



Take over position:		Unit
<b>IMM - Downstream equipment</b>		
<b>Discharge channel - extended version</b>		
distance from surface of fixed platen	115.88 ±0.05	mm
distance 'take over position' to mould center, horizontal	1034.60	mm
distance 'take over position' to mould center, vertical	208.00	mm
CD-cooling station, DVD-cooling station	5	pcs
CD-take out position	1	pcs
<b>Discharge channel - standard version</b>		
distance from surface of fixed platen	115.88 ±0.05	mm
distance 'take over position' to mould center, horizontal	605.20	mm
distance 'take over position' to mould center, vertical	132.28	mm
CD-cooling station, DVD-cooling station	2	pcs
CD-take out position	1	pcs

**II. Media and its connecting**

Compressed air		Unit
Connections	1	Pcs
Operating pressure	6	bar
Dimensions of connecting	R½	"
Notice:		
Compressed air must be free from any oil or moisture		

Hydraulic and hopper cooling		Unit
Connections	1	Pcs
Maximum operating pressure in outlet	4	bar
Maximum water temperature in outlet S	20	°C
Dimension of connecting	R1	"

S ΔT supply/return 6,3°C (intermediate cooling) at a cycle time of 3,9 sec.

Cooling water for Sprue bush and Ejector, mould temperature control		Unit
Connections	1	Pcs
Maximum operating pressure in outlet	4	bar
Maximum permissible water temperature in outlet SS	13	°C
Dimension of connecting	R1	"

SS ΔT supply/return 4,9°C at a cycle time of 3,9 sec.

Substrate for Optical Disc		Unit
Connections	1	Pcs
Optical Grade Polycarbonate Resin		
Polycarbonate must be thoroughly dried to the moisture content ≤ 0.015 %.		

**III. Power/Energy and Consumption**

Room temperature : 26 °C  
 Oil temperature : 45 °C  
 Hopper temperature : 80 °C

The DVD power consumption is only slightly different to the normal CD injection moulding machine.

Power consumption for:	S Installed load 50 Hz	measured at cycle time		Unit
		<del>4.3</del>	3.9	sec
Pump motor, heating and control	27.96	<del>19.89</del>	16.12 ✓	kW
Temperature control	15.40	<del>1.22</del>	1.16 ✓	kW
<b>IMM in total</b>	<b>43.36</b>	<del>14.41</del>	<b>17.28</b> →	<b>kW</b> →

S Installed load of the total unit will increase at 60 Hz up to 48,36kW  
 Installed load at emergency power supply at 50 and 60Hz 12,96kW

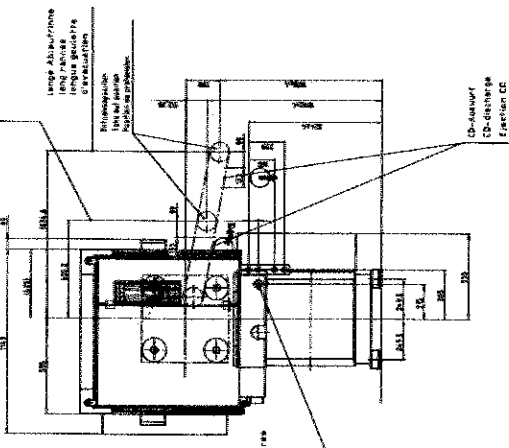
+ 2x Thermal STARTUP →

Heat dissipation for:	measured at cycle time		Unit
	<del>4.3</del>	3.9	sec
Oil cooling unit and hopper	<del>6.976</del>	7.913	kW
Sprue bush, ejector and temperature control	<del>3.171</del>	3.389	kW
<b>Heat dissipation in total</b>	<del>9.247</del>	<b>11.302</b>	<b>kW</b>

Water consumption for:	measured at cycle time		Unit
	<del>4.3</del>	3.9	sec
Oil cooling unit and hopper	<del>0.864</del>	1.082	m³/h
Sprue bush, ejector and temperature control	<del>0.586</del>	0.591	m³/h
<b>Water consumption in total</b>	<del>1.450</del>	<b>1.673</b>	<b>m³/h</b>
Compressed air (SCA: 1.01325 bar, 20°C)	<del>7.80</del>	8.60	m³/h
<b>Polycarbonate throughput (DVD 6,9-7,7 kg/h)</b>	<del>13.4</del>	<b>14.8</b>	<b>kg/h</b>

- Foundation drawing part, right handed # 649 6638, index 0
- Foundation drawing part, left handed # 649 6985, index 0
- Dimensions for material hopper attachment part # 690 1115 index 4
- Dimensions for mould attachment part, right handed # 649 6518 index 2
- Dimensions for mould attachment part, left handed # 649 6645 index 2
- CD-stamper drawing part # 411 6115, DVD-stamper drawing part # 4114439
- Attention: For measuring the stamper bore 10 stampers are requested
- CD-drawing part # 411 6116, DVD-drawing part # 4114360
- Interface power supply, circuit plan, Europe part # 697 0533, USA part # 697 0586

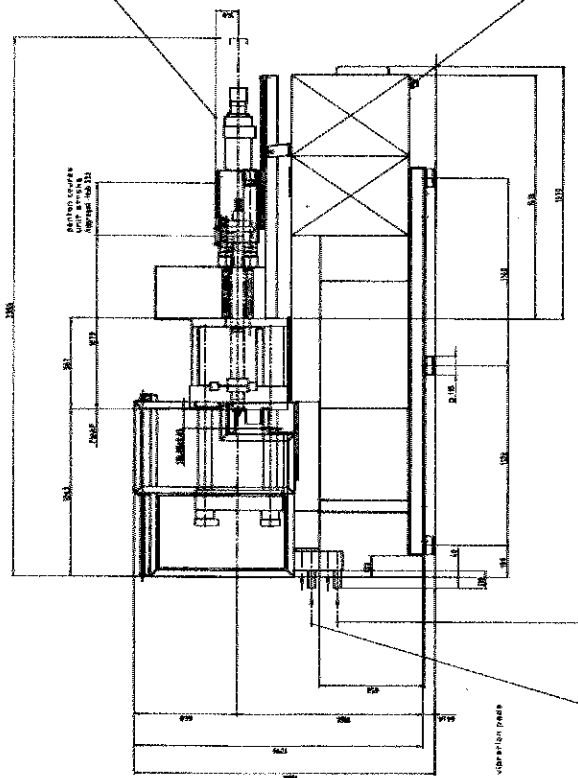
3.75 FT (45")  
1143 mm



Druckluftanschlag 1/2"  
Produit d'air comprimé 1/2"  
Pression d'air 1/2"  
Compressed air, assured dry and oil-free  
Pression d'air 1/2"  
Air comprimé, sec sans huile  
Pression d'air 1/2 bar

Anschlußflansche für Materialflücht  
Joint area for material copper  
surface coupling of frame

Speisung Stromversorgung  
Alimentation courant

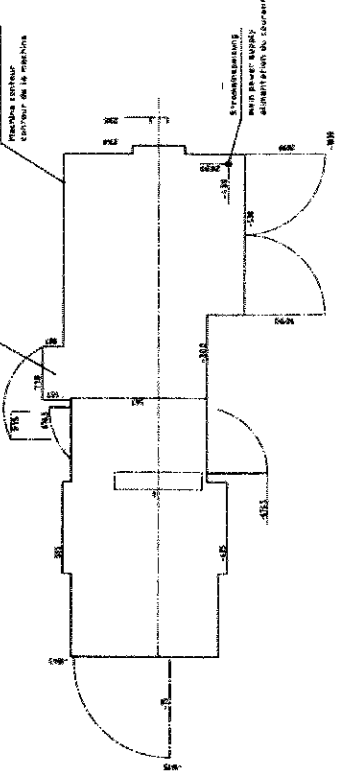


Bei Kältebetrieb  
With winter type anti-freeze pump  
sans gel

Kühlwasseranschluss, Drehzapfung RT  
Water connection for cooling water, oil cooling RT  
Water pressure max 1 bar, max 10°C oil  
Pression d'eau max 1 bar, max 10°C eau

Fertigungsart RT  
Manufacture max 1 bar, max 10°C steel  
Steel casting RT  
Water pressure max 1 bar, max 10°C steel  
Matière d'acier RT  
Pression d'eau max 1 bar, max 10°C eau

Gründungsplatte  
Basis de la machine



Stromanschluss  
Main power supply  
Alimentation de courant

3.0 TON	
Netto-Gewicht Net weight	3000 kg
Brutto-Gewicht Gross weight	3550 kg
Netto-Last Net load	137 kg
Brutto-Last Gross load	(175 am) ca. 185 kg

Verpackgewicht  
Total dispatch weight  
poids dans le transport  
Gesamtes Produkt/Bruttogewicht  
Total weight of machine project/ready  
with main assembly of production  
poids de bruts  
Hydraulisch  
Hydraulic  
huile hydraulique

Das Fundament ist für 137 kg.  
Die Basislast beträgt 175 kg.  
Die Basislast ist für die  
Kontrollen zu berücksichtigen.  
AUS: Netz und 24-Volt/24V  
Le fondation est à approuver, jusqu'à  
la charge nette de 137 kg.  
Le poids brut de la machine  
compte les parties sur la cellule de  
cellule.  
Lorsque les charges ont des dimensions fixes  
The foundation is to be load on  
137 kg.  
The contractor has to give full  
details concerning the stability  
All measurements are finished areas!

Rechtsausführung  
right hand installation  
Execution à droite

