

# HM 400 t

Clamping unit		HM 400/ ...								
Clamping force	kN	4000								
Distance between tier-bars	mm x mm	900 x 710								
Mold height (min.)	mm	400								
Opening stroke/opening force	mm/kN	975/175								
Maximum daylight	mm	1375								
Ejector stroke/ejector force	mm/kN	250/81								
Dry cycle time <sup>1)</sup>	s-mm	3,2 - 497								
Injection unit		... /2250			... /3400			... /5100		
Screw diameter	mm	55	65	75	65	75	85	75	85	95
Screw stroke	mm	325			375			425		
Screw L/D ratio		22			22			22		
Theoretical shot volume	cm <sup>3</sup>	772	1078	1436	1244	1657	2128	1878	2412	3012
Specific injection pressure	bar	2500	2070	1555	2500	2022	1574	2500	2110	1689
Max. screw speed	min <sup>-1</sup>	389			244			152		
Max. plasticizing rate (PS) <sup>2)</sup>	g/s	72	107	160	68	104	146	65	91	118
Max. screw torque	Nm	2373			3759			6048		
Nozzle stroke/nozzle contact force	mm/kN	500/129			600/129			600/129		
Injection rate into air	cm <sup>3</sup> /s	333	465	619	358	476	612	355	456	570
Injection rate into air with twin-pump (option)	cm <sup>3</sup> /s	442	617	822	475	632	812	471	605	756
Injection rate into air with hydraulic accumulator (option)	cm <sup>3</sup> /s	726	1014	1351	1040	1385	1779	1291	1659	2072
Drive										
Drive power	kW	55			55			55		
Oil tank volume	l	970			970			970		
Electrical power supply without/with Europackage	kVA	102/131			106/135			111/140		
Weights, Dimensions										
Netweight (exclusive oil)	kg	21000			22000			23000		
Lenght x width x weight <sup>3)</sup>	m	6,6x2,4x2,4			7,1x2,4x2,4			7,3x2,4x2,4		
Max. mold weight/min. mold diameter <sup>4)</sup>	kg/mm	5500/700			5500/700			5500/700		

1) according to Euromap 6 2) according to Battenfeld norm, higher plasticizing rates possible with twin-pump (option)

3) max. length with middle screw diameter in back position 4) max. 2/3 on clamping platen

