts are sealed with reliable axial face seals. The shaft bearings are separated from the shaft sealing, which allows for easy accessibility for maintenance and servicing.

7 Fluid coupling (optional)
The hydrodynamic fluid coupling prevents mechanical as well as electrical load peaks. It is recommended in particular for critical electricity supply conditions.
Spiral mixing tools: Precondition for a homogeneous mixture

8 High-quality hexagonal shaft with high torsional and bending strength
9 Streamlined mixing arms made of special cast iron
10 Arrangement of the mixing arms in a spiral shape
11 Easily adjustable mixing shovels

Suitable mixing tools for all types of mixtures

Universal mixing tools with 60° arm position for the production of ready-mixed concrete, precast concrete, specialty concretes and many other mixtures.

Coarse grain mixing tools with 60° arm position for the production of concrete for dam construction; depending on the mixer size they can be used for aggregates up to 7 in (180 mm).

Smooth mixing tools for the production of dry materials, dry mortar or concrete blocks. The smooth design of the mixing tools and shafts reduces caking to a minimum even when working with highly adhesive mixtures.

Duplex mixing tools for the production of dry and wet mixtures with a high degree of fine aggregates. Doubling the mixing arms greatly increases the shearing forces in the mixture.

Mixer Wear Liners: Innovative solutions for longevity

Rhombus tiles: Patented rhomb (diamond) shaped tiles with a material thickness of ¾ in (19 mm) optimized with cast chromium steel is used for the mixing trough lining. These exclusive BHS design increases the service-life by 30% in comparison to other square shaped tiles.

Lateral wall Liners: The lateral walls are lined with optimized cast chromium steel plates.

OPTILONG tiles: For higher levels of wear we offer rhombus shaped tiles with a material thickness of 1 inch (28 mm). Different material hardness of the specific tiling rows will ensure an even wear across all wear zones. The lifetime can be almost doubled compared to standard tile thickness.
Discharging and lubrication

Mixer Discharging: Leading solutions for emptying the mixer

Benefits of the rotary discharging gate
- Massive and robust cast iron design
- Centrally located between both mixer shafts
- Effective sealing using adjustable ledges
- Exact control of material discharge rates
- Reliable operation using pneumatic or hydraulic cylinders

Discharge rotary gate options
- Rotary gate in standard size, suitable for most applications
- Rotary gate in larger design for faster emptying
- Split design of the rotary gate for alternate emptying at two discharge points

Discharge door
- Discharge door for residue-free discharge – in particular for applications in the cement, dry mortar, precast and disposal industries

Lubrication systems: For an optimal and reliable lubrication supply

Central lubrication system
The central lubrication system continuously supplies the inner mixing trough seals with grease during the mixing operation. Manual lubrication of the seals is only necessary after each mixer cleaning.

Impulse controlled central lubrication system
The central lubrication system supplies the inner mixing trough seals with grease. The lubrication system is activated by a control panel with continuously variable grease proportioner.

Fully automatic central lubrication system
Using a PLC-control and a progressive plunger metering devices the lubrication points of the four inner mixing trough seals (optionally also for the other lubrication points of the mixer) are automatically supplied with grease. After the cleaning of the mixer only the grease pump has to be actuated via the control system.
Optional machine components

Moisture measurement and temperature measurement
For a moisture or a temperature measurement of the mixture our twin-shaft batch mixer can be equipped with probes from all notable manufacturers.

Sampling
Our twin-shaft batch mixer can be equipped with a device for taking mixture samples.

Electrical terminal box
Electrical cables can be centrally terminated into a factory supplied junction box for easy installation.

Maintenance stairs or maintenance mobile platform
For easy accessibility for cleaning and maintenance, the twin-shaft batch mixers can be supplied with maintenance stairs or mobile platforms.
**Mixer cover**

The dustproof mixer cover for our twin-shaft batch mixer is equipped with oversized access doors with industrial gas shocks for easy and safe access.

**Water feeding**

Depending on the application, the water can be introduced into the mixer on a baffle plate or a water spray pipe manifold (gravity or pressurized). The water manifold system with nozzles can be utilized with pressurized fresh or recycled water.

**High pressure cleaning**

Our approved high pressure cleaning system has been designed with three-dimensionally rotating nozzle heads. It is characterized by excellent cleaning results and reduced water consumption. For cleaning the discharge hopper an additional circular pipeline system can be added to the high pressure cleaning system. For batching plants, equipped with two mixers, only one pressure unit is required for a two-way cleaning of both mixers.
Skip hoist

For fast and clean charging of the mixer with aggregates, we offer custom-made, robust skip hoists as tilting bucket or bottom emptying units.

Laboratory mixer

For your concrete laboratory we provide our twin-shaft batch mixer in a version with roughly 16 Gal (60 liter) compacted concrete output/batch. The complete mixer has been reduced in size to scale for meaningful test results.

Combinix

With our patented Combimix system the BHS twin-shaft batch mixer becomes a continuously operating mixer with proven twin-shaft technology and controllable mixing time. Output improvements up to 60% are possible in comparison to batch operations.
### Performance data

<table>
<thead>
<tr>
<th>Type</th>
<th>Dry charge, aggregates and binder</th>
<th>Compacted concrete per batch</th>
<th>Compacted concrete output with truck mixer discharge</th>
<th>Drive system (ready-mixed concrete)</th>
<th>Maximum agg. Ready-mixed concrete</th>
</tr>
</thead>
<tbody>
<tr>
<td>DKX 0.50</td>
<td>1.0 yd³ 0.75 m³ 0.5 m³</td>
<td>0.7 yd³</td>
<td>73 cycles/h</td>
<td>48 yd³/h</td>
<td>48 yd³/h</td>
</tr>
<tr>
<td>DKX 0.75</td>
<td>1.5 yd³ 1.13 m³ 0.75 m³</td>
<td>1.0 yd³</td>
<td>65 cycles/h</td>
<td>64 yd³/h</td>
<td>64 yd³/h</td>
</tr>
<tr>
<td>DKX 1.00</td>
<td>2.0 yd³ 1.5 m³ 1.0 m³</td>
<td>1.3 yd³</td>
<td>58 cycles/h</td>
<td>76 yd³/h</td>
<td>78 yd³/h</td>
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<tr>
<td>DKX 1.25</td>
<td>2.5 yd³ 1.88 m³ 1.25 m³</td>
<td>1.6 yd³</td>
<td>53 cycles/h</td>
<td>86 yd³/h</td>
<td>86 yd³/h</td>
</tr>
<tr>
<td>DKX 1.67</td>
<td>3.3 yd³ 2.2 m³ 1.67 m³</td>
<td>2.2 yd³</td>
<td>48 cycles/h</td>
<td>105 yd³/h</td>
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<tr>
<td>DKX 2.00</td>
<td>4.0 yd³ 2.51 m³ 2.0 m³</td>
<td>2.6 yd³</td>
<td>49 cycles/h</td>
<td>128 yd³/h</td>
<td>139 yd³/h</td>
</tr>
<tr>
<td>DKX 2.25</td>
<td>4.5 yd³ 3.38 m³ 3.0 m³</td>
<td>3.0 yd³</td>
<td>46 cycles/h</td>
<td>136 yd³/h</td>
<td>148 yd³/h</td>
</tr>
<tr>
<td>DKX 2.50</td>
<td>5.0 yd³ 3.75 m³ 2.5 m³</td>
<td>3.3 yd³</td>
<td>48 cycles/h</td>
<td>157 yd³/h</td>
<td>183 yd³/h</td>
</tr>
<tr>
<td>DKX 2.75</td>
<td>5.4 yd³ 4.13 m³ 2.75 m³</td>
<td>3.6 yd³</td>
<td>46 cycles/h</td>
<td>166 yd³/h</td>
<td>198 yd³/h</td>
</tr>
<tr>
<td>DKX 3.00</td>
<td>6.0 yd³ 4.5 m³ 3.0 m³</td>
<td>4.0 yd³</td>
<td>44 cycles/h</td>
<td>173 yd³/h</td>
<td>208 yd³/h</td>
</tr>
<tr>
<td>DKX 3.33</td>
<td>6.5 yd³ 5.0 m³ 3.33 m³</td>
<td>4.4 yd³</td>
<td>41 cycles/h</td>
<td>179 yd³/h</td>
<td>218 yd³/h</td>
</tr>
<tr>
<td>DKX 3.50</td>
<td>6.9 yd³ 5.25 m³ 3.5 m³</td>
<td>4.6 yd³</td>
<td>42 cycles/h</td>
<td>192 yd³/h</td>
<td>238 yd³/h</td>
</tr>
<tr>
<td>DKX 4.00</td>
<td>7.9 yd³ 6.0 m³ 4.0 m³</td>
<td>5.2 yd³</td>
<td>39 cycles/h</td>
<td>204 yd³/h</td>
<td>256 yd³/h</td>
</tr>
<tr>
<td>DKX 4.50</td>
<td>9.0 yd³ 6.75 m³ 4.5 m³</td>
<td>6.0 yd³</td>
<td>37 cycles/h</td>
<td>218 yd³/h</td>
<td>301 yd³/h</td>
</tr>
<tr>
<td>DKX 5.00</td>
<td>10.0 yd³ 7.5 m³ 5.0 m³</td>
<td>6.5 yd³</td>
<td>35 cycles/h</td>
<td>229 yd³/h</td>
<td>327 yd³/h</td>
</tr>
<tr>
<td>DKX 6.00</td>
<td>12.0 yd³ 9.0 m³ 6.0 m³</td>
<td>8.0 yd³</td>
<td>31 cycles/h</td>
<td>243 yd³/h</td>
<td>377 yd³/h</td>
</tr>
<tr>
<td>DKX 7.00</td>
<td>13.7 yd³ 10.5 m³ 7.0 m³</td>
<td>9.2 yd³</td>
<td>28 cycles/h</td>
<td>256 yd³/h</td>
<td>403 yd³/h</td>
</tr>
<tr>
<td>DKX 8.00</td>
<td>15.7 yd³ 12.0 m³ 8.0 m³</td>
<td>10.5 yd³</td>
<td>26 cycles/h</td>
<td>272 yd³/h</td>
<td>450 yd³/h</td>
</tr>
<tr>
<td>DKX 9.00</td>
<td>17.7 yd³ 13.5 m³ 9.0 m³</td>
<td>12.0 yd³</td>
<td>24 cycles/h</td>
<td>283 yd³/h</td>
<td>506 yd³/h</td>
</tr>
</tbody>
</table>

1) 30 sec. mixing time, truck mixer input rate of 0.16 yd³/s (0.12 m³/s) and compactability rate of 1.15
2) 30 sec. mixing time, compactability rate of 1.45

Different drive power data for hp and kW relate to country-specific drive systems.
Drive systems for other applications are possible, please ask us.

Performance data for other mixing applications available on request.

Technical data may change due to technical progress.
Subject to modification without notice.
### Technical data DKX

#### Dimensions and weights

<table>
<thead>
<tr>
<th>Aggregate sizes</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hydrodam concrete</td>
<td>90.9 in</td>
<td>50.2 in</td>
<td>65.2 in</td>
<td>61.0 in</td>
<td>57.9 in</td>
<td>39.4 in</td>
<td>6800 lb</td>
</tr>
<tr>
<td></td>
<td>2310 mm</td>
<td>1275 mm</td>
<td>1655 mm</td>
<td>1550 mm</td>
<td>1470 mm</td>
<td>1000 mm</td>
<td>3100 kg</td>
</tr>
<tr>
<td>0-3 in</td>
<td>100.0 in</td>
<td>59.1 in</td>
<td>74.0 in</td>
<td>61.0 in</td>
<td>57.9 in</td>
<td>39.4 in</td>
<td>8000 lb</td>
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<td>1500 mm</td>
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<td>1470 mm</td>
<td>1000 mm</td>
<td>3600 kg</td>
</tr>
<tr>
<td>0-5 in</td>
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<td>48.4 in</td>
<td>61.8 in</td>
<td>80.3 in</td>
<td>72.0 in</td>
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<td>1230 mm</td>
<td>1570 mm</td>
<td>2040 mm</td>
<td>1830 mm</td>
<td>1200 mm</td>
<td>4040 kg</td>
</tr>
<tr>
<td>0-5 in</td>
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<td>72.4 in</td>
<td>80.3 in</td>
<td>74.2 in</td>
<td>47.2 in</td>
<td>11500 lb</td>
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<td>82.9 in</td>
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<td>1940 mm</td>
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<td>74.8 in</td>
<td>97.2 in</td>
<td>80.3 in</td>
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<td>80.3 in</td>
<td>55.1 in</td>
<td>18000 lb</td>
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<td>2040 mm</td>
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<td>2070 mm</td>
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<td>2080 mm</td>
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<td>9600 kg</td>
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<td>105.1 in</td>
<td>97.2 in</td>
<td>81.9 in</td>
<td>55.1 in</td>
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<td>2470 mm</td>
<td>2080 mm</td>
<td>1400 mm</td>
<td>10200 kg</td>
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<td>0-6½ in</td>
<td>128.0 in</td>
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<td>94.5 in</td>
<td>112.4 in</td>
<td>91.3 in</td>
<td>65.0 in</td>
<td>29600 lb</td>
</tr>
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<td>0-160 mm</td>
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<td>14000 kg</td>
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<td>76.8 in</td>
<td>48500 lb</td>
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<tr>
<td>0-160 mm</td>
<td>4260 mm</td>
<td>2410 mm</td>
<td>2870 mm</td>
<td>3180 mm</td>
<td>2760 mm</td>
<td>1950 mm</td>
<td>22000 kg</td>
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<tr>
<td>0-6½ in</td>
<td>188.6 in</td>
<td>115.7 in</td>
<td>133.9 in</td>
<td>125.2 in</td>
<td>110.2 in</td>
<td>76.8 in</td>
<td>53000 lb</td>
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<td>2940 mm</td>
<td>3400 mm</td>
<td>3180 mm</td>
<td>2800 mm</td>
<td>1950 mm</td>
<td>24000 kg</td>
</tr>
<tr>
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<td>208.3 in</td>
<td>136.8 in</td>
<td>154.9 in</td>
<td>125.2 in</td>
<td>102.0 in</td>
<td>76.8 in</td>
<td>64000 lb</td>
</tr>
<tr>
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<td>3935 mm</td>
<td>3180 mm</td>
<td>2590 mm</td>
<td>1950 mm</td>
<td>29000 kg</td>
</tr>
<tr>
<td>0-6½ in</td>
<td>214.2 in</td>
<td>136.8 in</td>
<td>154.9 in</td>
<td>125.2 in</td>
<td>110.2 in</td>
<td>76.8 in</td>
<td>75000 lb</td>
</tr>
<tr>
<td>0-160 mm</td>
<td>5440 mm</td>
<td>3475 mm</td>
<td>3935 mm</td>
<td>3180 mm</td>
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<td>1950 mm</td>
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</tr>
<tr>
<td>0-7 in</td>
<td>234.4 in</td>
<td>157.9 in</td>
<td>176.0 in</td>
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<td>81600 lb</td>
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<tr>
<td>0-180 mm</td>
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<td>4010 mm</td>
<td>4470 mm</td>
<td>3180 mm</td>
<td>2800 mm</td>
<td>1950 mm</td>
<td>37000 kg</td>
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BHS Product Range:

**Mixing Technology**
- Twin-Shaft Batch Mixer
- Twin-Shaft Continuous Mixer
- Single-Shaft Continuous Mixer
- Containerized Mixing Plants
- Stationary Mixing Plants
- Plant Modifications / Retrofit

**Crushing Technology**
- VSI Rotor Impact Mill
- VSI Rotor Centrifugal Crusher
- Impact Crusher & Mill
- Mineral Processing Plants

**Recycling Technology**
- Rotor Impact Mill
- Rotorshredder
- Recycling Plants

**Filtration Technology**
- Rotary Pressure Filter
- Belt Filter
- Autopress
- Candle Filter
- Pressure Plate Filter
- Laboratory and Pilot Filter
- Filtration Plants

**Service**
- Tests in our Pilot Plants
- Process Engineering & Consulting
- Spare Parts & After Sales Service