MITSUBISHI INJECTION MOLDING MACHINE

mj series

SPECIFICATION

	MODEL			90MJ		120MJ		150MJ
				2.5	5	5	10	10
INJECTION UNIT	Screw diameter		in	1.10	1.42	1.42	1.77	1.77
	Screw stroke			4.33	5.67	5.67	7.09	7.09
	Theoretical inj. volume		cu.in	4.1	9.0	9.0	17.4	17.4
	Injection weight(PS)		oz	2.2	4.8	4.8	9.3	9.3
	Injection pressure		psi	28446	28446	28446	28446	28446
	Inj. rate	Standard	cu.in/sec	8.5	9.8	9.8	12.2	12.2
		Option		17.4	17.4	17.4	21.7	21.7
	Plasticizing capacity(PS)		lbs/hr	101	176	176	267	267
	Screw rotation speed		rpm	380	350	350	300	300
CLAMP UNIT	Mold clamping force		US.ton	88	88	110	110	143
	Mold opening force			6.6	6.6	8.3	8.3	8.3
	Mold closing speed		ft/min	173.9	173.9	173.9	173.9	173.9
	Mold opening speed			173.9	173.9	164.0	164.0	164.0
	Platen size(HXV)		in	22.05×22.05	22.05×22.05	24.02×24.02	24.02×24.02	29.13×29.13
	Distance between tie rods			14.96×14.96	14.96×14.96	16.14×16.14	16.14×16.14	20.08×20.08
	Clamp stroke			17.7	17.7	20.1	20.1	20.1
	Max. daylight			24.8	24.8	28.0	28.0	29.5
	Min. mold thickness			7.1	7.1	7.9	7.9	9.4
	Ejection	Ejector force	US.ton	3.3	3.3	3.3	3.3	3.9
		Ejector stroke	in	3.1	3.1	3.1	3.1	3.1
		Ejector speed	ft/min	49.2	49.2	49.2	49.2	49.2
GENERAL	Motor for pump		HP	20	20	25	25	25
	Heater capacity		KW	4.8	6.0	6.0	9.6	9.6
	Overall dimension (L×W×H)		in	168.4×43.3×65.7		184.7×45.2×67.7		190.6×50.4×72.8

STANDARD EQUIPMENT

INJECTION UNIT

- Screw
- Bi-metallic screw cylinder
- Nozzle
- Heater control for cylinder & nozzle
- Screw cylinder cover
- Purge cover
- Injection unit swivel device
- Nozzle center adjust. device(up/down)
- Injection speed programmable control
- Injection pressure programmable control
- Screw speed programmable control
- Screw back press. programmable control
- Automatic color change circuit (Jet purge circuit)
- Melt decompression circuit(variable speed)
- Sprue cutting circuit
- Manual operation circuit
- Injection holding press. change over system
- Screw back press. selecting system
- Screw r p m display
- Screw position indicator
- Cushion volume monitor
- Injection start position monitor
- Injection speed closed loop control
- Injection hold. press. closed loop control
- Scr. cold start up prevention circuit
- Screw cylinder jacket cooling system

CLAMP UNIT

- Mold opening/closing brake circuit
- Mechanical safety device
- Hydraulic ejector
- Hydrauric ejector forward holding circuit
- Eject on fly
- Moving platen support rail
- Clamp stroke/speed remote control
- Clamp hold. press. programmable control
- Mold protect. circuit with try again
- Clamp hold. press. eary decomp. circuit
- Clamping pressure remote control
- Ejector stroke/speed romote control
- Automatic take out circuit
- Front safety door
- Rear safety door
- Replaceable locating ring
- Ejector motion no-link to clamp motion

HYD. UNIT

- Energy saving hydraulic circuit
- Hydraulic oil cleaning device
- Filter change announcing circuit
- Solenoid valve with lamp
- Hyd. oil high temperature annoucing circuit
- Separation circuit for clamping and injection

ELECTRIC & GENERAL

- Microprocessor control device(MAC-Ⅵ)
- Operation start "OK" monitor
- Automatic memory device for molding condition(for 30molds)
- Setting value change forbidding circuit
- Pre-setting circuit for next mold condition
- Indicator for proceeding time
- Shot counter
- Disorder indicator with buzzer
- Grease-up announcing for bushings
- Time monitor(1-cycle/inj./plast.)
- Product. completion announcing stop circuit
- Long cycle time circuit
- Automatic heat up circuit(heater & hyd. oil)
- Production hour meter
- Swing up control panel
- Main breaker
- Automatic memorize device for temperature of cylinder and nozzle
- Ejector retract after safety door closed

180MJ		210MJ		270MJ		320MJ	
10	17	17	30	17	30	30	40
1.77	1.97	1.97	2.25	1.97	2.25	2.25	2.44
7.09	10.04	10.04	13.5	10.04	13.5	13.5	14.6
17.4	30.5	30.5	53.7	30.5	53.7	53.7	68.3
9.3	16.3	16.3	28.6	16.3	28.6	28.6	36.3
28446	28446	28446	26810	28446	26810	26810	25744
12.2	11.3	11.3	11.9	16.2	16.8	16.8	19.8
21.7	19.8	19.8	20.7	32.3	32.3	32.3	40.9
267	304	304	401	304	401	401	518
300	260	260	260	260	225	225	225
176	176	209	209	265	265	320	320
11.0	11.0	11.0	11.0	15.4	15.4	15.4	15.4
164.0	164.0	164.0	164.0	170.6	170.6	170.6	170.6
160.8	160.8	160.8	160.8	173.9	173.9	173.9	173.9
29.13×29.13	29.13×29.13	32.28×32.28	32.28×32.28	32.28×32.28	32.28×32.28	37.4×37.4	37.4×37.4
20.08×20.08	20.08×20.08	22.44×22.44	22.44×22.44	22.04×22.04	22.04×22.04	25.98×25.98	25.98×25.98
24.8	24.8	24.8	24.8	29.9	29.9	29.9	29.9
33.5	33.5	35.4	35.4	39.4	39.4	41.7	41.7
8.7	8.7	10.6	10.6	9.5	9.5	11.8	11.8
5.0	5.0	5.0	5.0	6.8	6.8	6.8	6.8
3.9	3.9	3.9	3.9	4.9	4.9	4.9	4.9
49.2	49.2	49.2	49.2	49.2	49.2	49.2	49.2
30	30	30	30	40	40	50	50
9.6	12.0	12.0	12.0	12.0	16.4	16.4	16.4
204.3×50.4×72.8	214.1×50.4×72.8	218.1×53.5×76.0	242.3×53.5×76.0	229.7×53.5×76.0	253.9×53.5×76.0	265.9×58.6×81.1	

OPTIONAL EQUIPMENT

INJECTION UNIT

- Anti-wear, anti-corrosive screw
- Anti-wear, anti-corrosive cylinder
- High-homogeneous, high-plasticizing UB screw
- Heater insulation cover
- Spring operated shut off valve
- Hydraulic operated shut off valve
- Bearing housing lubrication by hand pump
- Slide lubrication by hand pump
- Hopper
- Band heater defect indicator

CLAMP UNIT

- Air ejector system
- Hydraulic core pull system
- Air core pull system
- Pipings for mold cooling water
- Chute
- Mold quick centering V-block
- Automatic clamp system
- Rear door hydraulic interlock circuit
- Interlock circuit for product drop
- Tie bar lubrication by hand pump
- Tie bar automatic lubrication
- Screw core circuit
- Mechanical stopper for mold open limit
- Mechanical stopper for ejector forward limit

HYD.UNIT

- Oil level decreasing alarm
- Hydraulic oil temperature controller

ELECTRIC & GENERAL

- Printer interface (LQ-850 CENTRONICS)
- Warning by patrol lamp
- Outlet circuit
- Level pads

Remarks:

- Injection Capacity and Pasticizing capacity varies depending on the types or resins used and on conditions for molding, therefore, please consult with us when operating - at full capacity.
- Figures in the above table are subject to change without prior notice due to modification.