

Clamping unit		PLUS 35
Clamping force	kN	350
Distance between tie-bars	mm	270
Platen area	mm	470 x 280
Max. mold height	mm	150 – 250
Opening stroke/opening force	mm/kN	200/29,5
Tie bar diameter	mm	60
Maximum daylight between platens	mm	450
Ejector force/ejector stroke	kN/mm	26,2/100
Oil tank capacity	l	125
Dry cycle time ¹⁾	s	1,3
Max. mold weight	kg	200
Weight	kg	1.100

Injection unit		PLUS 35			
International size designation		75			
Screw diameter	mm	18	22	25	30
Specific injection pressure	bar	3038	2034	1575	1094
Theoretical shot volume	cm ³	25,4	38	49	70,6
Max. shot weight (PS)	g	23,1	34,5	44,6	64,2
Screw L/D ratio		21	17	15	13,5
Max. screw speed	min ⁻¹	420			330
Screw torque	Nm	200			240
Plasticising rate (PS) ²	g/s	4,9	6,6	7,5	9,2
Nozzle stroke	mm	150			
Nozzle contact force	kN	27,5			
Screw stroke	mm	100			
Injection rate into the air	g/s	38,4	57,3	74	107
Barrel heating performance	kW	2,76			
Number of heating zones		1+2			
Drive performance	kW	7,5			
Electrical power input	kVA	15,5			

1) according to EUROMAP 6

2) according to Wittmann Battenfeld Standard

Shot weight conversion table

Material	Factor
ABS	0,88
CA	1,02
CAB	0,97
PA	0,91
PC	0,97
PE	0,71
PMMA	0,94
POM	1,15
PP	0,73

The maximum shot weights (g) are calculated by multiplying the theoretical swept volume (cm³) by the above factors.

Material	Factor
PP + 20% Talcum	0,85
PP + 40% Talcum	0,98
PP + 20% FR	0,85
PS	0,91
PVC-U	1,12
PVC-P	1,02
SAN	0,88
SB	0,88
PF	1,3
UP	1,6

Dark grey boxes = thermosets

Dimensions of PLUS 35

