

INJECTION UNIT SPECIFICATIONS

Injection Capacity, Max.								
G.P. Styrene (Theoretical)	oz.	5	7	9	g.	146	191	242
Displacement	in ³	9.4	12.3	15.5	cm ³	154	201	254
Injection Pressure, Max	psi	27500	21055	16636	bar	1897	1452	1147
Injection Rate	in ³ /sec	8.6	11.2	14.1	cm ³ /sec	140	183	232
Injection Screw Stroke	in	6.30	6.30	6.30	mm	160	160	160
Screw Diameter	in	1.38	1.57	1.77	mm	35	40	45
Screw L/D Ratio		22.9	20.0	17.8		22.9	20.0	17.8
Screw Performance								
Low Torque Screw Speed, Max	rpm	416			rpm	416		
Low Torque at Screw	in-lb	5600			Nm	633		
		@ 2500 psi				@ 172 bar		
Hi Torque Screw Speed, Max	rpm	277			rpm	277		
Hi Torque at Screw	in lb	8400			Nm	949		
		@ 2500 psi				@ 172 bar		
Barrel Heat Control								
Number of Pyrometers								
(Barrel/Nozzle)		3/1			3/1			
Total Heat Capacity	kw	8.2			kw	8.2		
Injection Capacity, Max.								
G.P. Styrene (Theoretical)	oz	11	13	16	g.	303	374	452
Displacement	in ³	19.4	24.0	29.0	cm ³	318	393	475
Injection Pressure, Max	psi	21000	21890	18075	bar	1862	1510	1245
Injection Rate	in ³ /sec	10.4	12.9	15.6	cm ³ /sec	171	211	255
Injection Screw Stroke	in	7.87	7.87	7.87	mm	200	200	200
Screw Diameter	in	1.77	1.97	2.17	mm	45	50	55
Screw L/D Ratio		22.2	20.0	18.2		22.2	20.0	18.2
Screw Performance								
Low Torque Screw Speed, Max	rpm	277			rpm	277		
Low Torque at Screw	in-lb	8400			Nm	949		
		@ 2500 psi				@ 172 bar		
Hi Torque Screw Speed, Max	rpm	194			rpm	194		
Hi Torque at Screw	in-lb	11900			Nm	1345		
		@ 2500 psi				@ 172 bar		
Barrel Heat Control								
Number of Pyrometers								
(Barrel/Nozzle)		3/1			3/1			
Total Heat Capacity	kw	15			kw	15		

MACHINE SPECIFICATIONS

Dimensions Overall				
Length (5, 7 and 9 oz.)	in	213	mm	5419
with injection unit retracted	in	213	mm	5419
Length (11, 13 and 16 oz.)	in	213	mm	5419
with injection unit retracted	in	217	mm	5508
Width	in	54.8	mm	1391
Height	in	86.8	mm	2204
Shipping Weight (Est.)	lbs	14,500	Kg	6590
Electric and Hydraulic				
Machine Hyd. System Pressure. Max.	psi	2800	bar	193
Hydraulic Pump Cap. (total)	gpm	36	L/min	136
Electric Motor	hp	25	kw	19
Oil Reservoir Capacity	gal.	68	L	258
Water Requirements				
Heat Exchanger*	gpm	7	L/min	27

CLAMP SPECIFICATIONS

Clamp Force	tons	165	tons	150
Maximum Daylight	in	35.8	mm	910
Mold Height Maximum/Minimum	in	20/5.9	mm	510/150
Clamp Stroke	in	15.7	mm	400
Clamp Speed				
**Dry Cycle Time (typical)	sec	2.0	sec	2.0
Platen Size (H x V)	in	26.8 x 25.6	mm	680 x 650
Distance between Tie Rods (H x V)	in	17.9 x 16.7	mm	455 x 425
Tie Rod Diameter	in	3.3	mm	85
Hydraulic Ejection System				
Ejector Force	tons	4.7	tons	4.3
Stroke (Max)	in	2.9	mm	75

*Note: Based on standard motor horsepower, 85 deg. F (29.4 deg. C) water in 10 deg F (5.5 deg C) temperature rise through heat exchanger

**Measured: Clamp open, clamp closed, build tonnage, clamp open